PRODUCT DATA SHEET

HDDUR TOPCOAT 390

Description: This is a two component polyamide cured epoxy coating. It has a glossy finish with fair gloss retention .To be used as topcoat in atmospheric and immersed environments.

Recommended use: Recommended for application on suitably primed steel structures exposed to industrial environment of paper, fertilizers, Pharmaceutical industries etc.

Service temperatures: Maximum, dry exposure only: 140°C

Physical Properties :

Colours/shade Nos.:	White*(Others shades also available on request)
Finish:	Glossy
Volume solids, %:	45 %
Theoretical spreading rate:	9.36 m²/litre, 50 micron
Flash point:	20°C
Specific gravity:	1.25 kg/litre
Surface-dry:	2 Hours at 30°C
Dry to Handle:	4 Hours at 30°C
VOC content:	410 g/litre

Application details:

Version, mixed product	**HDDUR Topcoat 390**
Mixing ratio:	Unilay EP BASE: Unilay EP Curing Agent 4 : 1 by volume
Application method:	Airless spray/Air Spray/Brush
Thinner (max.vol.):	Epoxy HD Thin (5%)/ Epoxy HD Thin (15%) /Epoxy HD Thin(5%)
Pot life:	4-6 hours at 30°C
Nozzle orifice:	.019"-.021"
Nozzle pressure:	180 bar [2600 psi] *(Airless spray data are indicative and subject to adjustment)*
Indicated film thickness, dry:	50-75 Micron
Indicated film thickness, wet:	100-120 Micron
Overcoat interval, min:	According to Specification
Overcoat interval, max:	According to Specification

Safety: Handle with care. Wear Necessary PPEs like safety shoes, gloves, goggles.

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Surface preparation:	Remove oil, grease and other contaminants by suitable detergent cleaning. Remove salts, detergents and other contaminants by high pressure fresh water cleaning. All damage of shop primer and contamination from storage and fabrication should be thoroughly mechanically/chemically cleaned prior to final painting. **New build:** Abrasive blasting to min. Sa 2½ (ISO 8501-1) / SP 10 (SSPC). Remove dust, blast media and loose materials. **Maintenance and Repair** Remove dust, blast media and loose materials. Flash rust degree of maximum FR M (ISO 8501-4). Spot abrasive blasting to min. PSa 2 (ISO 8501-2) / SP 6 (SSPC). Water jetting to min. Wa 2 (ISO 8501-4). Minor areas can be cleaned by power tool to St 3 provided the surface is roughened and not polished.
Application conditions:	To avoid condensation, apply on a clean and dry surface with a temperature that is at least 3°C [5°F] above the dew point. Surface temperature must be above -10°C [14°F] during application and curing. Beware of ice on the surface at low temperatures. Temperature of product must be above 15°C [59°F] during application. **Relative Humidity:** Relative humidity must be below 85% during application. Relative humidity must be below 85% during curing. To obtain the drying time stated, it is important to maintain sufficient ventilation during application, drying and curing.
Previous Coat:	None
Subsequent Coat:	None
Remarks/Notes:	
Film thicknesses/thinning: (optional)	For best performance, avoid excessive film thickness. Product may be specified in another film thickness than indicated depending on purpose and area of use. This will alter spreading rate, drying and curing time and over coating interval.
Overcoating note: (optional)	If the maximum over coating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion. The surface must be clean before over coating.