

BAJAPOX 45150

SURFACE

PREPARATION:

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 BAJAPOX4515. As an alternative to dry leaning, water jetting to min. WJ-3, preferably WJ-2 (NACE No. 5/SSPC-SP 12), may be used. A flash-rust degree of maximum FR-2 (BAJAK standard) is acceptable before application. Feather edges to sound intact areas. Dust off residues. Touch up to full film thickness. On pit-corroded surfaces, excessive amounts of salt residues may call for high pressure water jetting or wet abrasive blasting, alternatively dry abrasive blasting followed by high pressure fresh water hosing, drying, and finally, dry abrasive blasting again. Please see APPLICATION INSTRUCTIONS.

New steel: When used as intermediate and/or finishing coat surface preparation as to Product Data Sheet for the preceding primer coat (BAJAPOX primers). When used selfpriming surface preparation as to specification.

ZINCSILS: Please see APPLICATION INSTRUCTIONS.

APPLICATION CONDITIONS:

Apply only on a dry and clean surface. Use only where application and curing can proceed at temperatures above approx. 15°C/59°F. The temperature of the paint itself should also be minimum 15°C/59°F.

At high temperatures use the product immediately after a thorough mixing and stirring. See REMARKS below.

In confined spaces provide adequate ventilation during application and drying.

PRECEDING COAT:

None or according to specification. BAJAPOX 45150 may be used directly on zinc silicates or metal-sprayed surfaces - reference is made to APPLICATION INSTRUCTIONS.

SUBSEQUENT COAT:

None or according to specification.

REMARKS:

Please see separate APPLICATION INSTRUCTIONS.

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.

Colour:

Light shades will have a tendency to yellow when exposed to sunshine and darken when exposed to heat.

Film thicknesses:

May be specified in another film thickness than indicated depending on purpose and area of use. For airless spray application normal range is 150-250 micron/6-10 mils. This will alter spreading rate and may slightly influence drying time and recoating interval. Concerning measurement of wet film thickness, please consult separate APPLICATION INSTRUCTIONS.

For application by brush, obtainable dry film thicknesses are up to 100-125 micron/4-5 mils per coat.

Curing agent:

Note: At certain stockpoints, BAJAPOX 45150 may be supplied with an alternative, low-viscosity CURING AGENT 95450 in order to facilitate spray application in a dry film thickness of 75-150 micron/3-6 mils. This curing agent can be used for brush application too if a smooth surface is required. Contact BAJAK for further advice.

Pot life:

The pot life is dependent on packing size and temperature. For bigger packings and a temperature at 35°C/95°F the pot life will be reduced to approx. 15 minutes.

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.

Note:

BAJAPOX 45150 is for professional use only.