

PRODUCT DATA SHEET

HD EPOXY DTM 385

Description:	HD EPOXY DTM 385 is a two component, high solids, high build epoxy coating. It forms a hard coating, has good wetting properties and cures at low temperatures. Having excellent chemical and corrosion resistance.
Recommended use:	For atmospheric service as an intermediate or as a primer/DTM coating systems for new construction and maintenance. Finish coat on interior surfaces.
Temperatures Resistance:	Maximum, dry exposure: 120°C.

Physical constants:

Colours/shade Nos.:	Available in all shades.
Finish:	semi-flat
Volume solids, %:	80 ± 2
Theoretical spreading rate:	8 m ² /litre 100 micron
Flash point:	25°
Specific gravity:	1.6 kg/litre]
Dry to touch:	2 hours at 30°C/68°F
VOC content:	220 g/litre

Application details:

Version, mixed product	Mix		
Mixing ratio:	Base 4 : curing agent 1 4 : 1 By Volume		
Application method:	Airless spray	Air spray	Brush
Thinner (max.vol.):	HD Epoxy Thinner (5 %) HD Epoxy Thinner (15%)		HD Epoxy Thinner (5%)
Pot life:	3 -4 hours at 30°C		
Nozzle orifice:	.018"- .025"		
Nozzle pressure:	250 bar [3625 psi] (Airless spray data are indicative and subject to adjustment)		
Cleaning of tools:	HD EPOXY THINNER		
Indicated film thickness, dry:	130 micron/5.2 mils (see REMARKS overleaf)		
Indicated film thickness, wet:	150 micron/6 mils		
Overcoat interval, min:	6 hours (30°C/68°F)		
Overcoat interval, max:	1 Day (30°C/68°F)		

Safety:	Handle with care. Before and during use, observe all safety labels on packaging and paint containers,
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- Surface preparation Methods:**
- New steel:** When used as finish coat/DTM recommended Sa 21/2 (ISO 8501-1:1988). Improved surface preparation will improve the performance.
- Zinc silicate coated surfaces:** Remove oil and grease etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. After exposure to high humidity, zinc salts ("white rust") will have to be carefully removed by high pressure fresh water cleaning, if necessary combined with scrubbing with stiff nylon brushes.
- Repair and maintenance:** Remove oil and grease, etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. Clean damaged areas thoroughly by power tool cleaning to minimum St 2 (ISO 8501-1:1988) (spot-repairs) or by abrasive blasting to min. Sa 2, preferably to Sa 21/2 (ISO 8501-1:1988).
- Application Parameters :**
- Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation.
Use only where application and curing can proceed at temperatures above: - 5°C/23°F, preferably above 0°C/32°F.
- Film Thickness:**
- Normal range DFT: 100- 200 micron/4-8 mils. Avoid application of excessive film thickness
- Recoat Interval:**
- Maximum recoat interval refers to exterior surfaces exposed to periodical immersion, splash, condensation or abrasion during service life of the coating system. If the maximum recoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion.

Atmosphere	Atmospheric Temp.					
	10 °c		20 °c		30 °c	
	Min	Max	Min	Max	Min	Max
Surface Temperature						
HD EPOXY DTM	10 Hrs	20 Days	8 Hrs	15 Days	6 Hrs	10 Days
HDTHANE	10 Hrs	20 Days	8 Hrs	15 Days	6 Hrs	10 Days

- Notes:**
- The natural tendency of epoxy coatings to chalk in outdoor exposure and to become more sensitive to mechanical damage and chemical exposure at elevated temperatures is also reflected in this product.