

**BAJAPOX 42525**

CURING AGENT 61091

Formerly 45141

<b>Description:</b>	BAJAPOX 42525 is a two-component, polyamide adduct cured epoxy paint with good wetting properties and low water permeability. It is selfpriming and forms a hard and tough coating which has good resistance against abrasion and impact as well as to seawater, mineral oils, aliphatic hydrocarbons and splashes from petrol and related products. Harmless to grain cargoes.	
<b>Recommended use:</b>	<ol style="list-style-type: none"> <li>1. As a high build primer, intermediate and/or finishing coat in (heavy duty) paint systems according to specification. (As a finishing coat where a cosmetic appearance is of less importance).</li> <li>2. For repair and maintenance work at application temperatures above -5°C on hatch covers, decks, in cargo holds, etc.</li> <li>3. As a ballast tank coating. BAJAPOX 45143 is intended for use in cold/temperate climates, BAJAPOX 42525 for warmer climates - see APPLICATION CONDITIONS overleaf.</li> </ol>	
<b>Service temperature:</b>	Dry:	Maximum 150°C (See REMARKS overleaf)
	Ballast water service:	Resists normal ambient temperatures at sea*
	Other water service:	40°C (no temperature gradient)
	Other liquids:	Contact BAJAK
	*Avoid long-term exposure to negative temperature gradients.	
Certificates/Approvals:	See REMARKS overleaf.	
<b>PHYSICAL CONSTANTS:</b>	<b>42525</b>	
Version; mixed product:	42525	
Colours:	Red	
Finish:	Semi-gloss	
Volume Solid:	60 ± 1%	
Theoretical Spreading Rate:	4.0 m <sup>2</sup> /litre - 150 micron	
Fash point:	25°C	
Specific gravity:	1.3 Kg/liter	
Surface Dry:	4 (approx.) hrs at 20°C (ISO 1517)	
Dry to touch:	7 (approx.) hours at 20°C	
Fully cured:	7 (approx.) days at 20°C	
V.O.C:	385 g/litre	
<b>APPLICATION DETAILS:</b>	<b>42525</b>	
Mixing ratio:	Base 42525 : Curing agent 61091 3 : 1 by volume	
Application method:	Airless spray	Brush
Thinner (max.vol.):	8090 (5%)	8090(5%)
	(See REMARKS overleaf)	
Pot life:	2 hrs (20°C)	4 hrs (20°C)
	(See REMARKS overleaf)	
Nozzle orifice:	.019"-.023"	
Nozzle pressure:	250 bar/3600 psi (Airless spray data are indicative and subject to adjustment)	
Cleaning of tools:	BAJAK,S TOOL CLEANER 8000 or THINNER 8090	
Indicated film thickness, dry:	150 micron(See REMARKS overleaf)	
Indicated film thickness, wet:	250 micron	
Recoat interval, min:	As per separate APPLICATION INSTRUCTIONS	
Recoat interval, max:	As per separate APPLICATION INSTRUCTIONS	

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## BAJADUR 42525

**SURFACE PREPARATION:** New steel: When used selfprimed surface preparation as to specification. When being integral part in heavy duty systems abrasive blasting to Sa 2½. Reference is made to separate APPLICATION INSTRUCTIONS.

New steel, ballast tanks and similar areas: Abrasive blasting to Sa 2½. For temporary protection, if required, use a suitable shopprimer. All damage of shopprimer and contamination from storage and fabrication should be thoroughly cleaned prior to final painting - preferably by abrasive blasting. For repair and touch-up, use BAJAPOX 42525.

Stainless steel: (Ballast tanks in chemical carriers) to be abrasive blasted to a uniform, sharp, dense profile, ISO Comparator Medium (G), corresponding to Rz minimum 50 micron. Any salts, grease, oil, etc. to be removed before abrasive blasting is commenced.

Repair and maintenance: Remove oil and grease, etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. Clean damaged areas thoroughly by power tool cleaning to St 3 (spot-repairs) or by abrasive blasting to min. Sa 2, preferably to Sa 2½. Improved surface preparation will improve the performance of BAJAPOX 42525.

As an alternative to dry cleaning, water jetting to min. WJ-3, preferably WJ-2 (NACE No. 5/SSPC-SP 12), may be used. A flash-rust degree of FR-1 maximum FR-2 (BAJAK standard) is acceptable before application. Feather edges to sound and intact paint. Dust off residues.

On pit-corroded surfaces, excessive amounts of salt residues may call for water jetting, wet

abrasive blasting, alternatively dry abrasive blasting, high pressure fresh water hosing, drying, and finally, dry abrasive blasting again.

**APPLICATION CONDITIONS:** Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation.

BAJAPOX 42525 is to be selected in warmer climates. BAJAPOX 42525 may be used for curing conditions down to 0°C in cases where surfaces are not to be immersed. Optimal spraying properties are obtained at paint temperatures of 18-22°C. In warm climates, the paint should be stored in a cool place. At paint temperatures below 15°C or in the case of very long spray hoses, thinning may be necessary. This will cause lower film build and longer drying time.

In confined spaces provide adequate ventilation during application and drying.

**PRECEDING COAT:**

None or according to specification.

**SUBSEQUENT COAT:**

None or according to specification.

**REMARKS:**

See separate APPLICATION INSTRUCTIONS.

Certificates/

Certificates have been issued under the former quality number 4514.

Approvals:

Approved by Lloyd's Register of Shipping as a recognized corrosion control coating.

Weathering/

Service temperatures:

The natural tendency of epoxy coatings to chalk in outdoor exposure and to become more sensitive to mechanical damage and chemical exposure at elevated temperatures is also reflected in this product.

Film thickness:

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 dry is 125-175 micron.

**Note:**

**BAJAPOX 42525 is for professional use only.**

Thinning:

Thinning above 5% may cause lower film build and slower drying/curing. Mix the components thoroughly.

Induction time:

If the paint temperature, as an exception, is below approx. 10°C, allow the mixture to pre-react 30 minutes before use.

Recoating:

Recoat intervals related to later conditions of exposure: Consult separate APPLICATION

INSTRUCTIONS. Before recoating after exposure in contaminated environment, clean the surface thoroughly by (high pressure) fresh water hosing and allow to dry.

If the maximum recoat interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion.

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