

ASODUR[®]-HIGH BUILD

UNIVERSAL EPOXY COATING

Product Description:

ASODUR[®]-HIGH BUILD is a two-component, polyamide cured, high molecular weight epoxy coating. Designed as a high-build, all-purpose coating for new construction. Can be used as a primer, mid-coat, finish coat or as a single-coat system in atmospheric and immersed environments. Suitable for properly prepared carbon steel, stainless steel, aluminium, concrete, galvanised steel, shop primed steel and thermally sprayed zinc substrates.

Primary Uses:

A universal primer specifically designed for use in new construction situations, on steel to be exposed to harsh conditions. Can be applied on a wide range of substrates, as a primer, mid-coat, finish coat or as a single coat system for exposure in atmospheric and immersed environments. May be used by itself or in combination with other compatible products as part of a complete coating system. Offers excellent protection against corrosion and has excellent abrasion resistance. If a cosmetic finish is required it should be used together with a topcoat.

Technical Properties:

Colour	: aluminium, grey.
Solids (vol%)	: 54 ± 2 %.
Flash point	: 25°C.
VOC	: 0.416 kg/ litres.
Glass	: flat.
Water resistance	: excellent.
Abrasion resistance	: excellent.
Solvent resistance	: excellent.
Chemical resistance	: excellent.
Flexibility	: very good.

Mixing ratio (volume)	: 4:1
Mixing	: 4 parts comp. A (base) to be mixed thoroughly with 1 part comp. B. (curing agent).
Induction time	: 30 minutes.
Pot life @23°C	: 8 hours (reduced at higher temperatures).
Thinner/cleaner	: Thinner No.17

Film Thickness and Spreading Rate:

	Minimum	Maximum	Typical
Film thickness, dry (µm)	80	150	100
Film thickness, wet (µm)	150	280	190
Theoretical spreading rate (m ² /l)	6.8	3.6	3.5

Surface Preparation:

All surfaces should be cleaned, dry and free from any contaminations.

Stainless Steel:

Abrasive blast cleaning to achieve a surface profile using non-metallic abrasive media is suitable for achieving a sharp and angular surface profile.

Coated Surfaces:

Clean, dry and undamaged compatible primer. Contact AQUAFIN Pakistan's Technical Services Team for more information.



Other Surfaces:

The coating may be used on the other substrates. Please contact AQUAFIN Pakistan's Technical Services Team for more information.

Condition During Application:

The coating could be applied down to -15°C surface temperature. The temperature of the substrate should be a minimum of 3°C above the dew point of the air, temperature and relative humidity measured in the vicinity of the substrate. Good ventilation is required in confined areas to ensure proper drying and curing. Do not use heated air until solvents have evaporated from the paint film to void surface drying and solvent entrapments. The coating should not be exposed to oil, chemicals or mechanical stress until cured. During the application and the initial drying of the coating, the coating should not be exposed to high humidity as this can result in loss of gloss.

Application Methods:

Spray:

Use airless spray.

Brush:

Recommended for stripe coating and small areas, care must be taken to achieve the specified dry film thickness.

Roller:

May be used for small areas but is not recommended for the first primer coat, however, when using roller application care must be taken to apply sufficient material in order to achieve the specified dry film thickness.

Drying Time:

Drying times are generally related to air circulation, temperature, film thickness and number of coats, and will be affected correspondingly. The figures

Given in the table are typical with good ventilation (outdoor exposure or free circulation of air), typical film thickness and One coat on top of inert substrate.

Substrate Temperature	10°C	23°C	40°C
Surface (touch) dry	5 h	2.5 h	1 h
Walk-on- dry	16 h	8 h	3.5 h
Dry to overcoat, minimum	16 h	8 h	3.5 h
Dry/cured for service.	14 d	7 d	3 d

1. The earliest time that is possible to exert mechanical strain on the coating i.e. walk on to recoat.
2. The earliest time for recoating with the same generic type of paint. Note that the paint film is not hard at this time and cannot withstand mechanical strain.
3. Overcoating by itself for severe (tough mechanical or immersed) exposure.

The given data must be considered as guidelines only. The actual drying time/times before recoating may be shorter or longer, depending on film thickness, ventilation, humidity, underlying paint system, the requirement for early handling and mechanical strength, etc. A complete system can be described on a system sheet, where all parameters and special conditions could be included.

Storage:

ASODUR®-HIGH BUILD must be stored in its original containers tightly sealed. Kept in a dry, cool, well-ventilated area and away from the source of heat as well as ignition.

Health & Safety:

Please refer to the appropriate product MSDS for safety hazards and precautions during the use of the product.

