BAJAPOX 15550

CURING AGENT 95360

Description:

BAJAPOX 15550 is a two-component polyamide adduct-cured epoxy paint. It cures down to 10°C/14°F to a strong coating with good adhesion properties

Recommended use:

As a primer for BAJATEX BAJAPOX and BAJATHANE systems on hot dipped galvanized & stainless steel surfaces. In moderately corrosive environments. BAJAPOX 15550 is also suited when roughening of the surface is not possible. Please see surface preparation overleaf.

Service temperatures:

Maximum , dry : 140°C/284°F

PHYSICAL CONSTANTS:

Colours/Shade nos:	Red
Finish:	Flat
Volume Solids, %:	43 ± 1
Theoretical spreading rate:	8.6 m²/litre – 50 micron 345 sq.ft./US gallon - 2 mils
Flash point:	22°C/72°F
Specific gravity:	1.4 kg/litre - 11.7 lbs/US gallon
Surface dry:	¾(approx.) hrs at 20°C/68°F (ISO 1517)
Dry to touch:	2(approx.) hrs at 20°C/68°F
Fully cured:	7 days at 20°C/68°F
V.O.C.:	515 g/litre - 4.3 lbs/US gallon

Storage stability:

½ year from date of production. If exceeded, please contact BAJAK for further advice.

APPLICATION DETAILS:

Mixing ratio	Base 155500 : Curing agent 95360 7 : 1 by volume	
Application method:	Airless spray	Brush
Thinner (max.vol.):	08450 (5%)	08450 (5%)
Pot life:	2 hours (20°C/68°F) 8 hours (20°C/68°F) (brush)	
Nozzle orifice:	.021"	
Nozzle pressure:	175 bar/2450 psi (Airless spray data are indicative and subject to adjustment)	
Cleaning tools:	BAJAK'S TOOL CLEANER 99610	
Indicated film thickness, dry:	50 micron/2 mils (see REMARKS overleaf)	
Indicated film thickness, wet:	125 micron/5 mils	
Recoat interval, min:	See REMARKS overleaf	
Recoat interval, max:	See REMARKS overleaf	

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. This goes for personal protection such as, but not limited to, protection of lungs, eyes and of the skin, medical treatment in case of swallowing the paint or in case of other direct contact with the paint. Take necessary precautions against possible risks of fire or explosions as well as protection of the environment. Apply only in well ventilated areas and ensure that adequate forced ventilation exists when applying paint in confined spaces or when the air is stagnant.

2. BAJAPOX 15550

SURFACE PREPARATION: Removing oil and grease etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. " White rust" must be removed by sandpapering or light abrasive sweeping.
In certain cases – related to the structure of the outer zinc layer – roughening of the galvanized surfaces will be necessary to secure adhesion.
Concerning galvanizing it is recommended that fluxing takes place before dipping steel in the zinc kettle. Furthermore, see REMARKS below.

APPLICATION CONDITIONS: Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. At the freezing point and below be aware of the risk of ice on the surface, which will hinder the adhesion.
Use only where application and curing can proceed at temperatures above 10°C/50°F, the temperature of the surface must also be above these limit.
The temperature of the paint itself should be 15-25°C/59-77°F.
In confined spaces provide adequate ventilation during application and drying.

SUBSEQUENT COAT: BAJAPOX, BAJATHANE or BAJATEX qualities or according to specification.

REMARKS:

Passivation/: Surface preparation: Ammonium chloride or any other passivation agent should not be present on the surface when coating the galvanized surface.
Water should not be used for coating down the steel.
Cleaning of steel should not be initiated unless the steel temperature is below 30°C/86°F.

Application: As the galvanized zinc layer may be porous it is recommended to apply a mist coat of undiluted BAJAPOX 15550, allow air to escape and then apply of full coat of BAJAPOX 15550 a few minutes later.

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 50-80 micron/ 2-3.2mils.

Recoating: Recoating intervals related to later conditions of atmospheric exposure:

	Minimum			Maximum		
Surface temperature	20°C/68°F			20°C/68°F		
	Atmospheric			**Atmospheric**		
Recoated with	**Mild**	**Medium**	**Severe**	**Mild**	**Medium**	**Severe**
BAJATEX	**15 minutes**	**15 minutes**	**2 hours**	**None**	**24 hours**	**12 hours**
BAJAPOX	**2 hours**	**2 hours**	**6 hours**	**None**	**None**	**None**
BAJATHANE	**2 hours**	**2 hours**	**6 hours**	**None**	**10 days**	**3 days**

Except for mild climatic avoid long-term exposure of galvanized steel only coated with a thin layer of paint as this, may create white rust under the paint.

If the maximum recoating interval is exceeded, whatever the subsequent coat, roughening of the surface is necessary to ensure optimum intercoat adhesion or in the case of recoating with coatings other than BAJAPOX, apply a (thin) additional coat of BAJAPOX 15550 within the above directions for recoating.
A completely clean surface is mandatory to ensure intercoat adhesion, especially in the case of long recoating intervals. Any dirt, oil and grease have o be removed with a 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.

Note: **BAJAPOX 15550 is for professional use only .**