BAJAPOX 15100

CURING AGENT 95100

Description:

BAJAPOX 15100 is a two-component, amine-adduct cured high build coal tar epoxy. It has excellent resistance to wear and impact as well as to sea water, waste water, fuel oil and to aliphatic solvents and it resists spillage of mineral acids and aromatic hydrocarbon solvents. It has a higher resistance to elevated temperature and temperature gradients than polyamide cured coal tar epoxies.

Recommended use:

BAJAPOX 15100 is recommended for long time corrosion protection of structural steel and concrete in severe corrosive and immersed environments. Typical areas are steel buried in aggressive soil, pipelines of steel and concrete, tanks containing fuel or lubrication oil, drill water, drill mud, warm water (see below) or steel and concrete in sewage treatment plants.

Service temperatures:

Dry :	In water (maximum temperature gradient 35°C/63°F):
100°C/212°F	90°C/194°F

PHYSICAL CONSTANTS:

Mixed product:	15100	15100
Colours/Shade no:	Black	Brown
Finish:	Semi-gloss	Semi-gloss
Volume Solids, %:	55±1	55±1
Theoretical spreading rate:	2.8 m²/litre - 200 micron 110 sq.ft./US gallon - 8 mils	2.8 m²/litre - 200 micron 110 sq.ft./US gallon - 8 mils
Flash point:	13°C/56°F	13°C/56°F
Specific gravity:	1.3 kg/litre - 10.8 lbs/US gallon	1.4 kg/litre – 11.4 lbs/US gallon
Surface dry:	4 (approx.) hours at 20ºC/68ºF (ISO 1517)	4 (approx.) hours at 20ºC/68ºF (ISO 1517)
Dry to touch:	6 (approx.) hours at 20ºC/68ºF	6 (approx.) hours at 20ºC/68ºF
Fully cured:	7 days at 20ºC/68ºF	7 days at 20ºC/68ºF
V.O.C.:	390 g/litre - 3.2 lbs/US gallon	390 g/litre - 3.2 lbs/US gallon
Shelf life:	1 year (25°C/77°F) from time of production. Depending on storage conditions, mechanical stirring may be necessary before usage.	

APPLICATION DETAILS:

Mixing ratio for 15100:	BASE 15100 : Curing agent 95100 4 : 1 by volume	
Application method:	Airless spray	Brush
Thinner (max.vol.):	08450 (5%)	08450 (5%)
Pot life:	2 hours (20°C/68°F)	6 hours (20°C/68°F)
Nozzle orifice:	0.023”	
Nozzle pressure:	200 bar/2900 psi (Airless spray data are indicative and subject to adjustment)	
Cleaning of tools:	BAJAK’S TOOL CLEANER 99610	
Indicated dft:	200 micron/8 mils	
Indicated wft:	350 micron/14 mils	
Recoat interval, min:	See REMARKS overleaf	
Recoat interval, max:	See REMARKS overleaf	

2. BAJAPOX 15100

SURFACE PREPARATION:

New steel: Abrasive blasting to Sa 2½. For temporary protection, a suitable shopprimer may be used. All damage of shopprimer and contamination from storage and fabrication should be thoroughly cleaned prior to final painting. For repair and touch-up use BAJAPOX 15100. Depending on severity of later in-service exposure, abrasive blast sweeping or full removal by blast cleaning of intact shopprimer is recommended before coating with BAJAPOX 15100.
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, e.g. BAJAPOX SEALER 10597 (furthermore, please see Product Data Sheet for 05970).
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 abrasive blasting or power tool cleaning. Feather edges to sound and intact areas. Dust off residues. Touch up to full film thickness.

APPLICATION CONDITIONS:

Use only where application and curing can proceed at temperatures above 10°C/50°F. The temperature of the surface and that of the paint itself must also be above this limit. 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.

PRECEDING COAT:

Steel: None, BAJAPOX 15590 or according to specification.
Concrete: BAJAPOX SEALER 05970.

SUBSEQUENT COAT:

None

REMARKS:

Service temperatures:

The natural tendency of epoxy coatings to be come 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 amount of thinning necessary, drying time and recoating interval. Normal range is 125-200 micron/5-8 mils

Recoating:

Recoating intervals related to later conditions of exposure:
(200 micron/8 mils dry film thickness of BAJAPOX 15100)

	Minimum		Maximum	
Surface temperature	20°C/68°F		20°C/68°F	
Recoated with (Quality number only)	Atmospheric Serve	Water Immersion	Atmospheric Serve	Water Immersion
15100	6 hours	6 hours	36 hours*	36 hours*

*The maximum recoating interval between the layers of BAJAPOX 15100 can be prolonged to 4 days at 20°C/68°F **on the condition that the coating has not been exposed to sunlight, water/condensation or to (other) contamination before recoating. Furthermore, the surface of the first coat of BAJAPOX 15100 must be free of any exudations.** This is secured by keeping the conditions of application, drying and curing, ie such as ventilation, temperature, film thickness and thinning within the described limits. Note that excessive temperature during application/curing also must be avoided.

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

Note:

BAJAPOX 15100 is for professional use only.

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 or national safety regulations. Avoid inhalation, avoid contact with skin and eyes, and do not swallow. Take precautions against possible risks of fire or explosions as well as protection of the environment. Apply only in well ventilated areas.