

PRODUCT DATA SHEET

HDDUR 671



Description: A two component, high solids, high build, chemically resistant solvent based epoxy phenolic tank lining.

Recommended use: It has been used extensively for long term corrosion protection lining of storage tank for a wide range of chemicals, solvents, crude oil, aggressive palm oil and vegetable oil derivatives including hot water and portable water tank. Outstanding adhesion to blasted steel. Good anti-corrosive performance properties.

Service temperatures: Maximum, dry exposure only: 200°C. In water temperature 95°C /203°F

Physical Properties :

Colours/shade Nos.:	White & Grey
Finish:	Flat
Volume solids, %:	70 ± 2 %
Theoretical spreading rate:	7.1m ² /litre, 100 micron/4 miles
Flash point:	26°C [78.8°F]
Specific gravity:	1.73 kg/litre
Surface-dry:	1.5 hours at 30°C
Touch-dry:	7 hours at 30°C
Full cure:	7 days at 30°C
VOC:	320g/l

Application details:

Version, mixed product **HDDur 671**

Mixing ratio:	HDDUR 671 Base: HDDUR 671 Curing Agent 4 : 1 by volume
Application method:	Airless spray /Brush
Thinner (max.vol.):	HD Epoxy Thinner 100 (According to separate application)
Pot life:	3 hours at 30°C
Induction time:	10 min at 30°C
Nozzle orifice:	.017"-.021"
Nozzle pressure:	210 bar [2900 psi] <i>(Airless spray data are indicative and subject to adjustment)</i>

Indicated film thickness, dry:	100 – 120 micron <i>(see REMARKS overleaf)</i>
Indicated film thickness, wet:	150 - 170 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:	<p>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.</p> <p>New build: Abrasive blasting to min. Sa 2½ (ISO 8501-1) / SP 10 (SSPC). Remove dust, blast media and loose materials.</p> <p>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). Minor areas can be cleaned by power tool to St 3 provided the surface is roughened and not polished.</p> <p>Concrete: Remove slip agent and other possible contaminants by emulsion washing followed by high pressure hosing with fresh water. Remove scum layer and loose matter to a hard, rough and uniform surface, preferably by abrasive blasting, possibly by other mechanical treatment or acid etching. Seal surface with suitable sealer, as per relevant painting specification.</p>
Application conditions:	<p>Use only where application and curing can proceed at temperatures above: 10°C/50°F. Before exposure to outside temperatures below 10°C/50°F within the first day after application the coating must have been forced dried at minimum 15 minutes. The temperature of paint itself should be 15°C/59°F or above. Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. In confined spaces provide adequate ventilation during application and drying.</p>
Film thicknesses/thinning: (optional)	<p>The temperature of the paint should preferably be above 15°C (59°F), otherwise extra thinner may be required to obtain application viscosity Adding too much thinner results in reduced sag resistance and slower cure Thinner should be added after mixing the components. Film formation of each coat has to be of good quality, free from defects such as pinholes and without any dry spray.</p>
Overcoating note: (optional)	<p>Overcoating intervals related to later conditions of exposure: If the maximum overcoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion. Before overcoating after exposure in contaminated environment, clean the surface thoroughly with high pressure fresh water hosing and allow drying.</p>
Storage:	<p>Shelf life : Part A: 12 months (25°C) Part B: 12 months (25°C) Subject to re-inspection thereafter. Higher temperature during storage may reduce the shelf life and may lead to gelling in the tin. Store in tightly closed container in a dry, cool and well ventilated space, keep away from sources of heat and ignition.</p>

This Product Data Sheet supersedes those previously issued.

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