



A two-component, polyamide cured epoxy resin based high-build coating for heavy steel structures. It provides good resistance to water and excellent anti-corrosive property.

<b>Recommended use</b>	As a high-build primer or intermediate coat for use on the bridge or general steel structures. For structures exposed to outdoor, urethane topcoat is recommended to use.
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### Physical Properties

<b>Finish and Color</b>	Flat. Grey, etc
<b>Specific gravity</b>	Approx. 1.4 ~ 1.7 for Mixture of Base and Curing agent.
<b>Solids by volume</b>	Approx. 80%(Determined by ISO3233)
<b>Spreading rate (Theoretical)</b>	8.0 m <sup>2</sup> /L in 100 μm dry film thickness on a smooth surface.
<b>Flash point</b>	Base (EH6280(HS)-A) : 23 °C / 73 °F (Closed cup) Curing Agent (EH6280(HS)-B) : 27 °C / 81 °F (Closed cup)

### Application details

<b>Surface preparation</b>	Remove any oil, grease, dirt and any other contaminants from the surface before painting by proper method such as solvent cleaning and fresh water washing, etc.  * Steel : Blast cleaning to Sa2.5 or Power tool cleaning to St3, etc.
<b>Preceding coat</b>	Galvany IZ180N or according to specification.  When apply over inorganic zinc, a mist coat is required to reduce the bubbling.
<b>Method of application</b>	Spray (Airless or Air), Roller or Brush application. For airless spray application : Nozzle orifice : 432 μm ~ 635 μm (0.017" ~ 0.025") Output pressure : 11.7 MPa ~ 15.2 MPa Fan : 40° ~ 60° (Airless spray data are indicative and subject to adjustment)
<b>Mixing</b>	Base (Part A) : Curing Agent (Part B) = 9.4 : 5.6 (by volume)  Mix thoroughly together prior to application in the proportions with power agitator as delivered.
<b>Thinning</b>	Thinner No. 024  Do not dilute components separately, only the mixture.

<b>Application conditions</b>	Apply only where application and curing can proceed at temperatures above 5 °C/41°F. The surface should be completely cleaned and dried. Do not apply when relative humidity is above 85%. The surface temperatures should be at least 2.7 °C (5°F) above dew point to prevent condensation. In confined areas, ventilate with clean air during application to assist solvent evaporation.														
<b>Film thickness</b>	150 $\mu$ m dry. May be specified in another film thickness than indicated depending on purpose and area of use.														
<b>Drying time</b>	<table border="1"> <thead> <tr> <th>Substrate temperature</th> <th>5 °C / 41 °F</th> <th>20 °C / 68 °F</th> <th>30 °C / 86 °F</th> </tr> </thead> <tbody> <tr> <td>Set to touch</td> <td>12 h</td> <td>6 h</td> <td>4 h</td> </tr> <tr> <td>Dry through</td> <td>48 h</td> <td>24 h</td> <td>18 h</td> </tr> </tbody> </table> <p>* The actual drying time is subject to the film thickness, ventilation, humidity etc., and drying time under other temperature conditions should be checked and informed by KCC.</p>			Substrate temperature	5 °C / 41 °F	20 °C / 68 °F	30 °C / 86 °F	Set to touch	12 h	6 h	4 h	Dry through	48 h	24 h	18 h
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<b>Subsequent Coat</b>	Korethan Topcoat UT6581 or according to specification.														
<b>Pot life</b>	4 h at 20 °C / 68 °F														
<b>Recoating interval</b>	At 20°C / 68°F, Minimum : 18 h Maximum : 7 day  Prior to overcoating, remove the oil, salt, chalking material and any other contaminants on aged coating film completely by proper cleaning method such as solvent cleaning and/or fresh water washing.														
<b>Heat resistance temperature</b>	Continuous : 93 °C / 200 °F (Non-immersion service) Non-continuous : 121 °C / 250 °F (Non-immersion service)														
<b>Storage and package</b>															
<b>Shelf life</b>	12 months														
<b>Packing Unit</b>	15 L ( EH6280(HS)-A : 9.4 L, EH6280(HS)-B : 5.6 L )														
<b>Remarks</b>															
<b>Handling Precautions</b>	Protect skin and eyes from direct contact with liquid paint, and avoid prolonged breathing of solvent vapors. Use with adequate ventilation. Respiratory protection is recommended during application in confined spaces or stagnant air.														
<b>1'st issue</b>	2016-08-01														
<b>Revision</b>															

Disclaimer : The information in this data sheet is believed to the best of our knowledge based on laboratory test and practical experience. However, there are many factors affecting the performance of product and the product quality itself, so we are not able to guarantee without the confirmation of the purpose of using the product from us in writing. We reserve the right to change the data without notice and you should check that this data sheet is current prior to using the product.

