



# EPODUX 292

Epoxy phenolic coating

## DEFINITION

Epoxy phenolic coating that can be used as a primer or intermediate coat.

## INTENDED USES

Anti corrosion protection for any kind of metal structure subject to aggressive environments and thermal stress.

- Chemical, petroleum or nuclear industrial process.
- Piping.
- Metallic frame structures...

## PRINCIPAL CHARACTERISTICS

Quick drying.

Chemical resistance (Please contact our Technical Department).

Temperature Resistance (150°C continuous and up to 200°C as peak temperature).

## CERTIFICATIONS / APPROVALS

EDF : Is used in the following systems registered in the FNP under numbers 1038, 1086 et 1119.

## TECHNICAL DATA

Gloss level	: Mat
Colours	: White or beige
Number of components	: 2
Mix ratio, by weight	: 94/6
Mix ratio, by volume	: 90,5/9,5
Specific gravity	: 1,54 +/- 0,05 g/cm <sup>3</sup>
Solids volume	: 59,7 +/- 3%
Solids weight	: 77,1 +/- 2%
Typical thickness (dry)	: 45 µm
Typical thickness (wet)	: 75 µm
Theoretical spreading rate	: 13,2 m <sup>2</sup> /l for 45 µm dry



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### INSTRUCTIONS

#### SURFACE PREPARATION

New steel « heavy duty use »

Abrasive blast cleaning at Sa 2 ½ according to ISO 8501-1 : 2007

Roughness profile

Mid G according to ISO 8503-2 (Ra 10-12,5 µm)

Galvanized steel

Sweep blasting or etching with METONET followed by rinsing with clean water is recommended.

#### APPLICATION

**Mixing :** The product is sold as pre-prepared kits. For the hardener portion in the base coat container and mix. Take care not to create air bubbles. The minimal recommended temperature of the mixture must be at least 10°C, or a thinner may be required in order to achieve adequate viscosity. Please note that an excessive amount of thinner may induce a dripping phenomenon.

**Induction time :** None

**Working pot life :**

Temperature	Time
10°C	6 hours
20°C	3 hours
30°C	1 h 30

**Substrate temperature :** Between +5°C and +40°C and at least 3°C higher than the dew point in order to eliminate any risk of condensation.

**Weather conditions :** The temperature should be between 10°C and 45°C  
The relative humidity should be between 0% and 85%

**Technical note :** Do not keep the spraying equipment loaded for longer than the lifespan of the product in a container. Rinse the equipment with the 67-232 v02 thinner and rinse thoroughly with a cleaning solvent. The container containing the prepared and unused mixture must not be hermetically sealed. In case of prolonged interrupted use, it may be preferable to prepare a new kit.

#### AIRLESS SPRAY

Thinner : 67-232 v02

Dilution : 0 to 5 %

Nozzle : 0.015-0.017

Pressure at nozzle : 150-200 bars

Report pump Min: 45 / 1

#### AIR SPRAY

Thinner : 67-232 v02

Dilution : 5 to 10%

Nozzle : According to the material

Pressure at nozzle : Between 3 and 4 bars

#### BRUSH

Thinner : 67-232 v02

Dilution : 5 to 10%

#### ROLLER

Thinner : 67-232 v02

Dilution : 5 to 10%

**CLEANING SOLVENT :** D 600 or 67-232 v02



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### CURING TIME

Temperature	Drying time		Overcoating interval	
	Touch dry	Hard dry	Minimum	Maximum
10°C	15 hours	20 hours	12 hours	120 days
20°C	6 hours	10 hours	6 hours	90 days
30°C	2 h 30	4 hours	3 hours	60 days

### COMPATIBILITY

Previous coat(s)                      Itself or EPODUR 294.  
Subsequent coat(s)                  Itself, EPODUR NV75-25 or EPODUR 294.

### REGULATORY SPECIFICATIONS

AFNOR RATING                      AFNOR NFT 36 005 rating Family I Class 6b  
VOC (Directive                      EU limit value for this product (cat. A/i) : 500 g/l (2010)  
2004/42/EC)                          This product contains max 405 g/l VOC

### HEALTH AND SAFETY

Flash point                              BASE : Between 23°C et 55°C  
    HARDENER : between 23°C et 55°C

Transport and labelling              Refer to the safety data sheet established as per applicable European directives

Shelf life                                  3 years in original full, sealed packaging. Store in a cool, ventilated place.

Precautions                              Refer to the current material safety data sheet

### PACKAGING

KIT	BASE	HARDENER
15 l	13.60 l	1.40 l
5 l	4.50 l	0.50 l