



BAJAPOX HIGH SOLID 45880 BAJAPOX HIGH SOLID 45881

High temperatures: 45881 with CURING AGENT 95881

Low to medium temperatures: 45880 with CURING AGENT 95880

Description: BAJAPOX HIGH SOLID 45880/45881 is a two-component polyamide adduct cured, high solids, high build epoxy paint. It forms a hard and tough coating and has good wetting properties. Low temperature curing.

Recommended use: As a selfprimed paint system or as an intermediate or finishing coat in epoxy systems in medium to severely corrosive atmospheric environment and where a high solid content is required.
The MIO (micaceous iron oxide) pigment version may be specified where extended recoating properties for polyurethane topcoats are requested (typically travel coating). As a topcoat where the usual outdoor cosmetic appearance of epoxy paints is acceptable.
May be used directly on cured zinc silicate (ZINCSIL products) or spray - metallized surfaces to minimize popping.

Service temperatures: Maximum, dry: 120 °C/248 °F

PHYSICAL CONSTANTS:

	45880	45881
Mixed product:	45880	45881
Colours:	Grey	Grey
Finish:	Semi-gloss	Semi-gloss
Volume Solids, %:	80 ± 1	80 ± 1
Theoretical spreading rate:	5.3 m ² /litre - 150 micron 214 sq.ft./US gallon - 6 mils	5.3 m ² /litre - 150 micron 214 sq.ft./US gallon - 6 mils
Flash point:	28 °C/82 °F	28 °C/82 °F
Specific gravity:	1.4 kg./litre - 11.7 lbs/US gallon	1.4 kg./litre - 11.7 lbs/US gallon
Dry to touch:	4 (approx) hours at 20 °C/68 °F	3 (approx) hours at 30 °C/86 °F
Fully cured:	7 days at 20 °C/68 °F	5 days at 30 °C/86 °F
V.O.C.:	215 g./litre - 1.8 lbs/US gallon	215 g./litre - 1.8 lbs/US gallon

APPLICATION DETAILS:

	45880	45881
Mixing ratio	Base 45880 : Curing agent 95880 3 : 1 by volume	Base 45881 : Curing agent 95881 3 : 1 by volume
Application method:	Airless spray Brush (touch up)	Airless spray Brush (touch up)
Thinner (max.vol.):	Depending on purpose usually less than 5% THINNER 08450 (See REMARKS overleaf)	5% THINNER 08450 (See REMARKS overleaf)
Pot life:	1 hour (20 °C/68 °F) (Airless spray) 2 hours (20 °C/68 °F) (Brush) (See separate APPLICATION INSTRUCTIONS)	1½ hour (30 °C/86 °F) (Airless spray) 2 hours (30 °C/86 °F) (Brush) (See separate APPLICATION INSTRUCTIONS)
Nozzle orifice:	017"-023" (See separate APPLICATION INSTRUCTIONS)	
Nozzle pressure:	.250 bar/3600 psi (Airless spray data are indicative and subject to adjustment)	
Cleaning of tools:	BAJAK'S TOOL CLEANER 99610 or BAJAK'S THINNER 08450	
Indicated film thickness, dry:	150 micron/6 mils (see REMARKS overleaf)	
Indicated film thickness, wet:	200 micron/8 mils	
Recoat interval, min:	According to separate APPLICATION INSTRUCTIONS	
Recoat interval, max:	According to separate APPLICATION INSTRUCTIONS	

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.

2. BAJAPOX HIGH SOLID 45880/45881

SURFACE PREPARATION:	<p>New steel: When used as an intermediate or finishing coat please refer to the data sheet for the preceding BAJAPOX primer. When used as a primer please refer to the specification.</p> <p>Zinc silicate painted or spray-metallized surfaces: Remove oil and grease, etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. Zinc salts (white rust) must be removed by high pressure hosing combined with rubbing with a stiff nylon brush if necessary. It is recommended to recoat spray-metallized surfaces as soon as possible to avoid possible contamination.</p> <p>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, eg BAJAPOX SEALER 05970 (furthermore, please see Product Data Sheet for 05970).</p> <p>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 minimum St 2 (spot-repairs) or by abrasive blasting to min. Sa 2, preferably to Sa 2½. Improved surface preparation will improve the performance of BAJAPOX HIGH SOLID 45880/45881. As an alternative to dry cleaning, water eating to min. WJ-2 (NACE No. 5/SSPC-SP 12), may be used. A flash-rust degree of maximum FR-2 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 eating, wet abrasive blasting, alternatively dry abrasive blasting, high pressure fresh water hosing, drying, and finally, dry abrasive blasting again.</p>
APPLICATION CONDITIONS:	<p>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 /14 °F for BAJAPOX HIGH SOLID 45880 and above approx. 25 °C/77°F for BAJAPOX HIGH SOLID 45881. The temperature of the paint itself should be 15 °C/59 °F for above, but advantageously below approximately 30 °C/86 °F to secure proper application properties. Optimal spraying properties are obtained at a paint temperature of 18-22 °C/64-72 °F In warmer climates, the paint should be stored in a cool place and the paint temperature should preferably be kept below 30 °C/86 °F. In confined spaces provide adequate ventilation during application and drying. In cases where faster drying at very low temperatures is required, BAJAPOX HIGH SOLID 45880 may advantageously be replaced by BAJAPOX 45143. Please also see separate APPLICATION INSTRUCTIONS.</p>
PRECEDING COAT:	None or according to specification.
SUBSEQUENT COAT:	None or according to specification.
Colours:	<p>Certain lead-free red and yellow colours may discolour when exposed to chlorine- containing atmosphere.</p> <p>Leaded colours may become discoloured when exposed to sulphide-containing atmosphere.</p>
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 thicknesses / thinning:	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 125-200 micron/5-8 mils. May be specified in lower film thickness for which purpose additional thinning is required, please see separate APPLICATION INSTRUCTIONS. Avoid application of excessive film thicknesses.
Application onto zinc silicate or spray-metallized surfaces: (thinning):	It is recommended to apply BAJAPOX HIGH SOLID 45880 by using a "mist-coat" procedure provided silicate or spray- the paint temperature is approximately above 20 °C/68 °F: A thin, undiluted coat is applied (the metallized surfaces: mist coat) and after a few minutes, a second coat is applied in the full specified film thickness. If (thinning): the paint temperature is below 20 °C/68 °F thinning (max 15%) may be required.
Note:	BAJAPOX HIGH SOLID 45880/45881 is for professional use only.