

PRODUCT DATA SHEET

HDGAURD SF 101



Description:	Two component, solvent free, chemical resistant heavy duty amine adduct cured epoxy tank lining coating. A non-toxic, environment-friendly solvent free coating. Excellent gloss, hardness and high abrasion and chemical resistance to a wide range of chemicals. Suitable for application on both concrete and steel substrates.
Recommended use:	An internal steel tank lining suitable for contact with a wide range of chemical cargoes, portable water, food chemicals, edible oil etc. Suitable as lining for pipes and fittings.
Service temperatures:	Maximum, dry exposure only: 140°C/284°F
Certificate/approval	Approved by CFTRI-USFDA 175.300

Physical Properties :

Colours/shade Nos.:	Light Grey, Light Red, Buff, White
Finish:	Glossy
Volume solids, %:	100%
Theoretical spreading rate:	2.5m ² /litre, 400 micron/16 mils
Flash point:	101°C
Specific gravity:	1.52 kg/litre
Surface-dry:	1 hours at 30°C
Touch-dry:	3 hours at 30°C
VOC content:	125 g/litre

Application details:

Version, mixed product	HDGAURD SF 101
Mixing ratio:	Base : Curing Agent 3 : 1 by volume
Application method: Thinner (max.vol.):	Airless spray /Air spray/Brush Not Required - DO NOT THIN
Mixing Condition:	Material is supplied in two containers as a unit. Always mix a complete unit in the proportion supplied. Once the unit has been mixed it must be used within the working pot life specified. Agitate base with a power agitator and Agitate curing agent with a power agitator. Combine entire content of base with hardener and mix thoroughly with power agitator.
Pot life:	10°C 2 Hours 15°C 90 minutes 25°C 60 minutes 40°C 30 minutes
Nozzle orifice: Nozzle pressure:	.053"-.068"(21 – 26 thou) 211 bar [3000 psi] (Airless spray data are indicative and subject to adjustment)
Indicated film thickness, dry: Indicated film thickness, wet: Overcoat interval, min: Overcoat interval, max:	250 – 600 micron/10 - 24 mils (see REMARKS overleaf) 250 – 600 micron/10 - 24 mils (see REMARKS overleaf) According to Specification According to Specification
Safety:	Handle with care. Wear Necessary PPEs like safety shoes, gloves, goggles.

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Surface preparation:

Metal: The service life span and the service performance of UNIDUR SF 101 is directly related to the degree of surface preparation.

UNIDUR SF 101 should be applied to a surface that has been blast cleaned. It may be applied directly to blast cleaned steel.

Remove all wax, oil and grease by solvent cleaning in accordance with the guidelines given by SSPC-SP1. Where necessary remove weld spatter and round off all rough weld seams and sharp edges to a smooth surface.

Abrasive blast clean to a minimum standard of Sa 2 1/2 (ISO 8501-1:1988) or SSPC-SP 10. An average surface profile of 75-100 micron is required.

Ensure that all surface defects detected after blast cleaning is ground, filled or treated in a suitable manner.

After blasting, remove dust from the surface. Ensure that the surface to be coated is clean, dry and free from any contaminants.

UNIDUR SF 101 must be applied before oxidation of the steel occurs. If oxidation does occur the entire oxidation area should be reblasted to the standard specified above.

Concrete : New concrete should be left for at least 21 days to cure before coating.

The moisture content of the concrete surface should be checked and ensured to be below 6% when measured with a reliable moisture meter, such as the Sovereign Moisture Meter.

The surface should be dry, free from surface contaminants, sound and undamaged.

Apply one coat of suitable concrete primer/sealer.

Application conditions:

To avoid condensation of moisture onto substrate prior to coating application, relative humidity should not exceed 85% and substrate temperature should be more than 3°C above dew point. The temperature of paint itself should be 15°C/59°F or above. In confined spaces provide adequate ventilation during application and drying.

Preceding coat:

According to specification.

Subsequent coat:

According to specification.

Storage and Packing Size :

Shelf Life: 18 months minimum at 25°C. Subject to re inspection thereafter.

Store in dry, shaded condition away from sources of heat and ignition.

Pack Size: Part A 20 Lit

Part B 5 Lit

U.N. Shipping No.: Non Hazardous (Base): 1760 (Curing agent)

This Product Data Sheet supersedes those previously issued.

Data, specifications, directions and recommendations given in this data sheet represent only test results or experience obtained under controlled or specially defined circumstances. Their accuracy, completeness or appropriateness under the actual conditions of any intended use of the Products herein must be determined exclusively by the Buyer and/or User.

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