

PRODUCT DATA SHEET

HDLINE GF VINYL ESTER 500



Description:	Two component, vinyl ester coatings provide the ultimate in chemical and solvent-resistance to a broad range of chemicals, including acids and alkalis. These systems are ideal for corrosion control and containment applications and can be used for concrete and steel tank linings, or as a concrete floor topping.
Recommended use:	Flake-Reinforced Lining Systems for Steel and concrete tanks for chemical storage and processing, waste water applications.
Service temperatures:	Maximum, dry exposure only: 110°C/220°F
Certificate/approval	Approved by CFTRI-USFDA 175.300

Physical Properties :

Colours/shade Nos.:	Off white
Volume solids, %:	100%
Theoretical spreading rate:	2 m ² /litre, 500 micron/ 20mils
Flash point:	28°C
Specific gravity:	1.8 kg/litre
Surface-dry:	5-6 hours at 30°C
Touch-dry:	8-10hours at 30°C
Full dry:	4 days
VOC content:	365 g/litre

Application details:

Version, mixed product **HDLINE GF VINYL ESTER 500**

Mixing ratio:	Base : Curing Agent 49 : 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:	30 - 60 minutes @25°C .027"- .032" 198 bar[2820psi] (Airless spray data are indicative and subject to adjustment)
Nozzle orifice:	
Nozzle pressure:	500 – 600 micron/20 - 24 mils (see REMARKS overleaf) 650 - 770micron/26 – 30.8mils (see REMARKS overleaf)
Indicated film thickness, dry:	According to Specification
Indicated film thickness, wet:	According to Specification
Overcoat interval, min:	
Overcoat interval, max:	
Safety:	Handle with care. Wear Necessary PPEs like safety shoes, gloves, goggles.

Surface preparation:

Metal: It 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.

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.

Film Thinning:

May be specified in another film thickness than indicated depending on purpose and area of use. This will alter spreading rate and may influence drying time and Overcoating interval.

Normal dry film thickness range is 400-1000 micron/16-40 mils.

Preceding coat:

According to specification.

Subsequent coat:

According to specification.

Storage and Packing Size :

Shelf Life: 24 months minimum at 25°C. Subject to re inspection thereafter.

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

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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