



BAJAPOX HI-BUILD 45200

CURING AGENT 95040

Description: BAJAPOX HI-BUILD 45200 is a two-component, high build epoxy polyamide paint. It forms a hard and tough coating resistant to seawater, diesel oil, splashes from petrol and related products. Limited resistance to animal and vegetable oils and strong solvents such as ketones and esters. Not recommended for acids, alkalis, or oxidizing solutions. Harmless to grain cargo.

Recommended use: As a self primed paint system or as an intermediate or finish coat in epoxy systems in severely corrosive environment.
As a finishing coat where a cosmetic appearance is of less importance.
As a sealer for metal-sprayed coatings or zinc silicate primers in epoxy systems .
CURING AGENT 95040, polyamide, is typically for use in tropical and subtropical climates. CURING AGENT 95570, polyamide adduct, facilitate curing at temperatures down to -10°C/14°F.

Service temperatures:

	Dry:	In water (no temperature gradient):
Maximum :	140°C/284°F	35°C/95°F

 See REMARKS overleaf

PHYSICAL CONSTANTS:

Version;mixed product:	45200
Colours/Shade nos:	Grey (*other shades according to assortment RAL standard)
Finish:	Semi- flat
Volume Solids, %:	61 ± 1
Theoretical spreading rate:	6.1 m ² /litre – 100 micron 245 sq.ft./US gallon - 4 mils
Flash point:	26°C/79°F
Specific gravity:	1.4 kg/litre - 11.7 lbs/US gallon
Surface dry:	2 (approx.) hrs at 20°C/68°F (ISO 1517)
Dry to touch:	6-8 hours at 20°C/68°F
Fully cured:	7 days at 20°C/68°F
V.O.C.:	395 g/litre - 3.3 lbs/US gallon
Shelf life:	1 year (25°C) from time of production. Depending on storage condition: mechanical stirring may be necessary before usage.

*Other shades according to assortment list.

The physical constants stated are nominal data according to the BAJAK'S approved formulas. They are subject to normal manufacturing tolerances and where stated, being standard deviation according to ISO 3534-1. Further reference is made to "Explanatory Notes" in the BAJAK Book.

APPLICATION DETAILS:

Mixing ratio	45200 Base 45200 : Curing agent 95040 3 : 1 by volume	
Application method:	Airless spray	Brush (touch up)
Thinner (max.vol.):	08450 (5%) (See REMARKS overleaf)	08450 (5%)
Pot life:	5 hours (20°C/68°F) (airless) 8 hours (20°C/68°F) (brush)	
Nozzle orifice:	.018"-.021"	
Nozzle pressure:	250 bar/3600 psi (Airless spray data are indicative and subject to adjustment)	
Indicated film thickness, dry:	100 micron/4 mils (see REMARKS overleaf)	
Indicated film thickness, wet:	175 micron/7 mils	
Recoat interval, min:	See REMARKS overleaf	
Recoat interval, max:	See REMARKS overleaf	

2. BAJAPOX HI-BUILD 45200

SURFACE PREPARATION: **New steel:** Abrasive blasting to Sa 2½. For temporary protection, if required, use suitable shopprimer. 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 HI-BUILD 45200 or other specified BAJAPOX paint.

Maintenance: Remove oil and grease, etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. Remove all rust and other loose material 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: Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. Use only when application and curing can proceed at temperatures above 10°C/50°F, preferably above 15°C/59°F when using curing agent 95040 and above -10°C/14°F when using curing agent 95570. The temperature of the surface must also be above these limits, respectively. At the freezing point and below be aware of the risk of ice on the surface, which will hinder the adhesion. The temperature of the paint itself should be 15°C/60°F or above to secure proper application properties. In confined spaces provide adequate ventilation during application and drying.

PRECEDING COAT: None, PAJAPOX PRIMER 15300/15302, BAJAPOX ZINC 15360/15363 or according to specification

SUBSEQUENT COAT: None, BAJATHANE qualities or according to specification.

REMARKS:

Colours: Certain lead-free red and yellow colours may discolour when exposed to chlorine- containing atmosphere.
Leaded colours may become discoloured when exposed to sulphide-containing atmosphere.

Weathering/ service temperature: 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 80-125 micron/3.2-5 mils (100-125 micron/4-5 mils with CURING AGENT 95040).

Sealer: When used as a sealer on metal-sprayed coatings or zinc silicate primers, BAJAPOX HI-BUILD 45200 should be diluted 10-15% with THINNER 08700, recommended dry film thickness: 40 micron. Application by "flash coat technique" may be necessary, but a "closed film" is to be obtained and the following coat should not be applied within the next 8 hours (20°C/68°F).

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

SURFACE TEMPERATURE	Minimum		Maximum		Minimum		Maximum	
	20°C/68°F				10°C/50°F			
	45200 100 micron/4 mils				45201 100 micron/4 mils			
Recoated with (Quality numbers only)	Medium	Severe	Medium	Severe	Medium	Severe	Medium	Severe
46330,46410,56360 BAJATHANE BAJAPOX	6 hours 12 hours	6 hours 16 hours	16 hours 10 days	12 hours 3 days	6 hours 12 hours	6 hours 16 hours	12 hours 20 days	10 hours 6 days
	12 hours	16 hours	None	None	12 hours	16 hours	None	None

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 HI-BUILD 45200 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 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.

Note: **BAJAPOX HI-BUILD 45200 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. 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