



BAJAK'S EPOXY FLOW COAT 13220 FC

CURING AGENT 63020

Description: BAJAK'S 13220 FC is a two component epoxy flow coat base on epoxy and polyamide resins and Zinc phosphate as inhibitive pigments (Non toxic pigments) with good anticorrosive properties and facilitates fluid flow in steel pipes.

Recommended use: As an inhibitive flow coat selfe primer on blasted steel pipe to protect that against corrosion and facilitates fluid flow.

Service temperature: Dry: Maximum 130 C Wet: Maximum 50 C

PHYSICAL CONSTANTS:

Colors/Shade No: Red Brown, Gray
Finish: Semi Gloss
Volume Solid: 50%
Theoretical spreading rate: 8.3 m²/liter 60 Mic. Dft.
Flash point: 32 C
Specific gravity: 1.3 kg/liter
Surface dry: Max. 2 hours at 20 C (ISO 1517)
Dry to touch: Max. 4 hours at 20 C
Fully cured: 7 days at 20 C
V.O.C.: Max. 430 gr/liter
Shelf life: 2 Years (25 C/77 F) from time of production. Depending on storage condition, mechanical stirring may be necessary before usage.

APPLICATION DETAILS:

Mixing ratio for 13220 Base 13220 : Curing agent 63020
4 : 1 by weight
Application method: Airless sprays Brush (touch-up)
Thinner (max. vol.) 8020 (5%) 8020 (5%)
Pot life: 8 hours (20 C / 68 F) 8hours (20 C / 68 F)
Nozzle orifice: 0.019" - 0.021"
Nozzle pressure: 150 bar / 2200 Psi
(Airless spray data are indicative and subject to adjustment)
Cleaning of tools: 8020
Indicated film thickness, dry: 60 microns
Indicated film thickness, wet: 120 microns
Recoat interval, min: 8 hours (20 C)
Recoat interval, max: 7 days (20 C), See REMARKS overleaf

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APPLICATION AND CURING CONDITIONS:

New steel: Abrasive blasting to minimum Sa 2 1/2 is recommended. The surface must be completely clean and dry at the time of application. And its temperature must be above the dew point to avoid condensation.

At the freezing point and below, be ware of the risk of ice on the surface which will hinder the adhesion. High humidity and/or condensation during application and the following 16 hours (20 °C/68 °F) may adversely affect the film formation.

In confined spaces provide adequate ventilation during application and drying.

PRECEDING COAT:

None.

SUBSEQUENT COAT:

None , or BAJAK'S EPOXY INTER MEDIATE

REMARKS:

Film thicknesses:

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 recoating interval. Normal range is 60 microns/ 2.4 mils.

Thinning:

The type and amount of thinner depend on application conditions, application method, temperature, ventilation, and substrate. Thinner 8020 is recommended in general.

Physical data versus temperatures:

Recoating And drying/curing Time:				
Surface temperature	5°C /41°F	10°C /50°F	20 °C /68°F	30°C /86°F
Dry to touch approx.	12 hours	8 hours	4 hours	3 hours
Resist condensing humidity/ light showers after	4 days	2 days	24 hours	12 hours
Fully cured	20 days	14 days	7 days	5 days
Recoating interval, With epoxy mid coat	Min	24 hours	16 hours	8 hours
	Max	20 days	14 days	7 days

If the maximum recoating interval is exceeded, whatever the subsequent coat, roughening of the surface is necessary to ensure optimum intercoat adhesion.

A completely clean surface is mandatory to ensure intercoat adhesion, especially in the case of long recoating intervals. Any dirt, oil and grease have to be removed with eg suitable detergent followed by high pressure fresh water cleaning. Salts to be removed by fresh water hosing. Any degraded surface layer, as a result of a long exposure period, must be removed as well. Water jetting may be relevant to remove any degraded surface layer and may also replace the above-mentioned cleaning methods when properly executed. Consult BAJAK for specific advice if in doubt. To check whether the quality of the surface cleaning is adequate, a test patch may be relevant.

SAFETY:

Handle with care. Before and during use, observe all safety labels on packaging and paint containers, consult BAJAK material safety data sheets and follow all local and national safety regulations. Harmful or fatal if swallowed; immediately seek medical assistance swallowed. Avoid inhalations of possible solvent vapors or paint mist, as well as paint contact with skin and eyes. Apply only on well-ventilated areas and ensure that adequate forced ventilation exists when applying paint in confined spaces or when the air is stagnant. Always take precautions against the risks of fire and explosions.