



BAJAK'S GLASSFIBER MAT 690SA

Description: BAJAK'S GLASSFIBER MAT 690SA is a glass-fiber chopped strand mat made from E-Glass. It has good surface bonding, high strand integrity and good drapability.

Recommended use: As a glassfiber mat for use in conjunction with EPOXY Hand-Lay-Up or Chopped-fibre system.

PHYSICAL CONSTANTS:

Weight : 450 (Nominal) g/m², BS 3496

Moisture content : 0.5% (Maximum) ISO 3344

Loss on ignition : 4.8%

APPLICATION DETAILS:

Application method: For information as to proper usage, etc., please contact nearest BAJAK office.

Note : BAJAK'S GLASSFIBRE MAT 690SA is for professional use only.

Issued: March 2004

BAJAK'S GLASSFIBER SURFACING TISSUE 691SA

Description:

BAJAK'S GLASSFIBER SURFACING TISSUE 691SA is composed of staple glassfiber arranged in a fibrous veil-like pattern. It is designed to absorb a very high percentage of the laminating resin and provides a reinforced resin-rich surface on contact mouldings.

Recommended use:

As a surfacing tissue for use in conjunction with EPOXY Hand-Lay-up system.

PHYSICAL CONSTANTS:

Nominal thickness: 0.3 mm

Nominal density : 30 g/m²

APPLICATION DETAILS:

Application method: For information as to proper usage, etc., please contact nearest BAJAK office.

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باجاک (سهامی خاص)

BAJAK'S ZINCSIL 1570 D

Bajak's ZinCsil 97170

- Description:** BAJAK'S ZINCSIL 1570 D is a two-component, solvent-borne, self-curing, inorganic zinc silicate with outstanding resistance against weathering and abrasion. It has excellent chemical resistance within the pH range 6-9. For service temperature range, see below. Applicable by airless spray. Offers cathodic protection of local mechanical damage.
- Recommended use:**
1. As a general purpose, heavy-duty, rust-preventing primer.
 2. As a single, complete coating for long-term protection of steel exposed to moderately to severely corrosive environment and to abrasion.
 3. As a shopprimer.
- Service temperatures:** Dry service temperatures above 400°C/750°F do not result in immediate break-down but reduces long-term anticorrosive properties. Temperatures above approx. 500°C/900°F cause immediate breakdown.
Humid conditions :See REMARKS overleaf.

PHYSICAL CONSTANTS:

Colours/Shade nos:	Metal grey/19840
Finish:	Flat
Volume solids:	45%
Theoretical spreading rate:	10 m ² /litre - 50 micron
Zinc content in dry film:	> 93% wt
Flash point:	14°C/57°F
Specific gravity:	3 kg/litre – 25 lbs/US gallon
Dry to touch:	Approx.30 (approx.) min. at 25°C/77°F (40% RH)
Fully cured:	24 hours at 25°C/68°F (40% RH) Rub test required
V.O.C.:	450 g/litre – 3.77 lbs/US gallon
Shelf life:	2 Month (25°C/77°F) from time of production. Shelf life is depended on storage temperature. Shelf life is reduced at storage temperatures above 25°C/77°F. Do not store above 40°C/104°F. Shelf life is exceeded if the liquid is gelled or if the mixed product forms gels before application.

The physical constants are subject to normal manufacturing tolerances.

APPLICATION DETAILS:

Mixing ratio for 1570 D:	Liquid 1570 D: zinc dust 97170 1 parts by weight : 4 parts by weight
Application method:	Airless spray
Thinner (max.vol.):	08700 B (5%)
Pot life:	2 hours (20°C/68°F)
Nozzle orifice:	.019"-.023"
Nozzle pressure:	100 bar/1500 psi (Airless spray data are indicative and subject to adjustment)
Cleaning of tools:	THINNER 08700 B
Indicated film thickness, dry:	50 micron/2 mils (See REMARKS overleaf)
Indicated film thickness, wet :	100 micron/4 mils
Recoat interval, min. :	See REMARKS overleaf
Recoat interval, max. :	None. Consult with BAJAK's technical department.

BAJAK'S ZINCSIL 1570D

SURFACE PREPARATION:	Remove oil and grease, etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. Gritblasting to minimum Sa 2½ with a surface profile equivalent to Rugotest No. 3, BN10a, Keane-Tator Comparator, min. 3.0 G/S, or ISO Comparator rough MEDIUM (G). In case of new steel to be exposed to no more than medium aggressive (industrial) environment and without any extraordinary demands to lifetime, a surface preparation degree of SSPC-SP6 may suffice.
APPLICATION CONDITIONS:	The surface must be completely clean and dry with a temperature 3°C above the dew point to avoid condensation. At temperatures ranging from -10°C/15°F to 40°C/105°F.
SUBSEQUENT COAT:	none or according to specification.
REMARKS:	<p>Note: If used as anticorrosive protection under insulation of high temperature equipment it is very important that NO moisture can penetrate during shut-down periods. This to avoid risk of "wet corrosion" when the temperature rises. Wet service temperature, non-saline water: Maximum 60°C/140°F.</p> <p>Hot sea water washing and (low pressure) steam cleaning should never be executed on coatings which have not been in service for at least one month.</p>
Film thicknesses:	<p>If topcoated with a heavy- duty system, 50 micron/2 mils dry film thickness (100 microns/4 mils wet) is recommended.</p> <p>Minimum interval at 25°C/77°F, 40% RH for recoating with: BAJABOX (system/high-build) 1 days, full curing. BAJAPOX (25 micron/1 mil) 12 hours</p>
Recoating:	Recoating intervals are strongly dependent on both temperature and humidity. Deviations from the standard conditions may shorten or prolong the recoating intervals. The coating interval of 12 hours for 25 micron/1 mil BAJAPOX is only valid in case the subsequent coat is applied more than 1day after (25°C/77°F), 40% RH. Otherwise, the minimum recoating interval is the same as for system/high-build.
Curing:	Before cargo tanks are taken into use, the coating must be completely through-cured. It is recommended to carry out low pressure hosing of the tanks with (fresh) water 2-3 times . Let the tanks remain wet between the washings.
Note:	BAJAK'S ZINCSIL 1570 D is for professional use only.
SAFETY:	Handle with care. Before and during use, observe all safety labels on packaging and paint containers. Harmful or fatal if swallowed; immediately seek medical assistance. Avoid inhalation of possible solvent vapours or print mist, as well as Paint contact with skin and eyes. 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. Always take precautions against the risks of fire and explosions.
ISSUED:	June 2006.

2. BAJAK'S RESIN 05500

SURFACE PREPARATION :	Steel : Abrasive blasting to minimum ISO 8501-1:1988 standard Sa 2½ - 3, depending on area of use. Minimum roughness corresponding to Rugotest No. 3, BN11. Oil and grease must be removed by emulsifier cleaning and salts by high pressure hosing prior to blasting. After blasting, clean the surface carefully from abrasive and dust. Desert sand not recommended. Concrete: (Dry, fully cured) The concrete must be of good quality and fully cured. Minimum pull-off value should normally be 20 kilopond/cm ² measured after surface preparation. Cracks, crevices and voids must be repaired. The surface must be dry and free from dust, grease, etc. Laitance layer and loose particles must be removed, preferably by abrasive sweeping. The blasted or otherwise treated surfaces must be cleaned from dust abrasive, etc. , preferably by high pressure water hosing, whereupon complete drying must take place. Furthermore, see data sheet for BAJAPOX SEALER 0597 which is used to steel the surface. Necessary filling can then be done with, e.g BAJAK'S EPOXY KNIFING FILLER 355SA or with BAJAK'S EPOXY GROUT 353SA.
APPLICATION CONDITIONS:	Minimum temperature of material and substrate during application should be 15°C/59°F while curing will proceed down to 10°C/50°F. Clean and dry surface with a temperature above the dew point to avoid condensation.
PRECEDING COAT:	According to specification.
SUBSEQUENT COAT:	None or BAJAPOX 1540, BAJAPOX HIGH-STRENGTH 35530 or according to specification.
REMARKS: APPLICATION:	For further application details, consult the application instructions or contact the BAJAK office.

Note: **BAJAK'S RESIN 05500 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. Harmful or fatal if swallowed; Immediately seek medical assistance if swallowed, Avoid inhalation of possible solvent vapours or paint mist, as well as paint contact with skin and eyes. 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. Always take precautions against the risks of fire and explosions.

Issued: March 2004

2. BAJATHANE HI-BUILD 5521B

APPLICATION AND CURING CONDITIONS: The surface must be completely clean and dry at the time of application, and its temperature must be above the dew point to avoid condensation. Minimum temperature of curing is $-10^{\circ}\text{C}/14^{\circ}\text{F}$. At the freezing point and below, be aware of the risk of ice on the surface which will hinder the adhesion. High humidity and/or condensation during application and the following 16 hours ($20^{\circ}\text{C}/68^{\circ}\text{F}$) may adversely affect the film formation. In confined spaces provide adequate ventilation during application and drying.

PRECEDING COAT: BAJAPOX 45141, BAJAPOX HI-BUILD 45200/45201, BAJAPOX 45304, BAJAPOXMASTIC 45880 or according to specification.

SUBSEQUENT COAT: None.

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

SERVICE TEMPERATURE: At service temperature above $100^{\circ}\text{C}/212^{\circ}\text{F}$, slight discoloration may be expected.

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 is 75-125 micron/ 3-5 mils.

Thinning: The type and amount of thinner depend on application conditions, application method, temperature, ventilation, and substrate. THINNER 0808 is recommended in general. THINNER 08510 may be used alternatively depending on local condition.
Airless spray: 5-15% thinning is recommended. Under extreme conditions up to more than 20% may be necessary to obtain satisfactory film formation.
 The best result is obtained by applying a mist coat of BAJATHANE ENAMEL 5521B at first, and then 2-15 minutes later apply to full film thickness giving a uniform film formation. Do not exaggerate the film thickness.

Recoating And drying/curing time:

Physical data versus temperatures:						
SURFACE TEMPERATURE		$-10^{\circ}\text{C}/14^{\circ}\text{F}$	$0^{\circ}\text{C}/32^{\circ}\text{F}$	$10^{\circ}\text{C}/50^{\circ}\text{F}$	$20^{\circ}\text{C}/68^{\circ}\text{F}$	
Dry to touch, approx.		3 days	36 hours	16 hours	8 hours	6 hours
Resist condensing humidity/ light showers after*:		7 days	3 days	32 days	16 hours	12 hours
Fully cured, 70% RH		2 months	32 days	14 days	7 days	5 days
Recoating interval, Recoating 5521 with 5521	Min	6 days	3 days	32 hours	16 hours	12 hours
	Max	None	None	None	None	None

*Faster drying and curing may be obtained by using an "accelerator" – consult BAJAK for further advice.

A completely clean surface is mandatory to ensure intercoat adhesion, especially at long recoating intervals. Any dirt, oil, and grease has to be removed, e.g. with suitable detergent. Salts to be removed by fresh water hosing. To check an adequate quality of the surface cleaning a test patch is recommended before actual recoating.

Note: CURING AGENT 95370 is sensitive to moisture. Store in dry place and keep the can tightly closed until use. Open curing agent cans with caution as overpressure might exist. Even small traces of water in the mixed paint will reduce the pot-life and result in film defects.

Safety: **BAJATHANE HI-BUILD 5521B is for professional use only.** 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 SEALER 05970

SURFACE PREPARATION:	<p>All possible slip agent, oil, grease and other contaminants must be removed by eg abrasive blasting, volatilizing by flame cleaning or treatment with suitable detergent. Last mentioned in the following way: Saturation of the surface with fresh water. Washing with detergent followed by fresh water hosing.</p> <p>Depending on construction and purpose, abrasive blast, high pressure water jet or treat the concrete with power tools to obtain a rough and firm surface free of scum layer and other contamination. Remove dust and loose material. If mechanical treatment is impossible, the surface may be treated with acid etching. For this purpose and approx. 5% w/w nitric or phosphoric acid solution is recommended. Note: Strong acids, take necessary precautions, make sure that safety regulations are obeyed prior to etching the concrete should be saturated with fresh water to prevent acid corrosion of the reinforcement bars. Leave the acid to act for 3-4 minutes and hose down the surface with fresh water – preferably first a 5% w/w sodium hydroxide solution – and scrub carefully. After that the surface must dry homogeneously and appear as an even, rough surface free of a loose outer layer. The surface must have a PH reaction of between 6.5 – 8.0. If any of these conditions are not fulfilled, the process must be repeated. The surface must be dried with good ventilation for at least 2 days (65% relative humidity and 20°C/68°F). The pretreatment is controlled by scraping with a strong knife. The surface shall feel solid and hard, and the knife must only leave a clear scratch mark.</p>
APPLICATION CONDITIONS:	<p>The concrete must be fully cured, eg 28 days for normal Portland cement, and completely dry with a humidity content in the surface below 4%. The concrete must also be controlled for absence of capillary water action or for subsoil water.</p> <p>Use only where application and curing can proceed at temperatures above 10°C/50°F. Apply only on a dry surface, free of dust, grease, oil and other contamination – as described above. In confined spaces provide adequate ventilation during application and drying.</p>
SUBSEQUENT: COAT:	According to specification.
REMARKS: Film thicknesses/ consumption:	<p>BAJAPOX SEALER 05970 is used for saturation of the absorbent concrete surface. Application should be initiated by assessing the degree of dilution in order to obtain a correct results, ie up to approx 50%. The actual amount of thinner required will depend on temperatures, the surface and type of the concrete and the actual application technique.</p> <p>Furthermore, a practical theoretical spreading rate can not be calculated. For practical purposes, approx. 14 m²/litre (570 sq.ft./US gallon) is indicated depending on the surface roughness, porosity of the concrete, and the application method.</p>
Appearance:	In any case a glossy surface must not appear and such a surplus of BAJAPOX SEALER 05970 must be removed by sanding before painting takes place.
Note:	BAJAPOX SEALER 05970 is for professional use only.
Safety:	<p>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.</p>
Issued:	December 2013



BAJAK'S HI-VEE LACQUER 06520

- Description:** BAJAK'S HI-VEE LACQUER 06520 is a non-yellowing, clear varnish based on acrylic resin dissolved in white spirit. Physically drying. The inclusion of a UV absorber serves to protect the preceding paint film against ultraviolet radiation. Further benefits are water and dirt repellent properties.
- Recommended use:** For protection of BAJAK'S HI-VEE 56540, especially in outdoor exposure, to maintain the high visibility (HI-VEE) of the fluorescent effect. Not recommended for surfaces subject to excessive wear.
- Availability:** Part of BAJAK Assortment. Local availability subject to confirmation.

PHYSICAL CONSTANTS:

Colours /Shade nos.:	Transparent/00000
Finish:	Glossy
Volume solids, %:	27 ± 1
Theoretical spreading rate:	10.8 m ² /litre - 25 micron 433 sq.ft./US gallon - 1 mil
Flash point:	32°C/90°F
Specific gravity:	0.9 kg/litre - 7.7 lbs/US gallon
Dry to touch:	1-2 hours at 20°C/68°F
V.O.C.:	580 g/litre - 4.8 lbs/US gallon

The physical constants stated are nominal data according to the BAJAK Group's approved formulas. They are subject to normal manufacturing tolerances and where stated, being standard deviation according to ISO 3534-1.

APPLICATION DETAILS:

- Application method:** Best results are obtained with a flat varnish brush. Spray application is possible with most types of spray equipment after thinning with THINNER 08230, but this application method is mainly subject to specific local conditions, so no general guidelines can be given.
- Cleaning of tools:** THINNER 08230
- Indicated film thickness,dry:** 25 micron/1 mil
Indicated film thickness,wet: 100 micron/4 mils
Recoat interval, min: 3 hours (20°C/68°F)
Recoat interval, max: none (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.

BAJAK'S HI-VEE LACQUER 06520

APPLICATION CONDITIONS: As dictated by normal good painting practice.
In confined spaces provide adequate ventilation during application and drying.

PRECEDING COAT: BAJAK'S HI-VEE 56540.

SUBSEQUENT COAT: None.

REMARKS: No maximum recoating interval, but after prolonged exposure to polluted atmosphere, remove accumulated contamination by (high pressure) fresh water cleaning and allow to dry.

Note: **BAJAK'S HI-VEE LACQUER 06520 is for professional use only.**

ISSUED: May 2010
BAJAK PAINT COMPANY

Product Data



BAJAK'S ANTIFOULING 7199B

TIN-FREE

Description: BAJAK'S ANTIFOULING 7199B is a tin-free, self-polishing antifouling, which has a high content of cuprous oxide and organic bioactive material.

Recommended use: As antifouling to be used when paints containing tin are not suitable. As an antifouling for maintenance of bottom on vessels operating in global trade and with short idle periods.

PHYSICAL CONSTANTS:

Colours :	Light red - Red
Finish:	Flat
Volume solids, %:	58 ± 1
Theoretical spreading rate:	5.8 m ² /litre - 100 micron 233 sq.ft./US gallon - 4 mils
Flash point:	23°C/73°F
Specific gravity:	1.8 kg/litre - 15.0 lbs/US gallon
Dry to touch:	4-5 hours at 20°C/68°F
V.O.C.:	375 g/litre - 3.1 lbs/US gallon

APPLICATION DETAILS:

Application method:	Airless spray (see REMARKS overleaf)	Brush/Roller (see REMARKS overleaf)
Thinner (max. vol.):	08080 (5%)	08080 (5%)
Nozzle orifice:	.023"-.027"	
Nozzle pressure:	250 bar/3600 psi (Airless spray data are indicative and subject to adjustment)	
Cleaning of tools:	BAJAK'S THINNER 08080	
Indicated film thickness, dry:	100 micron/4 mils (see REMARKS overleaf)	
Indicated film thickness, wet:	175 micron/7 mils	
Recoat interval, min:	8 hours (20°C/68°F)	
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. 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.

BAJAK'S ANTIFOULING 7199B

SURFACE PREPARATION:	<p>Existing organotin copolymer based selfpolishing antifouling: Remove possible oil and grease etc. with suitable detergent, followed by careful high pressure fresh water cleaning. Ensure that any possible leached surface layer is removed effectively. Allow the surface to dry before recoating. Sealer: Whether to use a sealer coat or not depends on the type and condition of the existing antifouling.</p>
APPLICATION CONDITIONS:	<p>The surface must be completely clean and dry at the time of application and its temperature must be above the dew point to avoid condensation. In confined spaces such as sea chests and stagnant air under large flat bottoms provide adequate ventilation during application and drying.</p>
PRECEDING COAT:	BAJATEX HI-BUILD 46330 or according to specification.
SUBSEQUENT COAT:	None.
REMARKS:	<p>This product contains heavy particles. Stir well before use. By providing a constantly active surface during its lifetime, this antifouling is gradually sacrificed in the process.</p>
Colour:	<p>The colour of the system changes in accordance with the colours of the coats applied. The initial colour may vary within the same shade. Most pronounced in shade Light red. The final colour will appear after exposure to saltwater. This has no influence on the antifouling performance. Light red turns whitish in direct contact with seawater. Indicated film thickness will vary according to specification. This will alter spreading rate and may influence drying time. In case of multi-coat application, drying time and minimum recoat interval will be influenced by the number of coats and by the thickness of each coat applied - reference is made to the corresponding painting specification. Range and control of dry film thickness: 80 micron/3.2 mils to 125 micron/5 mils. Keep thinning to a minimum to ensure that correct film thickness is obtained. The proper way of governing the film thickness is to sub-divide the areas to be painted and calculate the amount of paint to be applied on each sub-divided area. The exact amount of paint calculated must be applied evenly on the area. For further information, please consult the corresponding painting specification. Recommended number of coats: As per specification depending on existing hull condition, trading pattern, and intended service life. No maximum recoat interval, but after prolonged exposure to polluted atmosphere, remove accumulated contamination by high pressure fresh water cleaning and allow to dry before applying next coat. If roller/brush application exceptionally is utilized (e.g. to line cut) more coats are necessary to achieve the recommended film thickness. Undocking: <u>Minimum</u> undocking time depends on number of coats applied, film thickness, and the prevailing temperature. For further information, please consult the corresponding painting specification. <u>Maximum</u> undocking time depends on the atmospheric conditions (UV-radiation, temperature, degree of air pollution, etc.). It is important to carry out a thorough high pressure fresh water cleaning after prolonged exposure. Exposure to the atmosphere up to 6 months normally presents no problem when such cleaning is carried out.</p>
Note:	BAJAK'S ANTIFOULING 7199B is for professional use only.



Product Data

BAJANOL 10220

Description: BAJANOL 10220 is a physically drying, high-build, bituminous coating.

Recommended use: For inexpensive short to medium-term anticorrosive protection of interior and exterior steelwork not exposed to direct sunlight. Not resistant to continuous mechanical stress.

PHYSICAL CONSTANTS:

Colours : Black
 Finish: Flat
 Volume solids, %: 53 ± 1
 Theoretical spreading rate: 3.0 m²/litre - 175 micron
 121 sq.ft./US gallon - 7 mils
 Flash point: 38°C/100°F
 Specific gravity: 1.1 kg/litre - 9.2 lbs/US gallon
 Surface dry: 10 (approx.) hours at 20°C/68°F (ISO 1517)
 Dry to touch: 16 (approx.) hours at 20°C/68°F
 V.O.C.: 375 g/litre - 3.1 lbs/US gallon

APPLICATION DETAILS:

Application method:	Airless spray	Air spray	Brush
Thinner (max.vol.):	08080 (2%)	08080 (15%)	08080 (5%)
Nozzle orifice:	.021"-.025"		
Nozzle pressure:	200 bar/2900 psi (Airless spray data are indicative and subject to adjustment)		
Cleaning of tools:	THINNER 08080		
Indicated film thickness, dry:	175 micron/7 mils (See REMARKS overleaf)		
Indicated film thickness, wet:	325 micron/13 mils		
Recoat interval, min:	When dry		
Recoat interval, max:	None		

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.

BAJANOL 10220

SURFACE PREPARATION: **New steel:** Abrasive blasting to minimum Sa 2 or mechanical cleaning to St 3. For temporary protection, if required, use a 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 BAJANOL 10220.

Maintenance: Remove oil and grease, etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. Remove all rust and loose material by abrasive blasting, power tool cleaning or water jetting. Dust off residues and allow the surface to dry. Touch up to full film thickness.

APPLICATION CONDITIONS: As dictated by normal good painting practice. In confined spaces provide adequate ventilation during application and drying.

PRECEDING COAT: None or according to specification.

SUBSEQUENT COAT: None.

REMARKS: May be specified in another film thickness than indicated depending on purpose and area of use. This will alter spreading rate and may influence the amount of thinning necessary, drying time and recoating interval. Normal range is 125-200 micron/5-8 mils.

Note: **BAJANOL 10220 is for professional use only.**



باجاک (سهامی خاص)

BAJAPOX ZINC 11121

CURING AGENT 63020

Description: BAJAPOX ZINC 11121 is a two-component polyamide cured zinc-rich epoxy primer. It cures to a hard wearing and highly weather-resistant coating. Offers cathodic protection of local mechanical damage. The product meets the SSPC paint No. 20, type II, level I requirements.

Recommended use: For on-line application on containers. Can be used as a zinc-rich epoxy primer for other purposes according to separate painting specification.

Service temperatures: Maximum, dry: 160°C/320°F, however depending on the subsequent coat.

PHYSICAL CONSTANTS:

Colours/Shade nos:	Red-grey
Finish:	Flat
Volume solids, %:	57 ± 1
Theoretical spreading rate:	12.5 m ² /litre - 40 micron 501 sq.ft./US gallon - 1.6 mils
Flash point:	30°C/86°F
Specific gravity:	3 kg/litre – 21.7 lbs/US gallon
Surface dry:	30 minutes at 20°C/68°F (ISO 1517)
Dry to touch:	2 (app.) hours at 20°C/68°F
Fully cured:	7 days at 20°C/68°F
V.O.C.:	455 g/litre - 3.8 lbs/US gallon
Zinc content in dry film (wt%):	Min. 90

APPLICATION DETAILS:

Mixing ratio for 11121:	Base 11121 : Curing agent 63020 5 : 1 by volume
Application method:	Airless spray Air spray Brush
Thinner (max.vol.):	8020 (30%) 8020 (50%) 8020 (5%)
Pot life:	8 hours (20°C/68°F) (airless spray) 8 hours (20°C/68°F)(brush)
Nozzle orifice:	.017"-.021"
Nozzle pressure:	150 bar/2200 psi (Airless spray data are indicative and subject to adjustment)
Cleaning of tools:	BAJAK'S THINNER 8020
Indicated film thickness, dry:	40 micron/1.6 mils (See REMARKS overleaf)
Indicated film thickness, wet:	80 micron/3 mils
Recoat interval, min:	As per separate APPLICATION INSTRUCTIONS
Recoat interval, max:	As per separate APPLICATION INSTRUCTIONS

Issued: Oct. 2007

2. BAJAPOX ZINC 11121

SURFACE contaminants by PREPARATION:	Remove oil and grease, etc. with suitable detergent. Remove salt and other (high pressure) fresh water cleaning. Abrasive blasting to Sa2½ with a sharp-edged surface profile corresponding to Rugotest No. 3, BN9a, Keane-Tator Comparator, 2.0 G/S or ISO Comparator, Medium (G).
APPLICATION CONDITIONS:	Use only where application and curing can proceed at temperatures above 10°C/50°F 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/59°F or above. 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.
SUBSEQUENT COAT:	According to specification.
REMARKS:	Note: If used as anticorrosive protection under insulation of high temperature equipment it is very important that NO moisture can penetrate during slow-down periods. This to avoid risk of "wet corrosion" when the temperature rises.
Film thicknesses: purpose and area of use. drying time, and Recoating: separate APPLICATION	May be specified in another film thickness than indicated depending on This will alter spreading rate and may influence amount of thinning necessary, recoating interval. Normal range is 15-50 micron/0.6-2.0 mils. Recoating intervals related to later conditions of exposure: Consult INSTRUCTIONS. If the maximum recoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion. Before recoating after exposure in contaminated environment, clean the surface thoroughly by (high pressure) fresh water hosing and allow to dry. In addition, scrubbing with a stiff brush may be necessary to remove zinc corrosion products (white rust).
Note:	BAJAPOX ZINC 11121 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. Harmful or fatal if swallowed; immediately seek medical assistance if swallowed. Avoid inhalation of possible solvent vapours or paint mist, as well as paint contact with skin and eyes. Apply only in well ventilated areas and ensure that adequate forced ventilation exists when applying paint in con-fined spaces or when the air is stagnant. Always take precautions against the risks of fire and explosions.
Issued:	Oct. 2007



باجاک (سهامی خاص)

BAJAPOX ZINC 11125

CURING AGENT 95740

Description: BAJAPOX ZINC 11125 is a two-component polyamide cured zinc-rich epoxy primer with MIO pigment. It cures to a hard wearing and highly weather-resistant coating. Offers cathodic protection of local mechanical damage.

Recommended use: For application on steel structure, pipe, Tank, container. Can be used as a zinc-rich epoxy primer for other purposes according to separate painting specification.

Approval: By research institute of petroleum (RIPI) for atmosphere zone.

Service temperatures: Maximum, dry: 160°C/320°F, however depending on the subsequent coat.

PHYSICAL CONSTANTS:

Colours /Shade nos:	Red-grey -7017
Finish:	Flat
Volume solids, %:	53 ± 1
Theoretical spreading rate:	13.25 m ² /litre - 40 micron
Flash point:	30°C/86°F
Specific gravity:	2.03 Kg / Lit
Surface dry:	30 minutes at 20°C/68°F (ISO 1517)
Dry to touch:	2 hours at 20°C/68°F
Fully cured:	7 days at 20°C/68°F
V.O.C.:	455 g/litre - 3.8 lbs/US gallon

APPLICATION DETAILS:

Mixing ratio for 11125:	Base 11125: Curing agent 95740 9:1 by Weight
Application method:	Airless spray Air spray Brush
Thinner (max.vol.):	08450 (30%) (50%) 8020 (5%)
Pot life:	8 hours (20°C/68°F) (airless spray) 8 hours (20°C/68°F) (brush)
Nozzle orifice:	.017"- .021"
Nozzle pressure:	150 bar/2200 psi (Airless spray data are indicative and subject to adjustment)
Cleaning of tools:	BAJAK'S THINNER 8020
Indicated film thickness, dry:	40 micron/1.6 mils (See REMARKS overleaf)
Indicated film thickness, wet:	80 micron/3 mils
Recoat interval, min:	3 hours / 20°C with Bajapox qualities
Recoat interval, max:	30 days / 20°C with Bajapox qualities

Issued:

Oct. 2019

2. BAJAPOX ZINC 11125

SURFACE PREPARATION:	Remove oil and grease, etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. Abrasive blasting to Sa2½ with a sharp-edged surface profile corresponding to Rugotest No. 3, BN9a, Keane-Tator Comparator, 2.0 G/S or ISO Comparator, Medium (G).
APPLICATION CONDITIONS:	Use only where application and curing can proceed at temperatures above 10°C/50°F 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/59°F or above. 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.
SUBSEQUENT COAT:	According to specification.
REMARKS:	Note: If used as anticorrosive protection under insulation of high temperature Equipment it is very important that NO moisture can penetrate during slow-Down periods. This to avoid risk of "wet corrosion" when the temperature rises
Film thicknesses:	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 15-50 micron/0.6-2.0 Mills.
Recoating:	Recoating intervals related to later conditions of exposure: Consult separate APPLICATION INSTRUCTIONS. If the maximum recoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion. Before recoating after exposure in contaminated environment, clean the surface thoroughly by (high pressure) fresh water hosing and allow to dry. In addition, scrubbing with a stiff brush may be necessary to remove zinc corrosion products (white rust).
Note:	BAJAPOX ZINC 11125 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. Harmful or fatal if swallowed; immediately seek medical assistance if swallowed. Avoid inhalation of possible solvent vapours or paint mist, as well as paint contact with skin and eyes. 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. Always take precautions against the risks of fire and explosions.
Issued:	Oct. 2019

**BAJAK'S SHOPPRIMER ZS 11161**

BAJAK'S LIQUID 61061

Description:	BAJAK'S SHOPPRIMER ZS 11161 is a two-component, medium-zinc, solvent-borne ethyl silicate shopprimer, designed for automatic and manual spray application. Hardwearing and highly weather-resistant. Offers cathodic protection of local mechanical damage.
Recommended use:	For relatively long time protection of blast cleaned steel plates and other structural steel during the storage, fabrication, and construction periods.
Certificate/Approvals:	Approved as a welding primer by Germanischer Lloyd.

PHYSICAL CONSTANTS:

Mixed product:	11161
Colours/Shade no:	Reddish grey/(Other shades according to assortment list)
Finish:	Flat
Volume Solids, %:	30 ± 1
Theoretical spreading rate:	See REMARKS overleaf
Flash point:	4°C/39°F
Specific gravity:	1.6 kg/litre – 13 lbs/US gallon
Dry to touch:	3-4 minutes at 20°C/68°F
Fully cured:	4 days at 20°C/68°F (75% RH)
V.O.C.:	645 g/litre - 5.4 lbs/US gallon
Shelf life:	6 months (25°C/77°F) from time of production. Shelf life is dependent on storage temperature. Shelf life is reduced at storage temperatures above 25°C/77°F. Do not store above 40°C/104°F or below 5°C/40°F. Shelf life is exceeded if the liquid is gelled or if the mixed product forms gels before application.

APPLICATION DETAILS:

Mixing ratio for 15722:	Base 11161 : Liquid 61061 2 : 3 by volume		
Application method:	Airless spray	Air spray	Brush (touch up)
Thinner (max.vol.):	08061 or 08060 (30%) (See REMARKS overleaf)	08060 (30%)	08061 or 08060 (15%)
Pot life:	24 hours (20°C/68°F) (Closed container, constant stirring) (See REMARKS overleaf)		
Nozzle orifice:	.019" - .023"		
Nozzle pressure:	80 bar/1200 psi (Airless spray data are indicative and subject to adjustment)		
Cleaning of tools:	THINNER 8061 or 08060		
Indicative dft:	15 micron/0.6 mil (See REMARKS overleaf)		
Indicative wft:	Not relevant		
Recoat interval, min:	When fully cured		
Recoat interval, max:	None (See REMARKS overleaf)		

2. BAJAK'S SHOPPRIMER ZS 11161

SURFACE PREPARATION:	Remove oil and grease with suitable detergent. Abrasive blasting to minimum Sa 2½ with a surface profile equivalent to Rugotest No. 3, min. N9a, Keane-Tator Comparator, 2 mils segments, or ISO Comparator Medium (G,S). For special purposes grit blasting is necessary.
APPLICATION CONDITIONS:	The surface must be completely clean and dry with a temperature above the dew point to avoid condensation. Minimum steel temperature 0°C/32°F, max. approximately 55°C/131°F: Curing: Minimum temperature for curing 0°C/32°F, minimum 50%, preferably above 65% relative humidity. Consult separate APPLICATION INSTRUCTIONS.
SUBSEQUENT COAT:	As per specification.
REMARKS:	
Film thicknesses and theoretical spreading rate:	On steel abrasive blasted to a profile Ra = 12½ micron (½ mil), equivalent to Rugotest No. 3, N10a-b, or Keane-Tator Comparator, 3 mils segments, the indicated 15 micron/0.6 mil film thickness corresponds to approx. 25 micron/1 mil measured on a smooth test panel (see special instructions for this procedure). The corresponding "theoretical" spreading rate will be 12.4 m²/litre (497 sq.ft./US gallon). On steel abrasive blasted to a profile Ra = 6.3 micron (1/4 mil), equivalent to Rugotest No. 3, N9a, or Keane-Tator Comparator, 2 mils segments, the indicated 15 micron/0.6 mil film thickness corresponds to approximately 20 micron/0.8 mil measured on a smooth test panel (see special instructions for this procedure). The corresponding "theoretical" spreading rate will be 15.5 m²/litre (622 sq.ft./US gallon). The shopprimer should be applied in a uniform film thickness. Avoid dry spray and exaggerated film thicknesses. May be specified in dry film thicknesses down to approximately 10 micron/0.4 mil.
Thinning:	Selection of proper thinner is related to application conditions.
Curing:	Curing time is prolonged at relative humidity below 75%.
Recoating:	No maximum recoating interval for adhesion, but dictated by gradual breakdown and damage during exposure and fabrication. Regarding treatment before recoating, please consult the APPLICATION INSTRUCTIONS.
Shelf life:	If shelf life is exceeded, it is usually possible to use the zinc paste (BASE), if any settling can be remixed. The LIQUID may be used provided it shows no signs of turbidity, but pot life will be very much shortened, see below. In any case, possible surpassing of storage time will be of 1-2 months maximum (20°C/68°F) for the LIQUID.
Pot life:	The pot life may be gradually reduced to 8 hours (20°C/68°F) as the liquid approaches the end of its shelf life, assuming that it is stored under favorable conditions.
Note:	BAJAK'S SHOPPRIMER ZS 11161 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.

Issued:

October 2005 – 11161

**BAJAK'S SHOPPRIMER ZS 11162**

BAJAK'S LIQUID 61062

Description: BAJAK'S SHOPPRIMER ZS 11162 is a two-component, low-zinc, solvent-borne ethyl silicate shopprimer, designed for automatic and manual spray application. Especially suited, where welding (MIG/MAG) and gas-cutting properties are of importance.

Recommended use: For short to medium-term protection of blast cleaned steel plates and other structural steel during the storage, fabrication, and construction periods.

Certificate/Approvals: Approved as a welding primer by Germanischer Lloyd.

PHYSICAL CONSTANTS:

Mixed product: 11162
 Colours/Shade no: Reddish grey
 Finish: Flat
 Volume Solids, %: 25
 Theoretical spreading rate: See REMARKS overleaf
 Flash point: 5°C/41°F
 Specific gravity: 1.3 kg/litre – 10.8 lbs/US gallon
 Dry to touch: 3-4 minutes at 20°C/68°F
 Fully cured: 4 days at 20°C/68°F (75% RH)
 V.O.C.: 620 g/litre - 5.15 lbs/US gallon
 (According to EPA Fed Ref Method 24)

Shelf life: 6 months (25°C/77°F) from time of production.
 Shelf life is dependent on storage temperature. Shelf life is reduced at storage temperatures above 25°C/77°F. Do not store above 40°C/104°F or below 5°C/40°F.
 Shelf life is exceeded if the liquid is gelled or if the mixed product forms gels before application.

APPLICATION DETAILS:

Mixing ratio for 11162: Base 11162 : Liquid 61062
 2 : 3 by volume

Application method: Airless spray Air spray Brush (touch up)

Thinner (max.vol.): 08061 or 08060 (30%) 08060 (30%) 08061 or 08060 (15%)
 (See REMARKS overleaf)

Pot life: 8 hours (20°C/68°F) (Closed container, constant stirring)

Nozzle orifice: .019" - .023"

Nozzle pressure: 80 bar/1200 psi
 (Airless spray data are indicative and subject to adjustment)

Cleaning of tools: THINNER 08061 or 08060

Indicative dft: 15 micron/0.6 mil (See REMARKS overleaf)

Indicative wft: Not relevant

Recoat interval, min: When fully cured

Recoat interval, max: None (See REMARKS overleaf)

2. BAJAK'S SHOPPRIMER ZS 11162

SURFACE PREPARATION:	Remove oil and grease with suitable detergent. Abrasive blasting to minimum Sa 2½ with a surface profile equivalent to Rugotest No. 3, min. N9a, Keane-Tator Comparator, 2 mils segments, or ISO Comparator Medium (G,S). For special purposes grit blasting is necessary.
APPLICATION CONDITIONS:	The surface must be completely clean and dry with a temperature above the dew point to avoid condensation. Minimum steel temperature 0°C/32°F, max. approximately 55°C/131°F: Curing: Minimum temperature for curing 0°C/32°F, minimum 50%, preferably above 65% relative humidity. Consult separate APPLICATION INSTRUCTIONS.
SUBSEQUENT COAT:	As per specification.
Film thicknesses and theoretical spreading rate:	On steel abrasive blasted to a profile Ra = 12½ micron (½ mil), equivalent to Rugotest No. 3, N10a-b, or Keane-Tator Comparator, 3 mils segments, the indicated 15 micron/0.6 mil film thickness corresponds to approx. 25 micron/1 mil measured on a smooth test panel (see special instructions for this procedure). The corresponding "theoretical" spreading rate will be 10.0 m²/litre (401 sq.ft./US gallon) (reddish grey). On steel abrasive blasted to a profile Ra = 6.3 micron (1/4 mil), equivalent to Rugotest No. 3, N9a, or Keane-Tator Comparator, 2 mils segments, the indicated 15 micron/0.6 mil film thickness corresponds to approx. 20 micron/0.8 mil measured on a smooth test panel (see special instructions for this procedure). The corresponding "theoretical" spreading rate will be 12.5 m²/litre (501 sq.ft./US gallon) (reddish grey). The shopprimer should be applied in a uniform film thickness. Avoid dry spray and exaggerated film thicknesses. Depending on requested protective lifetime the dry film thickness may be varied. Minimum is approximately 10 micron/0.4 mil, maximum 20 micron/0.8 mil as specified on a blasted surface.
Thinning:	Selection of proper thinner is related to application conditions.
Curing:	Curing time is prolonged at relative humidity below 75%.
Recoating:	No maximum recoating interval for adhesion, but dictated by gradual breakdown and damage during exposure and fabrication. Regarding treatment before recoating, please consult the APPLICATION INSTRUCTIONS.
Shelf life:	If shelf life is exceeded, it is usually possible to use the zinc paste (BASE), if any settling can be remixed. The LIQUID may be used provided it shows no signs of turbidity, but pot life will be reduced. In any case, possible surpassing of storage time will be of 1-2 months maximum (20°C/68°F) for the LIQUID.
Note:	BAJAK'S SHOPPRIMER ZS 11162 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. Harmful or fatal if swallowed; immediately seek medical assistance if swallowed. Avoid inhalation of possible solvent vapours or paint mist, as well as paint contact with skin and eyes. 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. Always take precautions against the risks of fire and explosions.
Issued:	October 2005 – 11162

**BAJAPOX 11220**

CURING AGENT 61022

Description: BAJAPOX 11220 is a two-component polyamide-cured epoxy primer coat containing zinc phosphate as corrosion inhibiting pigment. It cures to a strong and rust-preventing coating.

Recommended use: As a primer coat in steel structure and tank coating systems. May be used as a general purpose epoxy primer according to painting specification

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

PHYSICAL CONSTANTS:

Mixed product: 11220
 Colours/Shade no: Grey (7278)
 Finish: Flat
 Volume Solids, %: 58±1
 Theoretical spreading rate: 7.7m²/litre – 75 micron
 Flash point: 26°C/79°F
 Specific gravity: 1.45 kg/litre
 Dry to touch: 2-3 hours at 20°C/68°F
 Fully cured: 7 days at 20°C/68°F

APPLICATION DETAILS:

Mixing ratio for 11220: Base 11220 : Curing agent 61022
 6 : 1 by weight

Application method: Airless spray Air spray Brush
 Thinner (max.vol.): 08450 (5%) 08450 (15%) 08450 (5%)

Pot life: 8 hours (20°C/68°F) (airless spray)
 8 hours (20°C/68°F) (brush)

Nozzle orifice: 0.021"

Nozzle pressure: 175 bar/2500 psi
 (Airless spray data are indicative and subject to adjustment)

Cleaning of tools: BAJAK'S TOOL CLEANER 99610

Indicated dft: 75 micron/3 mils (See REMARKS overleaf)

Indicated wft: 130 micron/5.2 mils

Recoat interval: See REMARKS overleaf

2. BAJAPOX PRIMER 11220

SURFACE PREPARATION:	<p>New steel: Abrasive blasting to Sa 2½ for temporary protection, if required, use a 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 11220.</p> <p>Other metals and light alloys: Thorough degreasing and removal of any salty contamination. Abrasive sweeping to create a suitable dense anchor profile.</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 St 3 (minor areas) or by abrasive blasting to min. Sa2, preferably to Sa 2½.</p> <p>Improved surface preparation will improve the performance of BAJAPOX 11220. 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, wet abrasive blasting, alternatively dry abrasive blasting, high pressure fresh water hosing, drying, and finally, dry abrasive blasting again.</p>
APPLICATION CONDITIONS:	<p>Use only where application and curing can proceed at temperatures above 10°C/50°F. The temperature of the paint itself should be 15°C/59°F or above to secure proper application properties. In confined spaces provide adequate ventilation during application and drying. Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation.</p>
SUBSEQUENT COAT:	<p>BAJAPOX or BAJATHANE or according to specification.</p>
REMARKS:	
Weathering/Service temperatures:	<p>The natural tendency of epoxy coatings to chalk in outdoor exposure and to become more service sensitive to mechanical damage and chemical exposure at elevated temperatures is also reflected in this product.</p>
Film thickness:	<p>May be specified in another film thickness than indicated depending on purpose and area of use. This will alter spreading rate and will influence the amount of thinning necessary, drying time and recoating interval. Normal range dry is 50-75 micron/2-3 mils.</p>
Recoating:	<p>Recoating intervals:</p> <p>Minimum (Primarily only relevant for container coatings): 20 minutes, flash-off time for 40 micron/1.6 mils BAJAPOX 11220 when top coated with designed container coatings, epoxy, polyurethane, acrylic or CR types. The minimum recoating interval only applies in the case of forced ventilation, proper application and if the completed paint system is thoroughly dry before exposed to aggressive environments.</p> <p>Maximum: Recoating interval for non-immersion services is 24 hours for acrylic or CRs, 3 days for Pus and none for epoxies.</p> <p>In the case of long recoating intervals, a completely clean surface is mandatory to ensure intercoat adhesion. Any dirt, oil and grease 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.</p> <p>To check whether the quality of the surface cleaning is adequate, a test patch may be relevant.</p>
Note:	<p>BAJAPOX 11220 is for professional use only.</p>
Safety:	<p>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.</p>

**BAJAPOX 11222**

CURING AGENT 61022

Description: BAJAPOX 11222 is a two-component polyamide-cured epoxy primer and mid coat Containing zinc phosphate as corrosion inhibiting pigment. It cures to a strong and rust-preventing coating.

Recommended use: As a primer or intermediate coat in container systems as well as concrete. May be used as a general purpose epoxy primer according to painting specification

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

PHYSICAL CONSTANTS:

Mixed product: 11222
 Colours/Shade no: Grey (7278)
 Finish: Flat
 Volume Solids, %: 51±1
 Theoretical spreading rate: 5.1 m²/litre – 100 micron
 Flash point: 26°C/79°F
 Specific gravity: 1.45 kg/litre
 Dry to touch: 2-3 hours at 20°C/68°F
 Fully cured: 7 days at 20°C/68°F

APPLICATION DETAILS:

Mixing ratio for 11222: Base 11222 : Curing agent 61022
 7 : 1 by weight

Application method: Airless spray Air spray Brush
 Thinner (max.vol.): 08450 (5%) 08450 (15%) 08450 (5%)
 Pot life: 8 hours (20°C/68°F) (airless spray)
 8 hours (20°C/68°F) (brush)

Nozzle orifice: 0.021"
 Nozzle pressure: 175 bar/2500 psi
 (Airless spray data are indicative and subject to adjustment)

Cleaning of tools: BAJAK'S TOOL CLEANER 99610
 Indicated dft: 100 micron/4 mils (See REMARKS overleaf)
 Indicated wft: 200 micron/8 mils
 Recoat interval: See REMARKS overleaf

2. BAJAPOX PRIMER 11222

SURFACE PREPARATION:	<p>New steel: Abrasive blasting to Sa 2½ for temporary protection, if required, use a 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 11222.</p> <p>Other metals and light alloys: Thorough degreasing and removal of any salty contamination. Abrasive sweeping to create a suitable dense anchor profile.</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 St 3 (minor areas) or by abrasive blasting to min. Sa2, preferably to Sa 2½.</p> <p>Improved surface preparation will improve the performance of BAJAPOX 11222. 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, wet abrasive blasting, alternatively dry abrasive blasting, high pressure fresh water hosing, drying, and finally, dry abrasive blasting again.</p>
APPLICATION CONDITIONS:	<p>Use only where application and curing can proceed at temperatures above 10°C/50°F. The temperature of the paint itself should be 15°C/59°F or above to secure proper application properties. In confined spaces provide adequate ventilation during application and drying. Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation.</p>
SUBSEQUENT COAT:	<p>BAJAPOX or BAJATHANE or according to specification.</p>
REMARKS:	
Weathering/Service temperatures:	<p>The natural tendency of epoxy coatings to chalk in outdoor exposure and to become more service sensitive to mechanical damage and chemical exposure at elevated temperatures is also reflected in this product.</p>
Film thickness:	<p>May be specified in another film thickness than indicated depending on purpose and area of use. This will alter spreading rate and will influence the amount of thinning necessary, drying time and recoating interval. Normal range dry is 25-75 micron/1-3 mils.</p>
Recoating:	<p>Recoating intervals:</p> <p>Minimum (Primarily only relevant for container coatings): 20 minutes, flash-off time for 40 micron/1.6 mils BAJAPOX 11222 when top coated with designed container coatings, epoxy, polyurethane, acrylic or CR types. The minimum recoating interval only applies in the case of forced ventilation, proper application and if the completed paint system is thoroughly dry before exposed to aggressive environments.</p> <p>Maximum: Recoating interval for non-immersion services is 24 hours for acrylic or CRs, 3 days for Pus and none for epoxies.</p> <p>In the case of long recoating intervals, a completely clean surface is mandatory to ensure intercoat adhesion. Any dirt, oil and grease 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.</p> <p>To check whether the quality of the surface cleaning is adequate, a test patch may be relevant.</p>
Note:	<p>BAJAPOX 11222 is for professional use only.</p>
Safety:	<p>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.</p>

2. BAJAK'S EPOXY PRIMER 11320

APPLICATION AND
CURING CONDITIONS:

New steel: Abrasive blasting to minimum Sa 2½ is recommended. The surface must be completely clean and dry at the time of application. And its temperature must be above the dew point to avoid condensation
At the freezing point and below, be ware of the risk of ice on the surface which will hinder the adhesion. High humidity and/or condensation during application and the following 16 hours (20C/68 F) may adversely affect the film formation.
In confined spaces provide adequate ventilation during application and drying.

PRECEDING
COAT:

None, or as per specification.

SUBSEQUENT
COAT:

BAJAK'S EPOXY INTERMEDIATE 42522, or as per specification.

REMARKS:

Film thicknesses:

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 is 70 microns/ 2.8 mils.

Thinning:

The type and amount of thinner depend on application conditions, application method, temperature, ventilation, and substrate. Thinner 08020 is recommended in general.

Physical data versus
temperatures:

Recoating And drying/curing Time:					
Surface temperature		5°C /41°F	10°C /50°F	20°C /68°F	30°C /86°F
Dry to touch approx.		12 hours	8 hours	4 hours	3 hours
Resist condensing humidity/ light showers after		4 days	2 days	24 hours	12 hours
Fully cured		20 days	14 days	7 days	5 days
Recoating interval, Recoating with 52520,53550	Min	24 hours	16 hours	8 hours	4 hours
	Max	15 days	12 days	5 days	3 days

A completely clean surface is mandatory to ensure intercoat adhesion, especially at long recoating intervals. Any dirt,oil,and grease have to be removed, e.g. with suitable detergent.

Salts to be removed by fresh water hosing. To check an adequate quality of the surface cleaning a test patch is recommended before actual recoating.

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 and national safety regulations. Harmful or fatal if swallowed; immediately seek medical assistance swallowed. Avoid inhalations of possible solvent vapors or paint mist, as well as paint contact with skin and eyes. Apply only on well-ventilated areas and ensure that adequate forced ventilation exists when applying paint in confined spaces or when the air is stagnant. Always take precautions against the risks of fire and explosions.

2. BAJAPOX PRIMER 11321

APPLICATION AND
CURING CONDITIONS:

New steel: Abrasive blasting to minimum Sa 2½ is recommended. The surface must be completely clean and dry at the time of application. And its temperature must be above the dew point to avoid condensation
At the freezing point and below, be ware of the risk of ice on the surface which will hinder the adhesion. High humidity and/or condensation during application and the following 16 hours (20°C/68 °F) may adversely affect the film formation.
In confined spaces provide adequate ventilation during application and drying.

PRECEDING
COAT:

None, or as per specification.

SUBSEQUENT
COAT:

BAJAK'S EPOXY INTERMEDIATE 42521, or as per specification.

REMARKS:

Film thicknesses:

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 is 70 microns/ 2.8 mils.

Thinning:

The type and amount of thinner depend on application conditions, application method, temperature, ventilation, and substrate. Thinner 08450 is recommended in general.

Physical data versus
temperatures:

Recoating And drying/curing Time:					
Surface temperature		5°C /41°F	10°C /50°F	20°C /68°F	30°C /86°F
Dry to touch approx.		12 hours	8 hours	4 hours	3 hours
Resist condensing humidity/ light showers after		4 days	2 days	24 hours	12 hours
Fully cured		20 days	14 days	7 days	5 days
Recoating interval, Recoating with 52520,53550	Min	24 hours	16 hours	8 hours	4 hours
	Max	15 days	12 days	5 days	3 days

A completely clean surface is mandatory to ensure intercoat adhesion, especially at long recoating intervals. Any dirt,oil,and grease have to be removed, e.g. with suitable detergent.

Salts to be removed by fresh water hosing. To check an adequate quality of the surface cleaning a test patch is recommended before actual recoating.

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 and national safety regulations. Harmful or fatal if swallowed; immediately seek medical assistance swallowed. Avoid inhalations of possible solvent vapors or paint mist, as well as paint contact with skin and eyes. Apply only on well-ventilated areas and ensure that adequate forced ventilation exists when applying paint in confined spaces or when the air is stagnant. Always take precautions against the risks of fire and explosions.

2. BAJAPOX PRIMER 11321

APPLICATION AND
CURING CONDITIONS:

New steel: Abrasive blasting to minimum Sa 2½ is recommended. The surface must be completely clean and dry at the time of application. And its temperature must be above the dew point to avoid condensation
At the freezing point and below, be ware of the risk of ice on the surface which will hinder the adhesion. High humidity and/or condensation during application and the following 16 hours (20°C/68 °F) may adversely affect the film formation.
In confined spaces provide adequate ventilation during application and drying.

PRECEDING
COAT:

None, or as per specification.

SUBSEQUENT
COAT:

BAJAK'S EPOXY INTERMEDIATE 42521, or as per specification.

REMARKS:

Film thicknesses:

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 is 70 microns/ 2.8 mils.

Thinning:

The type and amount of thinner depend on application conditions, application method, temperature, ventilation, and substrate. Thinner 08450 is recommended in general.

Physical data versus
temperatures:

Recoating And drying/curing Time:					
Surface temperature		5°C /41°F	10°C /50°F	20°C /68°F	30°C /86°F
Dry to touch approx.		12 hours	8 hours	4 hours	3 hours
Resist condensing humidity/ light showers after		4 days	2 days	24 hours	12 hours
Fully cured		20 days	14 days	7 days	5 days
Recoating interval, Recoating with 52520,53550	Min	24 hours	16 hours	8 hours	4 hours
	Max	15 days	12 days	5 days	3 days

A completely clean surface is mandatory to ensure intercoat adhesion, especially at long recoating intervals. Any dirt,oil,and grease have to be removed, e.g. with suitable detergent.

Salts to be removed by fresh water hosing. To check an adequate quality of the surface cleaning a test patch is recommended before actual recoating.

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 and national safety regulations. Harmful or fatal if swallowed; immediately seek medical assistance swallowed. Avoid inhalations of possible solvent vapors or paint mist, as well as paint contact with skin and eyes. Apply only on well-ventilated areas and ensure that adequate forced ventilation exists when applying paint in confined spaces or when the air is stagnant. Always take precautions against the risks of fire and explosions.



باجاک (سهامی خاص)

BAJAK ALKYD PRIMER 11510

Description: BAJAK 11510 is a quick drying long oil alkyd primer which has good resistance to mild corrosive environments.

Recommended use:

1. As general purpose primer for Bajak alkyd systems on steel surfaces in moderately corrosive environments.
2. As a blast primer for temporary protection of steel blast cleaned on site.

Service temperature: Maximum, dry: 100°C/ 212°F.

PHYSICAL CONSTANTS:

Colors/Shade No: Reed , Green & Grey
Finish: Semi Flat
Volume Solid: 50-55%
Theoretical spreading rate: 10-11M² /Liter – 50 micron DFT.
Flash point: 35 °C/95° F
Specific gravity: 1.5-1.6 kg/liter
Surface dry: 0.5 hours at 20°C/68°F(ISO 1517)
Dry to touch: 2-4 hours at 20°C/68°F.
V.O.C.: 410 gr/liter
The physical constants are subject to normal manufacturing tolerances.

APPLICATION DETAILS:

Application method:	Airless spray	Air spray	Brush
Thinner (max. vol.)	8010 (5%)	8010 (15%)	8010 (5%)
Nozzle orifice:	0.018"		
Nozzle pressure:	150 bar / 2200 psi (Airless spray data are indicative and subject to adjustment)		
Cleaning of tools:	THINNER 8010		
Indicated film thickness, dry:	50 microns/2.mils		
Indicated film thickness, wet:	100 microns / 4 mils		
Recoat interval, min:	5 hours (20°C/ 68°F)		
Recoat interval, max:	See REMARKS overleaf		

Issued: Apr. 2007

2.BAJAK ALKYD PRIMER 11510

SURFACE REPATATION: **New Steel:** Abrasive blasting to minimum Sa2 is recommended. Alternatively power tool cleaning to St3.
Mintenance: Remove oil and grease, etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. Remove all rust and loose material by abrasive blasting or power tool cleaning. Dust off residues. Touch up to full film thickness.

APPLICATION CONDITIONS: As detected by normal good painting practice.
 In confined spaces provide adequate ventilation during application and drying.

PRECEDING COAT: None.

SUBSEQUENT COAT: BAJAK alkyd system according to specification.

REMARKS:
 Film thicknesses: 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 is 40 -60microns/ 1.6-2.4 mils.

Recoating:

	MINIMUM		MAXIMUM	
STEEL TEMPERATURE	20°C/68°F		20°C/68°F	
Recoated with	atmospheric		atmospheric	
	Mild	medium	Mild	medium
Alkyds	5 hours	8 hours	30 days	30 days

If this maximum recoating interval is exceeded, roughening of the surfasce is necessary to ensure intercoat adhesion.
 Before recoating after exposure in contaminated environment,clean surface thoroughly with (high pressure) fresh water cleaning and allow to dry.

Note: **BAJAK ALKYD PRIMER 11510 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 and national safety regulations. Harmful or fatal if swallowed; immediately seek medical assistance swallowed. Avoid inhalations of possible solvent vapors or paint mist, as well as paint contact with skin and eyes. Apply only on well-ventilated areas and ensure that adequate forced ventilation exists when applying paint in confined spaces or when the air is stagnant. Always take precautions against the risks of fire and explosions.

Issued: Apr. 2007

**BAJAPOX HB 11522**

CURING AGENT 61022

Description: BAJAPOX HB 11522 is a two-component Hi-Build polyamide-cured epoxy primer and mid coat . It cures to a strong and rust-preventing coating.

Recommended use: As a primer or intermediate coat in container systems as well as concrete. May be used as a general purpose epoxy primer according to painting specification.

Service temperatures:

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

PHYSICAL CONSTANTS:

Mixed product:	11522
Colours/Shade no:	Grey (7278)
Finish:	Flat
Volume Solids, %:	51±1
Theoretical spreading rate:	5.1 m ² /litre - 100 micron
Flash point:	26°C/79°F
Specific gravity:	1.4 kg/litre
Dry to touch:	2-3 hours at 20°C/68°F
Fully cured:	7 days at 20°C/68°F

APPLICATION DETAILS:

Mixing ratio for 11522:	BASE 11522 : Curing agent 61022 6 : 1 by weight		
Application method:	Airless spray	Air spray	Brush
Thinner (max.vol.):	08450 (5%)	08450 (15%)	08450 (5%)
Pot life:	8 hours (20°C/68°F) (airless spray)		
	8 hours (20°C/68°F) (brush)		
Nozzle orifice:	0.021"		
Nozzle pressure:	175 bar/2500 psi (Airless spray data are indicative and subject to adjustment)		
Cleaning of tools:	BAJAK'S TOOL CLEANER 99610		
Indicated dft:	100 micron/4 mils (See REMARKS overleaf)		
Indicated wft:	200 micron/8 mils		
Recoat interval	See REMARKS overleaf		

2. BAJAPOX PRIMER HB 11522

SURFACE PREPARATION:	<p>New steel: Abrasive blasting to Sa 2½. For temporary protection, if required, use a 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 11522.</p> <p>Other metals and light alloys: Thorough degreasing and removal of any salty contamination. Abrasive sweeping to create a suitable dense anchor profile.</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 St 3 (minor areas) or by abrasive blasting to min. Sa 2, preferably to Sa 2½.</p> <p>Improved surface preparation will improve the performance of BAJAPOX 11522. 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, wet abrasive blasting, alternatively dry abrasive blasting, high pressure fresh water hosing, drying, and finally, dry abrasive blasting again.</p>
APPLICATION CONDITIONS:	<p>Use only where application and curing can proceed at temperatures above 10°C/50°F. The temperature of the paint itself should be 15°C/59°F or above to secure proper application properties. In confined spaces provide adequate ventilation during application and drying. Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation.</p>
SUBSEQUENT COAT:	<p>BAJAPOX or BAJATHANE or according to specification.</p>
REMARKS:	
Weathering/service temperatures:	<p>The natural tendency of epoxy coatings to chalk in outdoor exposure and to become more service sensitive to mechanical damage and chemical exposure at elevated temperatures is also reflected in this product.</p>
Film thickness:	<p>May be specified in another film thickness than indicated depending on purpose and area of use. This will alter spreading rate and will influence the amount of thinning necessary, drying time and recoating interval. Normal range dry is 25-75 micron/1-3 mils.</p>
Recoating:	<p>Recoating intervals:</p> <p>Minimum (primarily only relevant for container coatings): 20 minutes' flash-off time for 40 micron/1.6 mils BAJAPOX 11522 when top coated with designed container coatings, epoxy, polyurethane, acrylic or CR types. The minimum recoating interval only applies in the case of forced ventilation, proper application and if the completed paint system is thoroughly dry before exposed to aggressive environments.</p> <p>Maximum: Recoating interval for non-immersion services is 24 hours for acrylic or CRs, 3 days for PUs and none for epoxies.</p> <p>In the case of long recoating intervals, a completely clean surface is mandatory to ensure intercoat adhesion. Any dirt, oil and grease 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.</p> <p>To check whether the quality of the surface cleaning is adequate, a test patch may be relevant.</p>
Note:	<p>BAJAPOX HB 11522 is for professional use only.</p>
Safety:	<p>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.</p>

BAJAMIRROR 11584-1132

Description: BAJAMIRROR 11584-1132 mirror-back coatings represent the state-of-the-art in high-performance, protective coatings for mirror products. BAJAMIRROR11584-1132 coatings deliver superior performance against the harshest accelerated environmental testing requirements in the mirror industry, including excellent salt spray and CASS corrosion results.

Recommended use: As a primer coat for copper mirror sheets.

APPLICATION DETAILS:

Applying viscosity 25-30 sec ,Ford cup No#4
Thinner (20%,based on volume) xylene

CURING CONDITION:

substrate: Copper mirror sheets
DFT: 50 microns
Baking temperature: 120°C
Baking time: 4min

PHYSICAL PROPERTIES:

Shade: Red
Specific gravity . $\pm 0.0.2$ (g/ml): 1.5,(ASTM 1475)
Volume solid (%): 59,(ASTM 2697)
Weight Solid (%): 69,(ASTM D 2697-03)
Preceding coat : Cooper mirror sheet

FILM PROPERTIES:

Shade: Red
Adhesion: 1B (ASTM D 3359 or 4,ISO 2409)
MEK resistance: 1 (double rubbing)

APPLICATION METHOD: Curtain coating

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.

Issued:



بازاک (سهامی خاص)

BAJAK EPOXY PHENOLIC PAINT 11590

CURING AGENT 61090

Description: BAJAK 11590 is a two component epoxy phenolic polyamine coating, which cures to a hard wearing and highly chemical resistant coating. Offers good permeability resistance.

Recommended use:

- 1- As a versatile long-term coating on steel and primed steel for bajak epoxy, vinyl and acrylic coating systems in moderately to severely corrosive environments.
- 2- As a final coating for fuel tank coatings.

Service temperatures: maximum: Dry : 140°C

TECHNICAL DATAS:

Binders: Epoxy phenolic resin and polyamine.
Pigments: TiO₂
Solvents: Ketones, Alcohols and aromatic hydrocarbons.
Hardener: 61090

PHYSICAL CONSTANTS:

Mixed product: 11590
Colours/Shade no: White / 9034
Finish: Semi gloss
Volume Solids, %: App. 68%
Spreading rate: 13.6 m²/litre at 50 microns dft.
(Theoretical)
Flash point: 30°C
Specific gravity: app. 1.7 kg/litre
Surface dry: app. 60 mintes at 20°C (ISO 1517)
Dry to touch: app. 2 hrs at 20°C
Fully cured: 7 days at 20°C
V.O.C.: app. 457 g/litre

APPLICATION DETAILS:

Mixing ratio for 11590: BASE 11590 : CURING AGENT 61090
15.5 : 1 by weight

Application method: Airless spray air spray Brush
Thinner (max.vol.): 08090 (5%) 08090 (15%) 08090 (10%)
Pot life: 3 hours (20°C) (airless)
Nozzle orifice: 0.019" - 0.021"
Nozzle pressure: 150 bar/2200 psi

Cleaning of tools: 08090
Indicativd dft: 50 microns
Indicative wft: 75 microns
Recoat interval, min: 8 hrs at 20°C
Recoat interval, max: 7 days at 20°C

2. BAJAK EPOXY PHENOLIC PAINT 11590

SURFACE PREPARATION:	Abrasive blasting to SA2½ with a surface profile corresponding to rugotest No. 3, BN10, Kean-Tator comparator, Rough medium (G).
APPLICATION CONDITIONS:	Use only where application and curing can proceed at temperatures above 10°C. The temperature of the surface and that of the paint itself must be above this limit . Optimum results are obtained at 17°C. Apply only on a dry and clean surface with a temperature 3°C above the dew point to avoid condensation. Relative humidity max. 80%, preferably 40-60%.
PRECEDING COAT:	42421, or as per specification.
SUBSEQUENT COAT:	None, or as per specification.
REMARKS: Recoating:	If the maximum recoating interval is exceeded roughening of the surface is necessary to ensure intercoat adhesion.
Safety:	Handle with care. Before and during use, observe all safety labels on packaging and paint containers. Avoid inhalation of possible solvent vapors or paint mist, as well as paint contact with skin and eyes. Apply only in well ventilated areas.
Issued:	Feb 2004

**BAJAPOX ANTISTATIC PRIMER 11720**

CURING AGENT 60021

Description: BAJAPOX ANTISTATIC PRIMER 11720 is high performance Epoxy polyamide conductive primer coat on sealed concrete structures.

Recommended use: 1. As a high performance conductive primer with excellent adhesion to a wide range of existing coatings on sealed concrete.
2. As a glue for sticking copper network.

Service temperatures: Dry:
Maximum: 120°C

PHYSICAL CONSTANTS:

Colours: Black
Finish: Matt
Solids Content, %: 10
Theoretical spreading rate: 2.5 m²/litre-40 micron

Flash point: 32°C
Specific gravity: 0.87 kg/litre
Surface dry: 3 (approx.) hrs at 20°C (ISO 1517)
Dry to touch: 5 (approx.) hours at 20°C
Fully cured: 5 days at 20°C
V.O.C.: 780 g/litre

APPLICATION DETAILS:

Mixing ratio: Base 11720: Curing agent 60021
10 : 1 by weight
Application method: Brush & roller
(Consult the separate APPLICATION INSTRUCTIONS)
Thinner (max.vol.): 8020
20%
Pot life: 2 hours (20°C)
Nozzle orifice: -
Nozzle pressure: -

Clearing of tools: BAJAK'S THINNER 8020
Indicated film thickness, dry: 100
Indicated film thickness, wet: 130 (20°C)
Recoat interval, min: 8 hour (20°C)
Recoat interval, max: 5 days (20°C)

2. BAJAPOX ANTISTATIC PRIMER 11720

SURFACE PREPARATION: Sealed Concrete surface should be clean from dust and grease with thinner or suitable detergent and dry

APPLICATION CONDITIONS: Use only where application and curing can proceed at temperatures above 10°C. The temperature of the paint itself must be above 15°C for proper application. In-can temperature of the paint should preferably be below 25°C Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. Relative humidity max 60%

PRECEDING COAT: BAJAPOX CLEAR PRIMER 23020

SUBSEQUENT COAT: BAJAPOX ANTISTATIC 54726

REMARKS: The natural tendency of epoxy coatings to chalk in outdoor exposure and to weathering/service become more sensitive to mechanical damage and chemical exposure at elevated temperatures: temperatures is also reflected in this product.

Dry film thicknesses: 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 of application is 100-200 mic.

Recoating:

Physical data versus temperatures:				
	Minimum		Maximum	
SURFACE TEMPERATURE	20°C		20°C	
	Atmospheric mid	Atmospheric medium	Atmospheric mid	Atmospheric medium
Recoated with	mid	medium	mid	medium
BAJAPOX 54726	8 hours	8 hours	5 days	3 days

Note: **BAJAPOX ANTISTATIC PRIMER 11720 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

**BAJAPOX ANTISTATIC PRIMER 11726**

CURING AGENT 61726

Description: BAJAPOX ANTISTATIC PRIMER 11726 is high performance Epoxy polyamine conductive primer coat on sealed concrete structures.

Recommended use: 1.As a high performance conductive primer with excellent adhesion to a wide range of existing coatings on sealed concrete.
2. As a glue for sticking copper network.

Service temperatures: Dry:
Maximum: 120°C

PHYSICAL CONSTANTS:

Colours: Black
Finish: Matt
Solids Content, %: 75
Theoretical spreading rate: 7.5 m²/litre-100 micron
300 sq.ft./US gallon – 4 mils
Flash point: 32°C
Specific gravity: 1.3 kg/litre
Surface dry: 3 (approx.) hrs at 20°C (ISO 1517)
Dry to touch: 5 (approx.) hours at 20°C
Fully cured: 5 days at 20°C
V.O.C.: 220 g/litre

APPLICATION DETAILS:

Mixing ratio: Base 11726: Curing agent 61726
5 : 1 by weight
Application method: Brush & roller
(Consult the separate APPLICATION INSTRUCTIONS)
Thinner (max.vol.): 8020
20%
Pot life: 2 hours (20°C)
Nozzle orifice: -
Nozzle pressure: -

Clearing of tools: BAJAK'S THINNER 8020
Indicated film thickness, dry: 100
Indicated film thickness, wet: 130 (20°C)
Recoat interval, min: 8 hour (20°C)
Recoat interval, max: 5 days (20°C)

2. BAJAPOX ANTISTATIC PRIMER 11726

SURFACE PREPARATION: Sealed Concrete surface should be clean from dust and grease with thinner or suitable detergent and dry

APPLICATION CONDITIONS: Use only where application and curing can proceed at temperatures above 10°C. The temperature of the paint itself must be above 15°C for proper application. In-can temperature of the paint should preferably be below 25°C. Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. Relative humidity max 60%

PRECEDING COAT: BAJAPOX CLEAR PRIMER 23020

SUBSEQUENT COAT: BAJAPOX ANTISTATIC 54726

REMARKS: The natural tendency of epoxy coatings to chalk in outdoor exposure and to weathering/service become more sensitive to mechanical damage and chemical exposure at elevated temperatures: temperatures is also reflected in this product.

Dry film thicknesses: 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 of application is 100-200 mic.

Recoating:

Physical data versus temperatures:				
	Minimum		Maximum	
SURFACE TEMPERATURE	20°C		20°C	
	Atmospheric mid	Atmospheric medium	Atmospheric mid	Atmospheric medium
Recoated with	mid	medium	mid	medium
BAJAPOX 54726	8 hours	8 hours	5 days	3 days

Note: **BAJAPOX ANTISTATIC PRIMER 11726 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



BAJALIN PRIMER 12050

Description: BAJALIN PRIMER 12050 is a relatively quick-drying, zinc phosphate primer, based on long oil alkyd and urethane alkyd.

Recommended use: General purpose primer for BAJALIN systems for protection of steel in mild to medium atmospheric corrosive environments.

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

PHYSICAL CONSTANTS:

Colours/Shade nos.: Green/40760 - Red/50410
 Finish: Flat
 Volume solids, %: 49 ± 1
 Theoretical spreading rate: 12.3 m²/litre - 40 micron
 491 sq.ft./US gallon - 1.6 mils
 Flash point: 38°C/100°F
 Specific gravity: 1.3 kg/litre - 10.8 lbs/US gallon
 Dry to touch: 2-4 hours at 20°C/68°F
 V.O.C.: 410 g/litre - 3.4 lbs/US gallon

APPLICATION DETAILS:

Application method:	Airless spray	Air spray	Brush/Roller
Thinner (max.vol.):	08230 (5%)	08230 (5%)	08230 (5%)
Nozzle orifice:	.018"		
Nozzle pressure:	150 bar/2200 psi (Airless spray data are indicative and subject to adjustment)		
Cleaning of tools:	THINNER 08230		
Indicated film thickness, dry:	40 micron/1.6 mil		
Indicated film thickness, wet:	75 micron/3 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.

BAJALIN PRIMER 12050

SURFACE PREPARATION:	<p>New steel: Abrasive blasting to minimum Sa 2. For temporary protection, if required, use a suitable shopprimer. Damage of shopprimer and contamination from storage and fabrication should be thoroughly cleaned prior to final painting. For repair and touch-up use BAJALIN PRIMER 12050.</p> <p>Maintenance: Remove oil and grease, etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. Remove all rust and loose material by abrasive blasting or power tool cleaning. Dust off residues. Touch up to full film thickness.</p>
APPLICATION CONDITIONS:	<p>As dictated by normal good painting practice.</p> <p>In confined spaces provide adequate ventilation during application and drying.</p>
SUBSEQUENT COAT:	<p>BAJALIN system according to specification.</p>
REMARKS: Film thicknesses:	<p>Some of the certificates are issued under the former quality number 1205.</p> <p>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 30-50 micron/1.2-2 mils.</p>
Recoating:	<p>Recoating intervals related to later conditions of exposure: (40 micron/1.6 mils dry film thickness of BAJALIN PRIMER 12050)</p>

	Minimum		Maximum	
Steel temperature	20°C/68°F		20°C/68°F	
Recoated with (Quality Numbers only)	Atmospheric		Atmospheric	
	Mild	Medium	Mild	Medium
BAJALIN, except 53240 53240	5 hrs 2 days	8 hrs 2 days	none none	3 days 7 days

If the maximum recoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion. Before recoating after exposure in contaminated environment, clean surface thoroughly with (high pressure) fresh water hosing and allow to dry.

Note: **BAJALIN PRIMER 12050 is for professional use only.**

**BAJAMIRROR 12148**

Description: BAJAMIRROR 12148 mirror-back coatings represent the state-of-the-art in high-performance, protective coatings for mirror products. BAJAMIRROR 12148 coatings deliver superior performance against the harshest accelerated environmental testing requirements in the mirror industry, including excellent salt spray and CASS corrosion results.

Recommended use : As a primer for Aluminum and silver-copper mirror sheets

APPLICATION DETAILS:

Applying viscosity 25-30 sec , Ford cup No.#4
Thinner(max. 25%,based on volume) xylene

CURING CONDITIONS :

Substrate Aluminum and silver-copper mirror sheets
DFT 25-30 microns
Baking temperature 120 °C
Baking time 3min @ 120°C

PHYSICAL PROPERTIES :

Shade Ocher
Density , ±0.02 (g/ml) 1.4 , (ASTM 1475)
Volume solid (%) 57, (ASTM 2697)
Weight solid (%) 68, (ASTM D 2697-03)
Pot life 24 hr
Shelf life 6 month
Subsequent coat BAJAMIRROR 52586

FILM PROPERTIES:

Shade ocher
Pencil Hardness 2H (min.), (ASTM D3363)
Adhesion 5B, (ASTM D 3359 or 0,ISO 2409)
MEK resistance >100 (double rubbing)
Neutral salt spray Min. 500 hours, without blistering (ASTM B117)
CASS(Copper accelerated acetic acid salt spray) 5 day without any blistering on surface and any penetration in the X cut line, (ASTM B 368 – 97)

APPLICATION METHOD: Curtain coating or Pouring method

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. Take precautions against possible risks of fire or explosions as well as protection of the environment. Apply only in well ventilated areas.



بازاک (سهامی خاص)

BAJAK'S EPOXY PRIMER COATING 12220

CURING AGENT 63020

Description: BAJAK'S 12220 is a two component epoxy primer coating base on epoxy and polyamide resins and Zinc phosphate as inhibitive pigments (Non toxic pigments such as zinc chormate) with an excellent anticorrosive efficiency in moderate to severe environment.

Recommended use: As a tank coating inhibitive primer on blasted steel to protect that against corrosion.

Service temperature: Dry: Maximum 130 °C Wet: Maximum 50 °C

PHYSICAL CONSTANTS:

Colors/Shade No: Dark Gray
Finish: Semi Flat
Volume Solid: 60%
Theoretical spreading rate: 8.6 m² /liter 70 Mic. Dft.
Flash point: 32 °C
Specific gravity: 1.4 kg/liter
Surface dry: Max. 2 hours at 20 °C (ISO 1517)
Dry to touch: Max. 4 hours at 20 °C
Fully cured: 7 days at 20 °C
V.O.C.: Max. 350 gr/liter
Shelf life: 2 Years (25 °C/77 °F) from time of production. Depending on storage condition, mechanical stirring may be necessary before usage.

APPLICATION DETAILS:

Mixing ratio for 12320 Base 12220 : Curing agent 63020
4 : 1 by weight

Application method: Airless sprays Brush (touch-up)
Thinner (max. vol.) 8020 (5%) 8020 (5%)
Pot life: 8 hours (20 °C / 68 °F) 8hours (20 °C / 68 °F)
Nozzle orifice: .021"
Nozzle pressure: 150 bar / 2200 Psi
(Airless spray data are indicative and subject to adjustment)

Cleaning of tools: 8020
Indicated film thickness, dry: 70 microns
Indicated film thickness, wet: 115 microns
Recoat interval, min: 8 hours (20 °C)
Recoat interval, max: 7 days (20 °C), See REMARKS overleaf

Issued: 2004

2.BAJAK'S EPOXY PRIMER 12220

APPLICATION AND CURING CONDITIONS:

New steel: Abrasive blasting to minimum Sa 2 1/2 is recommended. The surface must be completely clean and dry at the time of application. And its temperature must be above the dew point to avoid condensation.

At the freezing point and below, be ware of the risk of ice on the surface which will hinder the adhesion. High humidity and/or condensation during application and the following 16 hours (20°C/68 °F) may adversely affect the film formation.

In confined spaces provide adequate ventilation during application and drying.

PRECEDING COAT:

None.

SUBSEQUENT COAT:

BAJAK'S EPOXY INTER MEDIATE 43520

REMARKS:

Film thicknesses:

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 is 70 microns/ 2.8 mils.

Thinning:

The type and amount of thinner depend on application conditions, application method, temperature, ventilation, and substrate. Thinner 8020 is recommended in general.

Physical data versus temperatures:

Recoating And drying/curing Time:					
Surface temperature		5°C /41°F	10°C /50°F	20°C /68°F	30°C /86°F
Dry to touch approx.		12 hours	8 hours	4 hours	3 hours
Resist condensing humidity/ light showers after		4 days	2 days	24 hours	12 hours
Fully cured		20 days	14 days	7 days	5 days
Recoating interval, with epoxy mid coat	Min	24 hours	16 hours	8 hours	4 hours
	Max	20 days	14 days	7 days	5 days

A completely clean surface is mandatory to ensure intercoat adhesion, especially at long recoating intervals. Any dirt,oil,and grease have to be removed, e.g. with suitable detergent.

Salts to be removed by fresh water hosing. To check an adequate quality of the surface cleaning a test patch is recommended before actual recoating.

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 and national safety regulations. Harmful or fatal if swallowed; immediately seek medical assistance swallowed. Avoid inhalations of possible solvent vapors or paint mist, as well as paint contact with skin and eyes. Apply only on well-ventilated areas and ensure that adequate forced ventilation exists when applying paint in confined spaces or when the air is stagnant. Always take precautions against the risks of fire and explosions.



باجاک (سهامی خاص)

BAJAK ZINC CHROMATE PRIMER 12310

(Formerly 29610)

Description: BAJAK 12310 is a quick drying long oil alkyd primer with zinc chromate inhibitor which has good resistance to corrosive environments.

Recommended use:

1. As general purpose primer for Bajak alkyd systems on steel surfaces in moderately corrosive environments.
2. As a blast primer for temporary protection of steel blast cleaned on site.

Service temperature: Maximum, dry: 100°C/ 212°F.

PHYSICAL CONSTANTS:

Colors/Shade No: Reed , Green , Grey & Blue
Finish: Semi Flat
Volume Solid: 50%
Theoretical spreading rate: 10M2 /Liter – 50 micron DFT.
Flash point: 35 °C/95° F
Specific gravity: 1.4 kg/liter
Surface dry: 2 hours at 20°C/68°F(ISO 1517)
Dry to touch: 2-4 hours at 20°C/68°F.
V.O.C.: 410 gr/liter

The physical constants are subject to normal manufacturing tolerances.

APPLICATION DETAILS:

Application method:	Airless spray	Air spray	Brush
Thinner (max. vol.)	1028 (5%)	1028 (15%)	1028 (5%)
Nozzle orifice:	0.018"		
Nozzle pressure:	150 bar / 2200 psi (Airless spray data are indicative and subject to adjustment)		
Cleaning of tools:	THINNER 1028		
Indicated film thickness, dry:	50 microns/2.mils		
Indicated film thickness, wet:	100 microns / 4 mils		
Recoat interval, min:	5 hours (20°C/ 68°F)		
Recoat interval, max:	See REMARKS overleaf		

Issued: Feb. 2007

2.BAJAK ZINC CHROMATE PRIMER 12310

SURFACE REPATATION: **New Steel:** Abrasive blasting to minimum Sa2 is recommended. Alternatively power tool cleaning to St3.
Mintenance: Remove oil and grease, etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. Remove all rust and loose material by abrasive blasting or power tool cleaning. Dust off residues. Touch up to full film thickness.

APPLICATION CONDITIONS: As detected by normal good painting practice.
 In confined spaces provide adequate ventilation during application and drying.

PRECEDING COAT: None.

SUBSEQUENT COAT: BAJAK alkyd system according to specification.

REMARKS:
 Film thicknesses: 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 is 40 -60microns/ 1.6-2.4 mils.

Recoating:

	MINIMUM		MAXIMUM	
STEEL TEMPERATURE	20°C/68°F		20°C/68°F	
Recoated with	atmospheric		atmospheric	
	Mild	medium	Mild	medium
Alkyds	5 hours	8 hours	30 days	30 days

If this maximum recoating interval is exceeded, roughening of the surfasce is necessary to ensure intercoat adhesion.
 Before recoating after exposure in contaminated environment,clean surface thoroughly with (high pressure) fresh water cleaning and allow to dry.

Note: **BAJAK ZINC CHROMATE PRIMER 12310 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 and national safety regulations. Harmful or fatal if swallowed; immediately seek medical assistance swallowed. Avoid inhalations of possible solvent vapors or paint mist, as well as paint contact with skin and eyes. Apply only on well-ventilated areas and ensure that adequate forced ventilation exists when applying paint in confined spaces or when the air is stagnant. Always take precautions against the risks of fire and explosions.

Issued: Feb. 2007

2. BAJAK'S EPOXY FLOW PRIMER 12323

APPLICATION AND CURING CONDITIONS: **New steel:** Abrasive blasting to minimum Sa 2½ is recommended. The surface must be completely clean and dry at the time of application. And its temperature must be above the dew point to avoid condensation
 At the freezing point and below, be ware of the risk of ice on the surface which will hinder the adhesion. High humidity and/or condensation during application and the following 16 hours (20°C/68°F) may adversely affect the film formation.
 In confined spaces provide adequate ventilation during application and drying.

PRECEDING COAT: None, or as per specification.

SUBSEQUENT COAT: BAJAK'S EPOXY INTERMEDIATE 42523, or as per specification.

REMARKS:
Film thicknesses: 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 is 40 microns/ 1.6 mils.

Thinning: The type and amount of thinner depend on application conditions, application method, temperature, ventilation, and substrate. Thinner 08026 is recommended in general.

Physical data versus temperatures:

Recoating And drying/curing Time:				
Surface temperature	5°C /41°F	10°C /50°F	20°C /68°F	30°C /86°F
Dry to touch approx.	12 hours	8 hours	4 hours	3 hours
Resist condensing humidity/ light showers after	4 days	2 days	24 hours	12 hours
Fully cured	20 days	14 days	7 days	5 days
Recoating interval, Recoating with 42523	Min	24 hours	16 hours	8 hours
	Max	15 days	12 days	5 days

A completely clean surface is mandatory to ensure intercoat adhesion, especially at long recoating intervals. Any dirt,oil,and grease have to be removed, e.g. with suitable detergent.

Salts to be removed by fresh water hosing. To check an adequate quality of the surface cleaning a test patch is recommended before actual recoating.

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 and national safety regulations. Harmful or fatal if swallowed; immediately seek medical assistance swallowed. Avoid inhalations of possible solvent vapors or paint mist, as well as paint contact with skin and eyes. Apply only on well-ventilated areas and ensure that adequate forced ventilation exists when applying paint in confined spaces or when the air is stagnant. Always take precautions against the risks of fire and explosions.



بازاک (سهامی خاص)

BAJALIN RED LEAD 12370

Description:	BAJALIN RED LEAD 12370 is a long-oil alkyd-based primer with red lead pigments.
Recommended use:	As a new-construction and maintenance primer in BAJALIN system on interior and exterior steel in mildly to moderately corrosive environment. Not suited for immersion.
Service temperatures:	Maximum, dry: 100°C/212°F.

PHYSICAL CONSTANTS:

Colours/Shade nos.:	Light red/55024
Finish:	Semi-flat
Volume solids:	50%
Theoretical spreading rate:	12.5 m ² /litre - 40 micron 501 sq.ft./US gallon - 1.6 mils
Flash point:	38°C/100°F
Specific gravity:	1.5 kg/litre - 12.5 lbs/US gallon
Dry to touch:	5-7 hours at 20°C/68°F
V.O.C.:	400 g/litre - 3.3 lbs/US gallon

The physical constants are subject to normal manufacturing tolerances.

APPLICATION DETAILS:

Application method:	Airless spray	Air spray	Brush/Roller
Thinner (max.vol.):	08230 (5%)	08230 (15%)	08230 (5%)
Nozzle orifice:	.018"		
Nozzle pressure:	150 bar/2200 psi (Airless spray data are indicative and subject to adjustment)		
Cleaning of tools:	THINNER 10808 or 10823		
Indicated film thickness, dry:	40 micron/1.6 mils		
Indicated film thickness, wet:	75 micron/3 mils		
Recoat interval, min:	See REMARKS overleaf		
Recoat interval, max:	See REMARKS overleaf		

BAJALIN RED LEAD 12370

SURFACE

Preparation: **New steel:** Abrasive blasting to minimum Sa 2, alternatively power tool cleaning to St 3.

Maintenance: Remove oil and grease, etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. Remove all rust and loose material by abrasive blasting or power tool cleaning. Dust off residues. Touch up to full film thickness.

Note: When scraping and wire-brushing on old RED LEAD, precautions must be taken against lead poisoning (filter mask).

APPLICATION CONDITIONS:

As dictated by normal good painting practice.
In confined spaces provide adequate ventilation during application and drying.
BAJALIN System according to specification.

SUBSEQUENT COAT:

REMARKS:

Film thicknesses: 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 30-50 micron/1.2-2 mils.

Recoating: Recoating intervals related to later conditions of exposure:
(40 micron/1.6 mils dry film thickness of BAJALIN RED LEAD 12370)

	MINIMUM		MAXIMUM	
STEEL TEMPERATURE	20°C/68°F		20°C/68°F	
Recoated with	atmospheric		atmospheric	
	Mild	medium	Mild	medium
BAJALIN except 15324 15324	24 hours 7 days	24 hours 7 days	none none	5days 10days

Before recoating after exposure in contaminated environment, clean surface thoroughly with (high pressure) fresh water and allow to dry.
If the maximum recoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion.

Note: BAJALIN RED LEAD 12370 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. Harmful or fatal if swallowed; immediately seek medical assistance if swallowed. Avoid inhalation of possible solvent vapours or paint mist, as well as paint contact with skin and eyes. 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. Always take precautions against the risks of fire and explosions.



بازاک (سهامی خاص)

BAJALIN RED OXIDE 12510

- Description:** BAJALIN RED OXIDE 12510 is a quick drying alkyd primer with red oxide pigments.
- Recommended use:**
1. Primarily as a maintenance primer in BAJALIN systems for protection of steel in mild to medium corrosive environments .
 2. As a blast primer for temporary protection of blast cleaned steel.
- Service temperatures:** Maximum, dry: 100°C/212°F.

PHYSICAL CONSTANTS:

Colours.:	Brown
Finish:	Flat
Volume solids:	50%
Theoretical spreading rate:	12.5 m ² /litre - 40 micron 501 sq.ft./US gallon - 1.6 mils
Flash point:	38°C/100°F
Specific gravity:	1.3 kg/litre - 12.5 lbs/US gallon
Dry to touch:	5-7 hours at 20°C/68°F
V.O.C.:	487 g/litre - 3.3 lbs/US gallon

APPLICATION DETAILS:

Application method:	Airless spray	Air spray	Brush/Roller
Thinner (max.vol.):	08230 (5%)	08230 (15%)	08230 (5%)
Nozzle orifice:	.018"		
Nozzle pressure:	150 bar/2200 psi (Airless spray data are indicative and subject to adjustment)		
Cleaning of tools:	THINNER 08230		
Indicated film thickness, dry:	40 micron/1.6 mils		
Indicated film thickness, wet:	75 micron/3 mils		
Recoat interval, min:	See REMARKS overleaf		
Recoat interval, max:	See REMARKS overleaf		

BAJALIN RED OXIDE 12510

SURFACE Preparation: **New steel:** Abrasive blasting to minimum Sa 2, alternatively power tool cleaning to St3.
Maintenance: Remove oil and grease, etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. Remove all rust and loose material by abrasive blasting or power tool cleaning. Dust off residues. Touch up to full film thickness.

APPLICATION CONDITIONS: As dictated by normal good painting practice.
 In confined spaces provide adequate ventilation during application and drying.

SUBSEQUENT COAT: BAJALIN System according to specification.

REMARKS:
Film thicknesses: 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 30-50 micron/1.2-2 mils.

Recoating: Recoating intervals related to later conditions of exposure:
 (40 micron/1.6 mils dry film thickness of BAJALIN RED OXIDE 12510)

	MINIMUM		MAXIMUM	
STEEL TEMPERATURE	20°C/68°F		20°C/68°F	
Recoated with	atmospheric		atmospheric	
	Mild	medium	Mild	medium
BAJALIN except 53240	24 hours	24 hours	none	5days
53240	7 days	7 days	none	10days

Before recoating after exposure in contaminated environment, clean surface thoroughly with (high pressure) fresh water and allow to dry.
 If the maximum recoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion.

Note: **BAJALIN RED OXIDE 12510 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. Harmful or fatal if swallowed; immediately seek medical assistance if swallowed. Avoid inhalation of possible solvent vapors or paint mist, as well as paint contact with skin and eyes. 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. Always take precautions against the risks of fire and explosions.

**BAJAPOX 12526**

CURING AGENT 62026

Description: BAJAPOX 12526 is a two-component, high-build, polyamide adduct-cured epoxy paint which cures to a coating with good resistance to abrasion seawater and crude oils.

Recommended use: As a self-primed coating for ballast water tanks and similar. As a primer for epoxy - systems for atmospheric or in-water service. Suitable for application down to --- -10°C/15°F. BAJAPOX 12526 is intended for use in cold/temperate climates, BAJAPOX 12526 is intended for use in temperate to warm climates.

Service temperatures:

Dry:	Maximum 90°C/194°F (See REMARKS overleaf)
Ballast water service:	Resists normal ambient temperatures at sea*
Other water service:	40°C/104°F (no temperature gradient)
Other liquids:	Contact BAJAK

*Avoid long-term exposure to negative temperature gradients.

Approval: Approved as ballast tank coating by Germanischer Lloyd (GL).

PHYSICAL CONSTANTS:

Mixed product:	12526
Colours/Shade no:	Grey - cream
Finish:	Semi-flat
Volume Solids, %:	68±1
Theoretical spreading rate:	4.5 m ² /litre - 150 micron 182 sq.ft./US gallon - 6 mils
Flash point:	32°C/90°F
Specific gravity:	1.4 kg/litre – 11.7 lbs/US gallon
Dry to touch:	7-8 hours at 20°C/68°F
Fully cured:	7 days at 20°C/68°F
V.O.C.:	315 g/litre – 2.6 lbs/US gallon

APPLICATION DETAILS:

Mixing ratio:	12526 Base 12526 : Curing agent 62026 4 : 1 parts by volume
Application method:	Airless spray Brush
Thinner (max.vol.):	08450 (5%) 08450 (5%)
Pot life:	2 hours (20°C/68°F)
Induction time:	See REMARKS overleaf
Nozzle orifice:	.019" – .023"
Nozzle pressure:	250 bar/3600 psi (Airless spray data are indicative and subject to adjustment)
Cleaning of tools:	BAJAK'S TOOL CLEANER 99610
Indicated dft:	150 micron/6 mils
Indicated wft:	225 micron/9 mils
Recoat interval, min:	8 hours (20°C/68°F)
Recoat interval, max:	See separate <u>APPLICATION INSTRUCTIONS</u>

Issued: March, 2006

BAJAPOX 12526

SURFACE PREPARATION:	<p>New steel: Remove oil and grease, etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. Abrasive blasting to Sa 2½. For temporary protection, if required, use a 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 12526.</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 St 3 (minor areas) or by abrasive blasting to min. Sa 2, preferably to Sa 2½. Improved surface preparation will improve the performance of BAJAPOX 12526.</p> <p>As an alternative to dry cleaning, water jetting to sound, well adhering coat and/or to steel. Intact coat must appear with roughened surface after the water jetting. By water jetting to steel, cleanliness shall be WJ-3 to WJ-2 (atmospheric exposure)/minimum WJ-2 (immersion) (NACE No. 5/SSPC-SP12). A flash-rust degree of maximum FR-2 (atmospheric exposure) / FR-2, preferably FR-1 (immersion) (BAJAK standard) is acceptable before application. Feather edges to sound and intact paint. Dust off residues. Touch up to full film thickness.</p> <p>On pit-corroded surfaces, excessive amounts of salt residues may call for water jetting or wet abrasive blasting, alternatively dry abrasive blasting followed by high pressure fresh water hosing, drying, and finally, dry abrasive blasting again. on</p>
APPLICATION CONDITIONS:	<p>Use only where application and curing can proceed at temperatures above 10°C/14°F (curing agent 62026). The temperature of the paint itself should be above 15°C/59°F for proper application. Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation.</p> <p>In confined spaces provide adequate ventilation during application and drying.</p>
SUBSEQUENT COAT:	12526 or according to specification.
REMARKS:	<p>Certificates are issued under the former quality number 12526.</p> <p>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.</p> <p>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 125-200 micron/5-8 mils.</p> <p>Mixing/ Induction time: To facilitate proper application properties it is recommended to allow the thoroughly mixed BASE and CURING AGENT to prereact before application. In case two-component spray-equipment is used, paint material is to be heated. Consult separate APPLICATION INSTRUCTIONS.</p>
Note:	BAJAPOX 12526 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.



APPLICATION INSTRUCTIONS

For product description refer to product data sheet

BAJAPOX 12526

CURING AGENT 62026

- Scope:** These application instructions cover surface preparation, application equipment, and application of BAJAPOX 12526.
- Ballast tanks, steel work:** For optimum performance the following is recommended:
All welding seams must have a surface finish which ensures that the quality of the paint system will be maintained in all respects. Holes in welding seams, undercuts, etc. should be avoided. If found, they may necessitate extra stripe coating or filling (however, the classification societies, recommendations are to be followed).

All sharp edges to be broken or rounded depending on the actual conditions and the design lifetime. Laminations to be removed. However, rolled profiles, etc. from the steel mills normally have acceptably rounded edges.

All loose weld spatters to be removed.

Well adhering, scattered weld spatters are acceptable, but will need additional touch-up. If dense, they must be removed by grinding.

Requirements to the "surface quality" of welds according to WELD REPLICAS NACE RP 0178 minimum Grade E(NACE Standard RP0178-95).
- Abrasive blasting/
Abrasive sweep blasting:** Before blasting any deposits of grease or oil must be removed from the steel surface with a suitable detergent followed by fresh water hosing. Minor spots of oil / grease may be cleaned with thinner and clean rags – avoid smearing out the contamination. Possible alkali weld deposits, chemicals used for testing of welds, soap residues from the pressure testing must be removed by fresh water hosing.
- Repair:** Before blasting, old steel surfaces must be checked for any contamination. Possible blisters must be broken. If thick rust scale has been removed or deep pittings have been encountered, control procedures for contamination must be carried out. If still contaminated, the abrasive blast cleaned steel surface will need a repeated cleaning for salt and / or oil/grease followed by final abrasive blast cleaning.
- New building / new steelwork :** To obtain full performance of the ballast tank coating. Welds, burns, damaged and rusty shopprimer must be abrasive blast cleaned to Sa 2½. Minor areas mechanically cleaned to St 3.
- If welds have previously been coated with a (shop) primer just after welding this (shop) primer must be removed by abrasive blasting (sweeping) in order to obtain optimum performance.**
- Intact shopprimer:** Zinc salted surfaces, deposits of black iron oxides of plasma cutting and similar foreign matters to be removed by light abrasive sweep blasting. Chalk markings and plate marking of a non-compatible nature to be removed as well.
- The shopprimer must have been checked randomly for excessive film thicknesses and areas detected to have film thicknesses above approx.40 micron/1.6 mils (as measured directly on the shopprimed surface with equipment calibrated on smooth steel) are to be sweep blasted in order to remove most of the shopprimer.

BAJAPOX 12526

Spot-checking for possible salt contamination of the surface to be executed before and after abrasive sweep blasting.

When blasting, the importance of working systematically must be stressed. Poorly blasted areas covered with dust are very difficult to locate during the blast inspection made after the rough cleaning.

In the case of abrasive blast cleaning, the surface profile must be equivalent to Rugotest No. 3 BN09-BN10 or Keane-Tator Comparator, 3.0 G/S. According to ISO 8503-1 the grade will be MEDIUM (G).

Note: If any doubt exists about the quality of the primary surface preparation (before shoppriming), the substrate must be re-blasted in situ as defined above.

Block assembly zones: Overlap zones must be treated with great care. Damage caused by possible over-blasting must be avoided, paint edges must be feathered and consecutive layers or paint coatings given greater and greater overlaps – old layers being roughened corresponding to these overlaps (when sandpapering, use free-cut paper, grain size 80).

Furthermore, these areas may be either masked off with tape – to keep them as narrow as possible – or left with a **thin** zinc epoxy primer coat applied on these areas after secondary surface preparation at block stage.

Secondary surface preparation of block assembly zones are preferably to be abrasive spot-blasted. However, mechanical cleaning to St 3 may be acceptable if zones are narrow and an extra coat of BAJAPOX 12526 is applied to these areas. The procedure of masking off with tape or using the zinc epoxy primer as described above may advantageously be used in case of mechanical cleaning.

Repair:

Corroded pits deeper than approx 2 mm. but not repaired by welding, are recommended to be filled with BAJAPOX EPOXY FILLER 35250 after blast priming has been carried out.

Stainless Steel: (Ballast tanks of chemical carriers) to be abrasive blast cleaned to uniform, sharp, **dense**, profile (Rugotest No. 3, BN9.10,ISO Comparator Medium (G), Keane-Tator Comparator 2.0 G/S corresponding to Rz minimum 50 micron). Any salts, grease, oil etc. to be removed before abrasive blasting is commenced.

Water jetting:

This procedure will primarily be relevant for repair jobs. However, the very good removal of water-soluble salts may also make it useful in other cases.

The resulting standard is to be equal to the WJ-2(NACE No. 5/SSPC-SP 12 "Surface Preparation and Cleaning of Steel and other Hard Materials by High and Ultra-High Pressure Water Jetting prior to Recoating ", 1995).

Sufficient dehumidification equipment must be used to dry out the tanks as quickly as possible between the water jetting and the coating application

Local ventilators may be required to distribute the drying air evenly in tanks. All "slurry" is to be removed before it dries. New rust will be acceptable as discoloration only, **not** as powdery, loose rust. Acceptable degree of " flash rust" is maximum FR.2. Inhibitors are **not** to be used.

All surfaces must be free from contamination at the time of painting and the relative humidity is to be below 85%.

Refurbishment:

It is recommended to carry out rough abrasive blast cleaning – or water jetting – to facilitate visual inspection and any necessary repair of the existing steel work. In the case of pit-corroded tank bottoms this rough blasting will also provide a better basis for a decision between welding of corroded pits or repair by filling.

BAJAPOX 12526

A main concern is the contamination from sea water (water-soluble, corrosive salts). The preventive method will be to include very thorough cleaning with plenty of fresh water, please see below.

The maximum allowable concentration of chlorides on steel surfaces immediately before application is 7.0 micron grammes/Cm² as detected by the 'Bresle Method'.

In the case of contamination, cleaning procedures must be repeated and/ or improved. Especially pit-corroded steel will need special attention and the only possible way to remove contamination from the pits may often be to carry out very thorough cleaning with fresh water after abrasive blast cleaning. After repeated control and drying, the entire surface will need abrasive blast cleaning to obtain the specified degree of cleaning. Alternatively, the pit-corroded areas are cleaned by water jetting, any surplus of water is mopped up or removed by vacuum cleaning, allow to dry.

Note: Actual type of steel work and surface preparation is dependent on factors such as shipyard technology, contractual specification, required lifetime, etc. Reference is also made to BAJAK's Technical Standard for Ballast Tank Coating Work.

Application equipment: BAJAPOX 12526, being a high viscosity material, may require special measures to be taken at application.

Recommended airless spray equipment:

Pump ratio:	Min 45:1
Pump output:	12 litres / minute (theoretical)
Input pressure:	Min. 6 bar/90 psi
Spray hoses:	Max. 100 metres/300 feet, ½" internal diameter Max. 30 metres/100 feet, 3/8" internal diameter Max. 6 meters /20 feet, 1/4" internal diameter
Filter:	60 mesh
Regular surfaces:	
Nozzle size:	.021", .023"
Fan angle:	60-80"
Complicated surfaces:	
Nozzle size:	.019"
Fan angle:	40°

After finishing the application, clean the equipment immediately with BAJAK'S TOOL CLEANER 99610.

Note: Increasing hose diameter may ease paint flow thereby improving the spray fan. If longer hoses are necessary it may be necessary to raise the pump ratio to 60:1, maintaining the high output capacity of the pump.

Alternatively up to approximately 5% THINER 08450 may be added, but thinning must be done with care as the maximum obtainable film thickness is reduced significantly by overthinning.

Airless spray data are indicative and subject to adjustment.

Application:

Film-build / continuity: With this ballast tank coating it is of special importance that a continuous, pinhole-free paint film is obtained at application of each coat. An application technique which will ensure good film formation on **all** surfaces must be adopted. It is very important to use nozzles of the correct size, not too big, and to have a proper, uniform distance of the spray gun to the surface, 30-50 cm should be aimed at. Furthermore, great care must be taken to cover edges, openings, rear sides of stiffeners etc. Thus, on these areas a stripe coat will usually be necessary. To obtain good and steady atomizing, the viscosity of the paint must be suitable and the spray equipment must be sufficient in output pressure and capacity. At high working temperatures, use of extra thinner may be necessary to avoid dust – spray.

BAJAPOX 12526

The paint layer must be applied homogeneously and as close to the specification as possible. The consumption of paint must be controlled to avoid exaggerated film thickness, eg by controlling paint consumption and / or measuring wet film thickness.

The finished coating must appear as a homogeneous film with a smooth surface and irregularities such as dust, dry spray, abrasives, should be remedied.

Pot life / mixing / Induction time: (both curing agents):

When measured under standard conditions the pot life is 3 hours at 15°C / 59 °F and 2 hours at 20 °C / 68 °F. However, for a 20 litres/5 US gallons mix, the heat developed by the chemical reaction between BASE and CURING AGENT may make the corresponding practical pot life shorter.

- a. Mix the entire content of corresponding base and curing agent packings. If it is necessary to mix smaller portions, this must be done properly by either weighing base and curing agent in the prescribed weight ratio: 86 parts by weight of base and 14 parts by weight of curing agent or by volume: 4.0 parts by volume base and 1.0 parts by volume curing agent.
- b. Stir the mixed paint thoroughly by means of a clean mechanical mixer until a homogeneous mixture is obtained
- c. Use all mixed paint before the pot life is exceeded. The pot life depends on the temperature of the paint as shown in table below (valid for a 20 litres can) :

Temperature of mixed paint	15 °C / 59 °F	20 °C / 67 °F	25 °C / 77 °F	30 °C / 88 °F
Pot life	4 hours	3 hours	2 hours	1 hour

- 1) At 15 °C / 59 °F and below, the viscosity can be too high for airless spray application.
- 2) Temperatures above 30 °C /86 °F should preferably be avoided.

Induction time:

At **steel** temperatures below 5 °C/41 °F the paint may advantageously be prereacted 10-20 minutes before spray application (longer prereaction time at lower temperatures).

When two-component spray equipment is used, heating may be relevant to obtain a proper spray fan and a uniform and smooth paint film. This can either be done by preheating the two-component paint or by using a flow-heater on the pressure side. As an indication a paint temperature of approx. 40° C / 104° F will be relevant, but has to be adjusted according to the actual conditions.

Physical data Versus temperature:

(BAJAPOX 12526 in a dry film thickness of 150 micron / 6 mils):

Surface temperature	0 °C / 32 °F	10 °C / 50 °F	20 °C / 68 °F	30 °C / 88 °F
Drying time	32 hours	14 hours	7 hours	5 hours
Curing time	28 hours	14 hours	7 hours	3½ hours
Initial curing *	20 days	10 days	5 days	2½ days

(BAJAPOX 12526 in a dry film thickness of 150 micron/6 mils):

Surface temperature	-10 °C/14 °F	0 °C/32 °F	10 °C/50 °F
Drying time	63 hours	32 hours	14 hours
Curing time	56 days	28 days	14 days
Initial curing *	40 days	20 days	10 days

- * When the state "initial curing" has been reached, the coating may exceptionally be exposed to ballast water provided it has been applied within the specified limits of film thicknesses **and** the all painted areas have subject to thorough ventilation.

BAJAPOX 12526

Recoating:

Recoating intervals (provided proper ventilation)
(150 micron / 6 mils dry film thickness)

	12526			
	Minimum		Maximum	
Steel temperature	10 °C / 50 °F	20 °C / 68 °F	10 °C / 50 °F	20 °C / 68 °F
Recoated with (quality No. only)				
Itself (ballast tanks)	16 hours	8 hours	90 days *	30 days *
45182	16 hours	8 hours	90 days	30 days
46330	16 hours	8 hours	24 hours	12 hours

* Depending on actual local conditions, extended maximum recoating intervals may apply. Please contact BAJAK for future advice.

Maximum recoating intervals:

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 12526 within the following directions for recoating:

* Long recoating intervals:

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.

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.

**BAJAPOX 12570**

CURING AGENT 62070

Description: BAJAPOX 12570 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 12570 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 : 100°C/212°F In water (maximum temperature gradient 35°C/63°F): 90°C/194°F

PHYSICAL CONSTANTS:

Mixed product:	12570	12570
Colours/Shade no:	Black	Brown
Finish:	Semi-gloss	Semi-gloss
Volume Solids, %:	55±1	55±1
Theoretical spreading rate:	2.8 m ² /litre - 200 micron 110 sq.ft./US gallon - 8 mils	2.8 m ² /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 20°C/68°F (ISO 1517)	4 (approx.) hours at 20°C/68°F (ISO 1517)
Dry to touch:	6 (approx.) hours at 20°C/68°F	6 (approx.) hours at 20°C/68°F
Fully cured:	7 days at 20°C/68°F	7 days at 20°C/68°F
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 12570:	BASE 12570 : Curing agent 62070 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 12570

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 12570. 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 12570. **In case of no immersion surface preparation degree of SSPC-SP 2 (St 2) is sufficient.**
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 05970 (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 12570)

Surface temperature	Minimum		Maximum	
	20°C/68°F		20°C/68°F	
Recoated with (Quality number only)	Atmospheric Serve	Water Immersion	Atmospheric Serve	Water Immersion
12570	6 hours	6 hours	36 hours*	36 hours*

*The maximum recoating interval between the layers of BAJAPOX 12570 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 12570 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 12570 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.



BAJACOIL 12585

Description:	BAJACOIL 12585 is high performance modified Polyester-Melamine coil coating primer with ultimate corrosion resistance. The product has very high flexibility and hardness as well as adhesion and inter-coat adhesion.
Recommended use:	As a primer to Galvanized steel and Aluminum coils., to be used for sandwich panel, corrugate sheet and etc.
CURING CONDITIONS	
Substrate	Galvanized steel and Aluminum coils
Subsequent coat	BAJACOIL 53585
DFT of primer	5-7 microns
Primer curing condition	Galvanized steel: 30 sec. @ 315-325°C- Aluminum coils: 40 sec. @230-240°C
Primer PMT	Galvanized steel: 225-232°C- Aluminum coils: 215-220°C
Top coat DFT	16-18 microns
Topcoat curing condition	Galvanized steel: 30 sec. @ 315-325°C- Aluminum coils: 70 sec. @230-240°C
Topcoat PMT	Galvanized steel: 225-232°C- Aluminum coils: 215-220°C
PHYSICAL CONSTANTS OF THE PRODUCT	
Density , ±0.02 (gr/ml)	1.2
Volume solid (%)	42
Weight solid (%)	56
Viscosity	65-85 sec , ASTM D1200 Cup#4
Shelf life	One year
FILM PROPERTIES	
Shade (code)	Yellow
Gloss (%)	30-50
Flexibility (T-bend)	1T , only crack without delamination 2T, without crack
Cupping resistance	7mm, without crack
MEK resistance	30 (double rubs)
APPLICATION METHOD:	Automatic Roller
SURFACE PREPARATION	Chromating process
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.

BAJAK'S ALUMINIUM ZINC UHR 12612

Description: BAJAK'S ALUMINIUM ZINC UHR 12612 is a primer mid coat and top coat heat resistant aluminium and zinc pigmented phisicaly drying paint. resistance to corrosion and heat up to 400°C and heat stress.

Recommended use: For long-term protection of hot pipelines, exhaust pipes, smoke stacks and other hot Surfaces up to 400°C. resist short time exposure up to 450°C. when heated to above 400°C for longer periods a certain discoloration may occure, which do not affect the protective properties of the product..

Service temperatures: Maximum, dry: 400°C/752 °F.

Availability:

PHYSICAL CONSTANTS:

Colours/Shade nos: Aluminium/zinc
 Finish: Semi mat (See REMARKS overleaf)
 Volume Solids, %: 42 ± 1
 Theoretical spreading rate: 10 m²/litre – 40 micron
 Flash point: 28°C/82°F
 Specific gravity: 1.3 kg/litre - 9.2 lbs/US gallon
 Surface dry: 20 min. (app.) at 20°C/68°F (ISO 1517)
 Dry to touch: 2 hours at 20°C/68°F
 V.O.C.: 510 g/litre - 4.9 lbs/US gallon

APPLICATION DETAILS:

Application method:	Airless spray	Air spray	Brush
Thinner (max.vol.):	08012 (15%)	08012 (25%)	08012 (15%)
Pot life:			
Nozzle orifice:	.017"-0.019"		
Nozzle pressure:	125 bar/1800 psi (Airless spray data are indicative and subject to adjustment)		
Cleaning of tools:	THINNER 08012		
Indicated film thickness, dry:	40 micron/1.6 mil (See REMARKS overleaf)		
Indicated film thickness, wet:	100 micron/4 mils		
Recoat interval, min:	4 hours (20°C/68°F) (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.

BAJAK'S ALUMINIUM ZINC UHR 12612

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 BAJAK'SALUMINIUM ZINC HR 12612.
APPLICATION CONDITION:	The surface must be completely clean and dry at the time of application, and its temperature must be 3°C above the dew point to avoid condensation. Minimum temperature for curing is -10°C. At the freezing point and below, be aware of the risk of ice on the surface, which will hinder the adhesion. High humidity and /or condensation during application and the following 16 hours (20°C) may adversely affect the film formation.
PRECEDING COAT:	BAJAK ALUMINIUM ZINC HR 12612 or according to specification.
SUBSEQUENT COAT:	BAJAK'S ALUMINIUM ZINC HR 12612, BAJAK'S SILICONE ALUMINIUM 56910.
REMARKS:	
Gloss:	After exposure to heat the gloss is reduced.
Film thicknesses:	A series of maintenance jobs may result in build up of a too high total film thickness, which may cause blister formation due to “entrapped” solvents. As each coat may also retain solvents, it is generally recommended not to apply BAJAK ALUMINUM ZINC 12612 in excessive film thickness.
Recoating:	Before recoating after exposure in contaminated environment, clean the surface thoroughly by high pressure fresh water hosing and allow drying.
Issued:	March 2019



باجاك (سهامى خاص)

BAJAK'S ALUMINIUM ZINC HR 12615

Description: BAJAK'S ALUMINIUM ZINC HR 12615 is a primer, mid and top coat heat resistant aluminium and zinc pigmented physically drying paint. resistance to corrosion and heat up to 400°C and heat stress.

Recommended use: For long-term protection of hot pipelines, exhaust pipes, smoke stacks and other hot Surfaces up to 250°C. resist short time exposure up to 300°C. when heated to above 250°C for longer periods a certain discoloration may occur, which do not affect the protective properties of the product..

Service temperatures: Maximum, dry: 250°C

Availability:

PHYSICAL CONSTANTS:

Colours/Shade nos: Aluminium/zinc
Finish: Semi mat (See REMARKS overleaf)
Volume Solids, %: 40 ± 1
Theoretical spreading rate: 10 m²/litre – 40 micron

Flash point: 28°C
Specific gravity: 1.3 kg/litre 20 min. (app.) at 20°C/68°F (ISO 1517)
Surface dry: 2 hours at 20°C
Dry to touch: 540 g/litre
V.O.C.:

APPLICATION DETAILS:

Application method:	Airless spray	Air spray	Brush
Thinner (max.vol.):	08012 (15%)	08012 (25%)	08012 (15%)
Pot life:			
Nozzle orifice:	.017"-0.019"		
Nozzle pressure:	125 bar (Airless spray data are indicative and subject to adjustment)		
Cleaning of tools:	THINNER 08080		
Indicated film thickness, dry:	40 micron (See REMARKS overleaf)		
Indicated film thickness, wet:	100 micron		
Recoat interval, min:	4 hours (20°C) (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.

BAJAK'S ALUMINIUM ZINC HR 12615

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 BAJAK'SALUMINIUM ZINC HR 12615.
APPLICATION CONDITION:	The surface must be completely clean and dry at the time of application, and its temperature must be 3°C above the dew point to avoid condensation. Minimum temperature for curing is -10°C. At the freezing point and below, be aware of the risk of ice on the surface, which will hinder the adhesion. High humidity and /or condensation during application and the following 16 hours (20°C) may adversely affect the film formation.
PRECEDING COAT:	BAJAK ALUMINIUM ZINC HR 12615 or according to specification.
SUBSEQUENT COAT:	BAJAK'S ALUMINIUM ZINC HR 12615, BAJAK'S SILICONE ACRYLIC 56940.
REMARKS:	
Gloss:	After exposure to heat the gloss is reduced.
Film thicknesses:	A series of maintenance jobs may result in build up of a too high total film thickness, which may cause blister formation due to “entrapped” solvents. As each coat may also retain solvents, it is generally recommended not to apply BAJAK ALUMINUM ZINC 12615 in excessive film thickness.
Recoating:	Before recoating after exposure in contaminated environment, clean the surface thoroughly by high pressure fresh water hosing and allow drying.
Issued:	March 2019



بازاڪ (سهامى خاص)

BAJALIN RED LEAD 12710

Description: BAJALIN RED LEAD 12710 is a long-oil alkyd-based primer with high content of red lead pigment.

Recommended use: As a new-construction and maintenance primer in BAJALIN system on interior and exterior steel in mildly to moderately corrosive environment.
Not suited for immersion.

Service temperatures: Maximum, dry: 100 °C/212 °F.

PHYSICAL CONSTANTS:

Colours/Shade nos.: Brown
Finish: Semi-flat
Volume solids: 40%
Theoretical spreading rate: 10 m²/litre - 40 micron
400 sq.ft./US gallon - 1.6 mils
Flash point: 38 °C/100 °F
Specific gravity: 1.9 kg/litre - 15.8 lbs/US gallon
Dry to touch: 5-7 hours at 20 °C/68 °F
V.O.C.: 440 g/litre - 3.6 lbs/US gallon
The physical constants are subject to normal manufacturing tolerances

APPLICATION DETAILS:

Application method:	Airless spray	Air spray	Brush/Roller
Thinner (max.vol.):	08010 (5%)	08010 (15%)	08010 (5%)
Nozzle orifice:	.019"		
Nozzle pressure:	150 bar/2200 psi		
Cleaning of tools:	(Airless spray data are indicative and subject to adjustment) THINNER 08010		
Indicated film thickness, dry:	40 micron/1.6 mils		
Indicated film thickness, wet:	100 micron/3 mils		
Recoat interval, min:	See REMARKS overleaf		
Recoat interval, max:	See REMARKS overleaf		

BAJALIN RED LEAD 12710

SURFACE
Preparation:

New steel: Abrasive blasting to minimum Sa 2, alternatively power tool cleaning to St3.

Maintenance: Remove oil and grease, etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. Remove all rust and loose material by abrasive blasting or power tool cleaning. Dust off residues. Touch up to full film thickness.

Note: When scraping and wire-brushing on old RED LEAD, precautions must be taken against lead poisoning (filter mask).

APPLICATION
CONDITIONS:

As dictated by normal good painting practice.
In confined spaces provide adequate ventilation during application and drying.

SUBSEQUENT
COAT:

BAJALIN System according to specification.

REMARKS:
Film thicknesses:

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 30-50 micron/1.2-2 mils

Recoating:

Recoating intervals related to later conditions of exposure:
(40 micron/1.6 mils dry film thickness of BAJALIN RED LEAD 12710)

STEEL TEMPERATURE Recoated with	MIMIMUM 20°C/68°F atmospheric		MAXIMUM 20°C/68°F atmospheric	
	Mild	medium	Mild	medium
BAJALIN except 53240	24 hours	24 hours	None	5days
53240	7 days	7 days	none	10days

Before recoating after exposure in contaminated environment, clean surface thoroughly with (high pressure) fresh water and allow to dry.

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

Note:

BAJALIN RED LEAD 12710 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. Harmful or fatal if swallowed; immediately seek medical assistance if swallowed. Avoid inhalation of possible solvent vapours or paint mist, as well as paint contact with skin and eyes. 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. Always take precautions against the risks of fire and explosions



بازاک (سهامی خاص)

BAJAK'S EE-PRIMER 13140

Description: BAJAK'S EE-PRIMER 13140 is a quick-drying, one-component, modified epoxy ester primer with zinc phosphate rust-inhibiting pigments.

Recommended use: As a versatile primer on steel and metal surfaces for BAJALIN or BAJATEX in mild to medium corrosive atmospheric environment. It provides the possibility of reducing the number of primers for maintenance. Has good adhesion properties to smooth metal surface.

Service temperatures: Dry :
maximum: 140°C/284°F (or as dictated by subsequent BAJATEX topcoats).

PHYSICAL CONSTANTS:

Colours/Shade no:	Light grey	Red
Finish:	Flat	Flat
Volume Solids, %:	41±1	42±1
Theoretical Spreading rate:	8.2 m ² /litre at 50 microns 329 sq.ft./US gallon - 2 mils	8.4 m ² /litre at 50 microns 337 sq.ft./US gallon - 2 mils
Flash point:	30°C/86°F	30°C/86°F
Specific gravity:	1.4 kg/litre – 11.7 lbs/US gallon	1.4 kg/litre – 11.7 lbs/US gallon
Surface dry:	¾ (approx.) hr at 20°C/68°F (ISO 1517)	¾ (approx.) hr at 20°C/68°F (ISO 1517)
Dry to touch:	2 (approx.) hours at 20°C/68°F	2 (approx.) hours at 20°C/68°F
V.O.C.:	520 g/litre - 4.3 lbs/US gallon	520 g/litre - 4.3 lbs/US gallon

APPLICATION DETAILS:

Application method:	Airless spray	air spray	Brush / Roller
Thinner (max.vol.):	08080 (5%)	08080 (10%)	08080 (10%)
Nozzle orifice:	0.019" - 0.023"		
Nozzle pressure:	150 bar/2200 psi		
	<i>(Airless spray data are indicative and subject to adjustment)</i>		
Cleaning of tools:	BAJAK 'S THINNER 08080		
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		

2. BAJAK'S EE-PRIMER 13140

SURFACE PREPARATION: **New steel:** Abrasive blasting to minimum Sa 2½ is recommended. A suitable zinc-free or low-zinc shopprimer may be used for temporary protection if required. All damage of shopprimer and contamination from storage and fabrication should be thoroughly cleaned prior to final painting. For repair and touch-up use BAJAK'S EE-PRIMER 13140.
Maintenance: Remove oil and grease etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water hosing. 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.
 In confined spaces provide adequate ventilation during application and drying

SUBSEQUENT COAT: BAJALIN or similar alkyds or BAJATEX systems according to specification.
 Recoating with other qualities, see REMARKS below.

REMARKS:
Substrate: Smooth metal surfaces and zinc-coated steel are only relevant as substrate in case of later mild exposure conditions.

Film thicknesses: 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 25-80 micron/1-3.2 mils.

Recoating: Recoating intervals related to later conditions of exposure:
 (50 micron/2 mils dry film thickness of BAJAK'S EE-PRIMER 13140)

	Minimum		Maximum	
Steel temperature	20°C/68°F		20°C/68°F	
Recoated with	Atmospheric		Atmospheric	
	Mild	Medium	Mild	Medium
BAJALIN ⁽¹⁾	1 hour	2 hour	None	3 days
BAJATEX, BAJALIN ⁽²⁾	4 hour	6 hour	None	None

⁽¹⁾ Dissolved in white spirit only

⁽²⁾ Dissolved in aromatic solvents

Recoating with epoxy and P.U.: If the maximum recoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion.
 Recoating with BAJAPOX and BAJATHANE is possible, but should be done with as thin layers as possible to minimize the risk of lifting. Furthermore, in this case - used as a "bridge coating" – it is recommended to apply BAJAK'S EE-PRIMER 13140 in 25 micron/1 mil dry film thickness only. Make a test patch to secure full compatibility between the old paint system and the new paint system.
 Minimum recoating interval (20°C/68°F) is 48 hours, maximum none.

Notes: Before recoating after exposure in contaminated environment, clean surface thoroughly with high pressure fresh water hosing and allow to dry.
BAJAK'S EE-PRIMER 13140 is for professional use only.

Safety: Handle with care. Before and during use, observe all safety labels on packaging and paint containers, consult BAJAKA 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 and ensure that adequate forced ventilation exists when applying paint in confined spaces or when the air is stagnant.



باجاک (سهامی خاص)

BAJAK'S HIGH SOLID EPOXY 13220HS

CURING AGENT 63028

Description: BAJAK'S high solid epoxy 13220HS a two component epoxy high solid base on epoxy and polyamide resins and Non toxic pigments with good barrier protection properties.

Recommended use: As a self primer lining on blasted steel pipe to protect that against potable water.

Approval certificate: Approved by METRA (Amirkabir Paint Research Institute) according to AWWA C210 & BS6920 for potable water tanks & pipes.

Service temperature: Dry: Maximum 130 °C Wet: Maximum 50 °C

PHYSICAL CONSTANTS:

Colors/Shade No: Red Brown, Gray
Finish: Semi Gloss
Volume Solid: 80±5%
Theoretical spreading rate: 5.33 m²/liter 150 Mic. Dft.
Flash point: 32 °C
Specific gravity: 1.4 kg/liter
Surface dry: Max. 2 hours at 20 °C (ISO 1517)
Dry to touch: Max. 4 hours at 20 °C
Fully cured: 7 days at 20 °C
V.O.C.: Max. 270 gr/liter
Shelf life: 1 Years (25 °C//77 °F) from time of production. Depending on storage condition, mechanical stirring may be necessary before usage.

APPLICATION DETAILS:

Mixing ratio: Base 13220 : Curing agent 63028
3 : 1 by volume

Application method: Airless sprays Brush (touch-up)

Thinner (max. vol.) 8020 (5%) 8020 (5%)

Pot life: 8 hours (20 °C / 68 °F) 8 hours (20 °C / 68 °F)

Nozzle orifice: 0.019" - 0.021"

Nozzle pressure: 150 bar / 2200 Psi
(Airless spray data are indicative and subject to adjustment)

Cleaning of tools: 8020

Indicated film thickness, dry: 150 microns

Indicated film thickness, wet: 220 microns

Recoat interval, min: 8 hours (20 °C)

Recoat interval, max: 7 days (20 °C), See REMARKS overleaf

Issued: 2007

2.BAJAK'S EPOXY HIGH SOLID 13220HS

APPLICATION AND CURING CONDITIONS:

New steel: Abrasive blasting to minimum Sa 2 1/2 is recommended. The surface must be completely clean and dry at the time of application. And its temperature must be above the dew point to avoid condensation.

At the freezing point and below, be ware of the risk of ice on the surface which will hinder the adhesion. High humidity and/or condensation during application and the following 16 hours (20°C/68 °F) may adversely affect the film formation.

In confined spaces provide adequate ventilation during application and drying.

PRECEDING COAT:

None.

SUBSEQUENT COAT:

None , or 13220

REMARKS:

Film thicknesses:

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 is 150 microns/ 6 mils.

Thinning:

The type and amount of thinner depend on application conditions, application method, temperature, ventilation, and substrate. Thinner 8020 is recommended in general.

Physical data versus temperatures:

Recoating And drying/curing Time:				
Surface temperature	5°C /41°F	10°C /50°F	20°C /68°F	30°C /86°F
Dry to touch approx.	12 hours	8 hours	4 hours	3 hours
Resist condensing humidity/ light showers after	4 days	2 days	24 hours	12 hours
Fully cured	20 days	14 days	7 days	5 days
Recoating interval, With epoxy mid coat	Min	24 hours	16 hours	8 hours
	Max	20 days	14 days	7 days

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

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.

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 and national safety regulations. Harmful or fatal if swallowed; immediately seek medical assistance swallowed. Avoid inhalations of possible solvent vapors or paint mist, as well as paint contact with skin and eyes. Apply only on well-ventilated areas and ensure that adequate forced ventilation exists when applying paint in confined spaces or when the air is stagnant. Always take precautions against the risks of fire and explosions.



بازاک (سهامی خاص)

BAJAQUICK PRIMER 13624

Description: BAJAQUICK PRIMER 13624 is a very quick-drying zinc phosphate pigmented alkyd primer.

Recommended use: As a rust preventing primer on steel, machinery parts, etc. where quick drying is needed, both as a workshop primer for temporary protection and as a general purpose primer in fast drying alkyd-based systems for protection of steel in mild to medium atmospheric corrosive environments.

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

PHYSICAL CONSTANTS:

Colours.: Light gray/12170 - Red/50710
Finish: Flat
Volume solids: 47%
Theoretical spreading rate: 5.9 m²/litre - 80 micron
236 sq.ft./US gallon – 3.2 mils
Flash point: 31°C/88°F
Specific gravity: 1.4 kg/litre - 11.7 lbs/US gallon
Dry to touch: 1 hours at 20°C/68°F
V.O.C.: 470 g/litre - 3.9 lbs/US gallon

APPLICATION DETAILS:

Application method:	Airless spray	Air spray	Brush/Roller
Thinner (max.vol.):	08080 (5%)	08080 (15%)	08080 (5%)
Nozzle orifice:	.021"		
Nozzle pressure:	150 bar/2200 psi (Airless spray data are indicative and subject to adjustment)		
Cleaning of tools:	THINNER 08080		
Indicated film thickness, dry:	80 micron/3.2 mils		
Indicated film thickness, wet:	175 micron/7 mils		
Recoat interval, min:	See REMARKS overleaf		
Recoat interval, max:	See REMARKS overleaf		

BAJAQUICK PRIMER 13624

SURFACE Preparation: New Steel: Remove oil and grease etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. Abrasive blasting to minimum Sa 2, alternatively power tool cleaning to St 3 depending on the corrosion impact.
 On machinery: May be applied directly on steel and iron after degreasing and mechanical cleaning.
 Repair of damaged areas: Remove oil and grease etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. Remove all rust and loose material by abrasive blasting or power tool cleaning followed by fresh water cleaning. 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.
 In confined spaces provide adequate ventilation during application and drying.

SUBSEQUENT COAT: Xylene-based BAJALINs and similar alkyds or according to specification.

REMARKS: Film thicknesses: 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 40-80 micron/1.6-3.2 mils.

Recoating: Recoating intervals related to later conditions of exposure:
 (80 micron/3.2 mils dry film thickness of BAJAQUICK PRIMER 13624)

	MINIMUM		MAXIMUM	
STEEL TEMPERATURE	20°C/68°F		20°C/68°F	
Recoated with	atmospheric		atmospheric	
	Mild	medium	Mild	medium
BAJALIN*	15 minutes	30 minutes	none	none

*Dissolved in xylene only.

Note: Before recoating after exposure to contaminated environment, the surface should be thoroughly cleaned by high pressure fresh water hosing and allow to dry.

BAJAQUICK PRIMER13624 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. Harmful or fatal if swallowed; immediately seek medical assistance if swallowed. Avoid inhalation of possible solvent vapors or paint mist, as well as paint contact with skin and eyes. 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. Always take precautions against the risks of fire and explosions.

**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 : 100°C/212°F In water (maximum temperature gradient 35°C/63°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 m ² /litre - 200 micron 110 sq.ft./US gallon - 8 mils	2.8 m ² /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 20°C/68°F (ISO 1517)	4 (approx.) hours at 20°C/68°F (ISO 1517)
Dry to touch:	6 (approx.) hours at 20°C/68°F	6 (approx.) hours at 20°C/68°F
Fully cured:	7 days at 20°C/68°F	7 days at 20°C/68°F
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	
	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.

**BAJAKPOX 15130**

CURING AGENT 95140

Description: BAJAPOX 15130 is a two-component, polyamide cured coal tar epoxy which provides a very hardwearing coating, highly resistant to seawater and mineral oils. Limited resistance to a number of solvents. Aliphatic hydrocarbons may be discolored.

Recommended use: As a self-priming coating system for long-term protection of steel and concrete in severely corrosive environment. It provides excellent protection as a lining in cured and fuel oil tanks.

If the exposure is acidic or a temperature gradient is developed, it is recommended to use BAJAPOX 15100. For application at lower temperatures, ie in the interval from -10°C/ 14°F to + 10°C /50°F, it is recommended to use BAJAPOX LTC 15030.

Service temperatures:

Dry:	Maximum 90°C/194°F(See REMARKS overleaf
Ballast water service:	Resists normal ambient temperatures at see*
Other water service:	45/113°F (no temperature gradient)
Other liquids:	Contact BAJAK

* Avoid long-term exposure to negative temperature gradients.

PHYSICAL CONSTANTS:

Colours:	Black	Brown
Finish:	Semi-gloss	Semi-gloss
Volume Solids, %:	70 ± 1	70 ± 1
Theoretical spreading rate:	5.6 m ² /litre – 125 micron 225 sq.ft. /US gallon - 5 mils	5.6 m ² /litre – 125 micron 225 sq.ft. /US gallon - 5 mils
Flash point:	25°C/77°F	25°C/77°F
Specific gravity:	1.3 kg/ litre. 10.8 lbs.US gallon	1.3 kg/litre - 10.8 lbs.US gallon
Surface dry:	6 (approx) hrs at 20°C/68°F (ISO 1517)	5 (approx) hrs at 20°C/68°F (ISO 1517)
Dry to touch:	7-8 hours at 20°C/68°F	6-7 hours at 20°C/68°F
Fully cured:	7 days at 20°C/68°F	7 days at 20°C/68°F
V.O.C.:	295 g/litre - 2.4 lbs/US gallon	300 g/litre - 2.4 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 15130: Base 15130 : Curing agent 95140
4 : 1 by volume

Application method:	Airless spray	Brush (touch up)
Thinner (max.vol.):	08450 (5%)	08450 (5%)
Pot life:	2 hours (20°C/68°F)	6 hours (20°C/68°F)
Nozzle orifice:	.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 film thickness, dry : 125 micron/ 5 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 15130

SURFACE PREPARATION: **New steel:** Abrasive blasting to Sa 2½ . For temporary protection, if required, use a 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 15130. **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, see the Product Data Sheet for BAJAPOX SEALER 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. As an alternative to dry cleaning, 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 is acceptable before application. 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 5°C/41°F. The temperature of the paint itself should preferably be above 15°C/59°F. Best results are obtained at surface and paint temperatures of 15-25°C/59-77°F. 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.

SUBSEQUENT COAT: None or as per specification depending on area of use.

REMARKS: Weathering/ Service temperatures: The natural tendency of epoxy coatings to become more sensitive to mechanical damage and chemical exposure at elevated temperatures is also reflected in this product.

Film thicknesses: 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.

Recoating: The recoating intervals in hours for BAJAPOX 15130 (on condition of sufficient ventilation):

Surface temperature		5°C/41°F		100°C/50°F		20°C/68°F		30°C/86°F	
DFT of BAJAPOX 15130		125	200	125	200	125	200	125	200
BAJATEX HI-BUILD 46330	Min	21	39	14	25	6	11	4	7
	Max	54	76	36	48	16	22	11	14
BAJAPOX qualities	Min	21	39	14	25	6	11	4	7
	Max	7 d	7 d	4½ d	4½ d	48	48	32	32

The maximum recoating interval between layers of BAJAPOX 15130 can be doubled 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 layer of BAJAPOX 15130 must be free of any exudations. This is secured by keeping the conditions of application, drying and curing, i.e. such as ventilation, temperature, film thickness and thinning within the above described limits. Note that excessive temperatures also must be avoided. If the maximum recoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion.

Note: Bleeding may occur into subsequent coats. The effect is cosmetic only and has no negative influence on neither the anticorrosive nor the antifouling properties of the system. **BAJAPOX 15130 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.

**BAJAKPOX 15130M**

CURING AGENT 95140

Description: BAJAPOX MIO 15130M is a two-component, polyamide cured coal tar epoxy micaceous iron oxide pigmented which provides a very hardwearing coating, highly resistant to seawater and mineral oils. Limited resistance to a number of solvents. Aliphatic hydrocarbons may be discolored.

Recommended use: As a self-priming coating system for long-term protection of steel and concrete in severely corrosive environment. It provides excellent protection as a lining in cured and fuel oil tanks. If the exposure is acidic or a temperature gradient is developed, it is recommended to use BAJAPOX 15100. For application at lower temperatures, ie in the interval from -10°C/ 14°F to + 10°C /50°F, it is recommended to use BAJAPOX LTC 15030.

Service temperatures:

Dry:	Maximum 90°C/194°F(See REMARKS overleaf
Ballast water service:	Resists normal ambient temperatures at see*
Other water service:	45/113°F (no temperature gradient)
Other liquids:	Contact BAJAK

* Avoid long-term exposure to negative temperature gradients.

PHYSICAL CONSTANTS:

Colours:	Black
Finish:	Semi-gloss
Volume Solids, %:	70 ± 1
Theoretical spreading rate:	5.6 m ² /litre – 125 micron 225 sq.ft. /US gallon - 5 mils
Flash point:	25°C/77°F
Specific gravity:	1.3 kg/ litre. 10.8 lbs.US gallon
Surface dry:	6 (approx) hrs at 20°C/68°F (ISO 1517)
Dry to touch:	7 days at 20°C/68°F
Fully cured:	295 g/litre - 2.4 lbs/US gallon
V.O.C.:	
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 15130M:	Base 15130M : Curing agent 95140 4 : 1 by volume	
Application method:	Airless spray	Brush (touch up)
Thinner (max.vol.):	08450 (5%)	08450 (5%)
Pot life:	2 hours (20°C/68°F)	6 hours (20°C/68°F)
Nozzle orifice:	.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 film thickness, dry :	125 micron/ 5 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 MIO 15130

SURFACE PREPARATION:	<p>New steel: Abrasive blasting to Sa 2½ with roughness equal to BN11 according to Rugotest No. 3. For temporary protection, if required, use a 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 15130M.</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, see the Product Data Sheet for BAJAPOX SEALER 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 abrasive blasting or power tool cleaning. As an alternative to dry cleaning, 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 is acceptable before application. Feather edges to sound and intact areas. Dust off residues. Touch up to full film thickness.</p>																																																										
APPLICATION CONDITIONS:	<p>Use only where application and curing can proceed at temperatures above 5°C/41°F. The temperature of the paint itself should preferably be above 15°C/59°F. Best results are obtained at surface and paint temperatures of 15-25°C/59-77°F. 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.</p>																																																										
SUBSEQUENT COAT:	None or as per specification depending on area of use.																																																										
REMARKS: Weathering/ Service temperatures:	The natural tendency of epoxy coatings to become more sensitive to mechanical damage and chemical exposure at elevated temperatures is also reflected in this product.																																																										
Film thicknesses:	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 500-700 micron/ 20-28 mils.																																																										
Recoating:	<p>The recoating intervals in hours for BAJAPOX MIO15130M(on condition of sufficient ventilation):</p> <table border="1"> <thead> <tr> <th colspan="2">Surface temperature</th> <th colspan="2">10°C/50°F</th> <th colspan="2">30°C/68°F</th> <th colspan="2">20°C/68°F</th> <th colspan="2">30°C/86°F</th> </tr> <tr> <th colspan="2">DFT of BAJAPOX 15130M</th> <th>125</th> <th>200</th> <th>125</th> <th>200</th> <th>125</th> <th>200</th> <th>125</th> <th>200</th> </tr> </thead> <tbody> <tr> <td rowspan="2">BAJATEX HI-BUILD 46330</td> <td>Min</td> <td>21</td> <td>39</td> <td>14</td> <td>25</td> <td>6</td> <td>11</td> <td>4</td> <td>7</td> </tr> <tr> <td>Max</td> <td>54</td> <td>76</td> <td>36</td> <td>48</td> <td>16</td> <td>22</td> <td>11</td> <td>14</td> </tr> <tr> <td rowspan="2">BAJAPOX qualities</td> <td>Min</td> <td>21</td> <td>39</td> <td>14</td> <td>25</td> <td>6</td> <td>11</td> <td>4</td> <td>7</td> </tr> <tr> <td>Max</td> <td>7 d</td> <td>7 d</td> <td>4½ d</td> <td>4½ d</td> <td>48</td> <td>48</td> <td>32</td> <td>32</td> </tr> </tbody> </table> <p>The maximum recoating interval between layers of BAJAPOX 15130 can be doubled 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 layer of BAJAPOX 15130 must be free of any exudations. This is secured by keeping the conditions of application, drying and curing, i.e. such as ventilation, temperature, film thickness and thinning within the above described limits. Note that excessive temperatures also must be avoided. If the maximum recoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion.</p>	Surface temperature		10°C/50°F		30°C/68°F		20°C/68°F		30°C/86°F		DFT of BAJAPOX 15130M		125	200	125	200	125	200	125	200	BAJATEX HI-BUILD 46330	Min	21	39	14	25	6	11	4	7	Max	54	76	36	48	16	22	11	14	BAJAPOX qualities	Min	21	39	14	25	6	11	4	7	Max	7 d	7 d	4½ d	4½ d	48	48	32	32
Surface temperature		10°C/50°F		30°C/68°F		20°C/68°F		30°C/86°F																																																			
DFT of BAJAPOX 15130M		125	200	125	200	125	200	125	200																																																		
BAJATEX HI-BUILD 46330	Min	21	39	14	25	6	11	4	7																																																		
	Max	54	76	36	48	16	22	11	14																																																		
BAJAPOX qualities	Min	21	39	14	25	6	11	4	7																																																		
	Max	7 d	7 d	4½ d	4½ d	48	48	32	32																																																		
Note:	<p>Bleeding may occur into subsequent coats. The effect is cosmetic only and has no negative influence on neither the anticorrosive nor the antifouling properties of the system.</p> <p>BAJAPOX MIO 15130M is for professional use only.</p>																																																										
Safety:	<p>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.</p>																																																										

**BAJAPOX PRIMER 15300**

CURING AGENT 95040

Description: BAJAPOX PRIMER 15300 is a two-component polyamide-cured epoxy primer containing zinc phosphate as corrosion inhibiting pigment. It cures to a strong and rust-preventing coating.

Recommended use: As a primer or intermediate coat in container systems. May be used as a general purpose epoxy primer according to painting specification.

Service temperatures:

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

PHYSICAL CONSTANTS:

Mixed product:	15300
Colours/Shade no:	Red-Grey
Finish:	Flat
Volume Solids, %:	51±1
Theoretical spreading rate:	12.75 m ² /litre - 40 micron 521 sq.ft./US gallon - 1.6 mils
Flash point:	26°C/79°F
Specific gravity:	1.3 kg/litre - 10.8 lbs/US gallon
Dry to touch:	2-3 hours at 20°C/68°F
Fully cured:	7 days at 20°C/68°F
V.O.C.:	455 g/litre - 3.8 lbs/US gallon
Shelf life:	1 year (25°C) from time of production. Depending on storage conditions, mechanical stirring may be necessary before usage.

APPLICATION DETAILS:

Mixing ratio for 15300:	BASE 15300 : Curing agent 95040 4 : 1 by volume		
Application method:	Airless spray	Air spray	Brush
Thinner (max.vol.):	08450 (5%)	08450 (15%)	08450 (5%)
Pot life:	8 hours (20°C/68°F) (airless spray) 8 hours (20°C/68°F) (brush)		
Nozzle orifice:	0.021"		
Nozzle pressure:	175 bar/2500 psi (Airless spray data are indicative and subject to adjustment)		
Cleaning of tools:	BAJAK'S TOOL CLEANER 99610		
Indicated dft:	40 micron/1.6 mils (See REMARKS overleaf)		
Indicated wft:	75 micron/3 mils		
Recoat interval	See REMARKS overleaf		

2. BAJAPOX PRIMER 15300

SURFACE PREPARATION:	<p>New steel: Abrasive blasting to Sa 2½. For temporary protection, if required, use a 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 PRIMER.</p> <p>Other metals and light alloys: Thorough degreasing and removal of any salty contamination. Abrasive sweeping to create a suitable dense anchor profile.</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 St 3 (minor areas) or by abrasive blasting to min. Sa 2, preferably to Sa 2½.</p> <p>Improved surface preparation will improve the performance of BAJAPOX PRIMER 15300. 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, wet abrasive blasting, alternatively dry abrasive blasting, high pressure fresh water hosing, drying, and finally, dry abrasive blasting again.</p>
APPLICATION CONDITIONS:	<p>Use only where application and curing can proceed at temperatures above 10°C/50°F. The temperature of the paint itself should be 15°C/59°F or above to secure proper application properties. In confined spaces provide adequate ventilation during application and drying. Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation.</p>
SUBSEQUENT COAT:	<p>BAJATEX HI-BUILD 14637 or according to specification.</p>
REMARKS:	
Weathering/service temperatures:	<p>The natural tendency of epoxy coatings to chalk in outdoor exposure and to become more service sensitive to mechanical damage and chemical exposure at elevated temperatures is also reflected in this product.</p>
Film thickness:	<p>May be specified in another film thickness than indicated depending on purpose and area of use. This will alter spreading rate and will influence the amount of thinning necessary, drying time and recoating interval. Normal range dry is 25-75 micron/1-3 mils.</p>
Recoating:	<p>Recoating intervals: Minimum (primarily only relevant for container coatings): 20 minutes' flash-off time for 40 micron/1.6 mils BAJAPOX PRIMER 15300 when topcoated with designed container coatings, epoxy, polyurethane, acrylic or CR types. The minimum recoating interval only applies in the case of forced ventilation, proper application and if the completed paint system is thoroughly dry before exposed to aggressive environments. Maximum: Recoating interval for non-immersion services is 24 hours for acrylic or CRs, 3 days for PUs and 1 months at 20°C for epoxies. In the case of long recoating intervals, a completely clean surface is mandatory to ensure intercoat adhesion. Any dirt, oil and grease 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.</p>
Note:	<p>To check whether the quality of the surface cleaning is adequate, a test patch may be relevant. BAJAPOX PRIMER 15300 is for professional use only.</p>
Safety:	<p>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.</p>



بازاک (سهامی خاص)

BAJAPOX ZINC 15360

CURING AGENT 95740

Description: BAJAPOX ZINC 15360 is a two-component polyamide cured zinc-rich epoxy primer. It cures to a hard wearing and highly weather-resistant coating. Offers cathodic protection of local mechanical damage. Zinc content is min. 80% in dry film.

Recommended use: For on-line application on containers. Can be used as a zinc-rich epoxy primer for other purposes according to separate painting specification.

Service temperatures: Maximum, dry: 160°C/320°F, however depending on the subsequent coat.

PHYSICAL CONSTANTS:

Colours/Shade nos: Red-grey/19830
Finish: Semi-flat
Volume solids, %: 50 ± 1
Theoretical spreading rate: 12.5 m²/litre - 40 micron
501 sq.ft./US gallon - 1.6 mils
Flash point: 30°C/86°F
Specific gravity: 2.3 kg/litre - 19.2 lbs/US gallon
Surface dry: 30 minutes at 20°C/68°F (ISO 1517)
Dry to touch: 2 (app.) hours at 20°C/68°F
Fully cured: 7 days at 20°C/68°F
V.O.C.: 455 g/litre - 3.8 lbs/US gallon

APPLICATION DETAILS:

Mixing ratio for 15360: Base 15360 : Curing agent 95740
4 : 1 by volume

Application method:	Airless spray	Air spray	Brush
Thinner (max.vol.):	0845 (30%)	0845 (50%)	0845 (5%)
Pot life:	8 hours (20°C/68°F) (airless spray)		
	8 hours (20°C/68°F)(brush)		
Nozzle orifice:	.017"-.021"		
Nozzle pressure:	150 bar/2200 psi (Airless spray data are indicative and subject to adjustment)		
Cleaning of tools:	BAJAK'S TOOL CLEANER 99610		
Indicated film thickness, dry:	40 micron/1.6 mils (See REMARKS overleaf)		
Indicated film thickness, wet:	75 micron/3 mils		
Recoat interval, min:	3 hours / 20°C with Bajapox qualities		
Recoat interval, max:	30 days / 20°C with Bajapox qualities		

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. Always take precautions against the risks of fire and explosions.

BAJAPOX ZINC 15360

SURFACE

PREPARATION:

Remove oil and grease, etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning.
Abrasive blasting to Sa 2½ with a sharp-edged surface profile corresponding to Rugotest No. 3, BN9a, Keane-Tator comparator, 2.0 G/S or ISO comparator, Medium (G).

APPLICATION

CONDITIONS:

Use only where application and curing can proceed at temperatures above 10°C/50°F when using curing agent 95740 . The temperature of the surface must also be above this limit, 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/59°F or above. 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.

SUBSEQUENT

COAT:

According to specification.

REMARKS:

Certificate is issued under the quality number 15360.

Note: If used as anticorrosive protection under insulation of high temperature equipment it is very important the NO moisture can penetrate during slow-down periods. This to avoid risk of "wet corrosion" when the temperature rises.

Film thicknesses:

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 15-50 micron/0.6-2.0 mils.

Recoating:

Recoating intervals related to later conditions of exposure: Consult separate APPLICATION INSTRUCTIONS.

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

Before recoating after exposure in contaminated environment, clean the surface thoroughly by (high pressure) fresh water hosing and allow to dry. In addition, scrubbing with a stiff brush may be necessary to remove zinc corrosion products (white rust).

Note:

BAJAPOX ZINC 15360 is for professional use only.

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بازاک (سهامی خاص)

BAJAPOX ZINC 15360L

CURING AGENT 95740

Description:	BAJAPOX ZINC 15360L is a two-component polyamide cured zinc-rich epoxy primer. It cures to a hard wearing and highly weather-resistant coating. Offers cathodic protection of local mechanical damage.		
Recommended use:	For on-line application on containers. Can be used as a zinc-rich epoxy primer for other purposes according to separate painting specification.		
Service temperatures:	Maximum, dry: 160°C/320°F, however depending on the subsequent coat.		
PHYSICAL CONSTANTS:			
Colours/Shade nos:	Red-grey/19830		
Finish:	Semi-flat		
Volume solids, %:	50 ± 1		
Theoretical spreading rate:	12.5 m ² /litre - 40 micron 501 sq.ft./US gallon - 1.6 mils		
Flash point:	30°C/86°F		
Specific gravity:	2.05 kg/litre – 17.1 lbs/US gallon		
Surface dry:	30 minutes at 20°C/68°F (ISO 1517)		
Dry to touch:	2 (app.) hours at 20°C/68°F		
Fully cured:	7 days at 20°C/68°F		
V.O.C.:	455 g/litre - 3.8 lbs/US gallon		
APPLICATION DETAILS:			
Mixing ratio for 15360L:	Base 15360L : Curing agent 95740 4 : 1 by volume		
Application method:	Airless spray	Air spray	Brush
Thinner (max.vol.):	08450 (5%)	08450 (30%)	08450 (50%)
Pot life:	8 hours (20°C/68°F) (airless spray) 8 hours (20°C/68°F)(brush)		
Nozzle orifice:	.017"-.021"		
Nozzle pressure:	150 bar/2200 psi (Airless spray data are indicative and subject to adjustment)		
Cleaning of tools:	BAJAK'S TOOL CLEANER 99610		
Indicated dft.:	40 micron/1.6 mils (See REMARKS overleaf)		
Indicated wft.:	75 micron/3 mils		
Recoat interval, min:	As per separate APPLICATION INSTRUCTIONS		
Recoat interval, max:	As per 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. 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.		



باجاک (سهامی خاص)

BAJAPOX ZINC 15360VL

CURING AGENT 95740

Description: BAJAPOX ZINC 15360VL is a two-component polyamide cured zinc-rich epoxy primer. It cures to a hard wearing and highly weather-resistant coating. Offers cathodic protection of local mechanical damage. Zinc content is min. 45% in dry film.

Recommended use: For on-line application on containers. Can be used as a zinc-rich epoxy primer for other purposes according to separate painting specification.

Service temperatures: Maximum, dry: 160°C/320°F, however depending on the subsequent coat.

PHYSICAL CONSTANTS:

Colours/Shade nos: Red-grey/19830
Finish: Semi-flat
Volume solids, %: 49
Theoretical spreading rate: 12.5 m²/litre - 40 micron
501 sq.ft./US gallon - 1.6 mils
Flash point: 30°C/86°F
Specific gravity: 2.12 kg/litre
Surface dry: 30 minutes at 20°C/68°F (ISO 1517)
Dry to touch: 2 (app.) hours at 20°C/68°F
Fully cured: 7 days at 20°C/68°F
V.O.C.: 455 g/litre - 3.8 lbs/US gallon

APPLICATION DETAILS:

Mixing ratio: Base 15360VL : Curing agent 95740
4 : 1 by volume

Application method:	Airless spray	Air spray	Brush
Thinner (max.vol.):	08450 (5%)	08450 (30%)	08450 (50%)
Pot life:	8 hours (20°C/68°F) (airless spray)		
	8 hours (20°C/68°F)(brush)		

Nozzle orifice: .017"-.021"
Nozzle pressure: 150 bar/2200 psi
(Airless spray data are indicative and subject to adjustment)

Cleaning of tools: BAJAK'S TOOL CLEANER 99610
Indicated dft.: 40 micron/1.6 mils (See REMARKS overleaf)
Indicated wft.: 75 micron/3 mils
Recoat interval, min: As per separate APPLICATION INSTRUCTIONS
Recoat interval, max: As per 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. 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.



BAJAPOX 15400

CURING AGENT 95100

بازاک (سهامی خاص)

Description:	BAJAPOX 15400 is a two-component, amine adduct cured epoxy paint, which cures to a coating with excellent resistance to a wide range of chemicals.
Recommended use:	As a tank lining.
Service temperatures:	Dry: In water (no temperature gradient): Maximum: 140°C/284°F 50°C/122°F Wet service temperatures, other liquids: Consult the corresponding CARGO PROTECTION GUIDE.
PHYSICAL CONSTANTS:	
Colours/Shade nos:	White/11000 - Light red/55090
Finish:	Semi-flat
Volume solids, %:	48 ± 1
Theoretical spreading rate:	6.0 m ² /litre - 80 micron 241 sq.ft./US gallon - 3.2 mils
Flash point:	26°C/79°F
Specific gravity:	1.4 kg/litre - 11.7 lbs/US gallon
Surface dry:	3 (approx.) hrs at 20°C/68°F (ISO 1517)
Dry to touch:	8-10 hours at 20°C/68°F
Fully cured:	7 days at 20°C/68°F
V.O.C.:	465 g/litre - 3.9 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 15400:	Base 15400 : Curing agent 95100 4 : 1 by volume
Application method:	Airless spray Brush (touch-up)
Thinner (max.vol.):	10845 (5%) (See APPLICATION INSTRUCTIONS) 10845 (5%)
Pot life:	2 hours (20°C/68°F) 4 hours (20°C/68°F)
Nozzle orifice:	.021"
Nozzle pressure:	200 bar/2900 psi (Airless spray data are indicative and subject to adjustment)
Cleaning of tools:	BAJAK'S TOOL CLEANER 19961
Indicated film thickness, dry:	80 micron/3.2 mils (See REMARKS overleaf)
Indicated film thickness, wet:	175 micron/7 mils
Recoat interval, min:	10 hours (20°C/68°F)
Recoat interval, max:	21 days (20°C/68°F)
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.

BAJAPOX 15400

SURFACE

PREPARATION:

Abrasive blasting to near white metal Sa 2½ with a surface profile corresponding to Rugotest No, BN10, Keane-Tator Comparator, 3.0 G/S, or ISO Comparator, Rough Medium (G). (Please do also see Notes under REMARKS).

APPLICATION

CONDITIONS:

Use only where application and curing can proceed at temperatures above 10°C/50°F. As special curing agent 29599 may be available for curing between 5°C/41°F and 10°C/50°F if required, see Application instructions. The temperature of the surface and that of the paint itself must also be above this limit. Optimal spraying properties are obtained at paint temperatures of 15-25°C/59-76°F. Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. Relative humidity max. 80%, preferably 40-60%. In confined spaces provide adequate ventilation during application and drying.

PRECEDING

COAT:

None, or as per specification.

SUBSEQUENT

COAT:

None, or as per specification.

Film thicknesses:

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 is 80-125 micron/3.2-5 mils. If the maximum recoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion.

Recoating:

Curing:

Do not put tanks into service until the paint system is completely cured - consult the corresponding CARGO PROTECTION GUIDE and APPLICATION INSTRUCTIONS.

In the case of coating potable water tanks, it is a must that all solvents are evaporated and that the system is fully cured before the tanks are taken into use. It is furthermore recommended to fill the tank twice with water, each time for a period of not less than 24 hours, and finally flush with fresh water.

Notes:

This datasheet outlines the main guidelines and recommendations. For details the corresponding PAINTING SPECIFICATION must be consulted and strictly adhered to during execution of the work. The CARGO PROTECTION GUIDE and the corresponding PAINTING SPECIFICATION may be tailored to meet other conditions than stipulated above. Such adjustments may include the degree of surface preparation, conditions of application, dry film thickness, and recoating interval. BAJAPOX 15400 is for professional use only.

**BAJAPOX 15500**

CURING AGENT 97580

بازاک (سهامی خاص)

Description: BAJAPOX 15500 is a two-component, amine adduct cured phenolic epoxy (novolac) paint, which cures to a coating with excellent resistance to a wide range of chemicals as tabulated in separate CARGO PROTECTION GUIDE.

Recommended use: As a tank lining.

Service temperatures:

	Dry:	In water (no temperature gradient):
	Maximum: 160°C/320°F	50°C/122°F

For higher temperatures: see REMARKS overleaf.
Wet service temperatures, other liquids:
Consult the corresponding CARGO PROTECTION GUIDE.

PHYSICAL CONSTANTS:

Colours/Shade nos:	Off-white/11163- Light red/55090
Finish:	Flat
Volume solids, %:	68 ± 1
Theoretical spreading rate:	6.8 m ² /litre - 100 micron 273 sq.ft./US gallon - 4 mils
Flash point:	26°C/79°F
Specific gravity:	1.7 kg/litre - 14.2 lbs/US gallon
Surface dry:	2-3 hrs at 20°C/68°F (ISO 1517)
Dry to touch:	6 (approx.) hours at 20°C/68°F
Fully cured:	10 days at 20°C/68°F (See REMARKS overleaf)
V.O.C.:	325 g/litre - 2.7 lbs/US gallon
Shelf life:	1 year (25°C) from time of production. Depending on storage conditions, mechanical stirring may be necessary before usage.

APPLICATION DETAILS:

Mixing ratio for 15500:	Base 15500 : Curing agent 97580 8.9 : 1.1 by volume 93.8 : 6.2 by weight
Application method:	Airless spray Brush (touch-up)
Thinner (max.vol.):	08450 08450 (See APPLICATION INSTRUCTIONS)
Pot life:	3 hours (20°C/68°F)
Induction time:	15 minutes (20°C/68°F) (see REMARKS overleaf)
Nozzle orifice:	.018"-.021"
Nozzle pressure:	200 bar/2900 psi (Airless spray data are indicative and subject to adjustment)
Cleaning of tools:	BAJAK'S TOOL CLEANER 19961
Indicated film thickness, dry:	100 micron/4 mils (See REMARKS overleaf)
Indicated film thickness, wet:	150 micron/6 mils
Recoat interval, min:	36/24 hours (20°C/68°F)
Recoat interval, max:	21 days (20°C/68°F) (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

BAJAPOX 15500

SURFACE PREPARATION:	For optimum performance to the full range of chemicals in accordance with the main CARGO PROTECTION GUIDE, abrasive blasting to very near white metal Sa 2½-3 with a surface profile corresponding to Rugotest No. 3, BN10, Keane-Tator Comparator 3.0 G/S, or ISO Comparator Rough Medium (G). Consult separate APPLICATION INSTRUCTIONS.
APPLICATION CONDITIONS:	Use only where application and curing can proceed at temperatures above 10°C/50°F. The steel temperature must never drop below this limit until full curing has taken place. The temperature of the paint itself must be above 15°C/59°F, best results are obtained at 17-23°C/62-73°F. Relative humidity max. 80%, preferably 40-60%. Apply on a dry and clean surface with a temperature above the dew point to avoid condensation. Provide adequate ventilation during application and drying in confined spaces. Consult separate APPLICATION INSTRUCTIONS.
PRECEDING COAT:	None.
SUBSEQUENT COAT:	None.
REMARKS:	
FILM THICKNESS:	Minimum total dry film thickness for the system is 300 micron/12 mils. May be specified in higher film thickness than indicated depending on purpose and area of use. This will alter spreading rate and influence drying time. For further information about film thicknesses, see separate APPLICATION INSTRUCTIONS.
Minimum:	Use in contact with potable water, 3 days (20°C/68°F) between each coat 36 hours (20°C/68°F) between 1 and 2 coat 24 hours (20°C/68°F) between 2 and 3 coat
Maximum:	Use without contact with potable water, 21 days (20°C/68°F)
Recoating:	Roughening of the surface is necessary if the maximum recoating interval is exceeded.
Mixing:	The thoroughly mixed BASE and CURING AGENT must be prereacted before application (15 minutes at 20°C/68°F), at other temperatures, please see APPLICATION INSTRUCTIONS.
Thinning:	Keep thinning at an absolute minimum. Do not dilute the components separately - only the mixture.
Curing:	Resistance to the widest range of cargoes is provided by additional heat curing, see APPLICATION INSTRUCTIONS and CARGO PROTECTION GUIDE.
Note:	BAJAK 15500 is for professional use only.

**BAJAPOX 15500A**

CURING AGENT 97580

Description: BAJAPOX 15500A is a two-component, amine adduct cured phenolic epoxy (novolac) paint, which cures to a coating with excellent resistance to a wide range of chemicals as tabulated in separate CARGO PROTECTION GUIDE. As a tank lining.

Recommended use:**Service temperatures:**

Dry: In water (no temperature gradient):
 Maximum: 160°C/320°F 50°C/122°F
 For higher temperatures: see REMARKS overleaf.
 Wet service temperatures, other liquids:
 Consult the corresponding CARGO PROTECTION GUIDE.

PHYSICAL CONSTANTS:

Colours/Shade nos: Off-white/11163- Light red/55090
 Finish: Flat
 Volume solids, %: 68 ± 1
 Theoretical spreading rate: 6.8 m²/litre - 100 micron
 273 sq.ft./US gallon - 4 mils
 Flash point: 26°C/79°F
 Specific gravity: 1.75±5 kg/litre - 14.2 lbs/US gallon
 Surface dry: 2-3 hrs at 20°C/68°F (ISO 1517)
 Dry to touch: 6 (approx.) hours at 20°C/68°F
 Fully cured: 10 days at 20°C/68°F (See REMARKS overleaf)
 V.O.C.: 325 g/litre - 2.7 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 15500A:**

Base 15500A : Curing agent 97580

8.9 : 1.1 by volume

93.8 : 6.2 by weight

Application method:

Airless spray

Brush (touch-up)

Thinner (max.vol.):

08450

08450 (See APPLICATION INSTRUCTIONS)

Pot life:

3 hours (20°C/68°F)

Induction time:

15 minutes (20°C/68°F) (see REMARKS overleaf)

Nozzle orifice:

.018"-.021"

Nozzle pressure:

200 bar/2900 psi

(Airless spray data are indicative and subject to adjustment)

Cleaning of tools:

BAJAK'S TOOL CLEANER 19961

Indicated film thickness, dry:

100 micron/4 mils (See REMARKS overleaf)

Indicated film thickness, wet:

150 micron/6 mils

Recoat interval, min:

36/24 hours (20°C/68°F)

Recoat interval, max:

21 days (20°C/68°F) (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

BAJAPOX 15500A**SURFACE:**

For optimum performance to the full range of chemicals in accordance with the main CARGO

PREPARATION:

PROTECTION GUIDE, abrasive blasting to very near white metal Sa 2½-3 with a surface profile corresponding to Rugotest No. 3, BN10, Keane-Tator Comparator 3.0 G/S, or ISO Comparator Rough Medium (G). Consult separate APPLICATION INSTRUCTIONS.

APPLICATION CONDITIONS:

Use only where application and curing can proceed at temperatures above 10°C/50°F. The steel temperature must never drop below this limit until full curing has taken place. The temperature of the paint itself must be above 15°C/59°F, best results are obtained at 17-23°C/62-73°F. Relative humidity max. 80%, preferably 40-60%. Apply on a dry and cleansurface with a temperature above the dew point to avoid condensation. Provide adequate ventilation during application and drying in confined spaces.

Consult separate APPLICATION INSTRUCTIONS.

PRECEDING COAT:

None.

SUBSEQUENT COAT:

None.

Film thicknesses:

Minimum total dry film thickness for the system is 300 micron/12 mils. May be specified in higher film thickness than indicated depending on purpose and area of use. This will alter spreading rate and influence drying time. For further information about film thicknesses, see separate APPLICATION INSTRUCTIONS.

Recoating:

Minimum: Use in contact with potable water: 3 days (20°C/68°F) between each coat

Use without contact with potable water:

36 hours (20°C/68°F) between 1 and 2 coat

24 hours (20°C/68°F) between 2 and 3 coat

Maximum: 21 days (20°C/68°F)

Roughening of the surface is necessary if the maximum recoating interval is exceeded.

Mixing:

The thoroughly mixed BASE and CURING AGENT must be prereacted before application (15 minutes at 20°C/68°F), at other temperatures, please see APPLICATION INSTRUCTIONS.

Thinning:

Keep thinning at an absolute minimum. Do not dilute the components separately - only the mixture.

Curing:

Resistance to the widest range of cargoes is provided by additional heat curing, see APPLICATION INSTRUCTIONS and CARGO PROTECTION GUIDE.

Note:

BAJAK 15500A is for professional use only.



Product Data

APPLICATION INSTRUCTIONS

For product description refer to the product data sheet

BAJAPOX 15500

CURING AGENT 97580

Scope:

These application instructions cover surface preparation, application equipment, and application of BAJAPOX 15500 as a tank coating.

The following are general rules, which may be supplemented with more detailed descriptions when needed, for instance for major newbuildings/new constructions or extensive repair jobs.

Steel work:

All welding seams must have a surface finish which ensures that the quality of the paint system will be maintained in all respects. Holes in weldings seams, undercuts, cracks, etc. should be avoided. If found, they must be remedied by welding and/or grinding.

All welds must be complete and continuous which will otherwise cause coating discontinuity.

All weld spatters must be removed.

All sharp edges must be removed or rounded off in such a way that the specified film thickness can be build-up on all surfaces. The radius of the rounding should be approximately 1-2 mm.

The steel must be of first class quality and should not have been allowed to rust more than corresponding to grade B of ISO 8501-1:1988. Any laminations must be removed.

All steel work (including welding, flamecutting, grinding) must be finished before the surface preparation starts.

Surface preparation:

Prior to abrasive blast cleaning of the steel, remove oil, grease, salts and other contamination with a suitable detergent followed by high pressure fresh water hosing. Alkali deposits on new welding seams as well as soap traces from pressure testing of tanks to be removed by fresh water and scrubbing with stiff brushes.

Control for absence of contamination according to separate guidelines.

On repair jobs, a rough blasting to remove all loosely adhering materials may be required before degreasing/washing is carried out.

Old steel: Even after a very thorough tank cleanings, pits may typically contain contamination in the form of remnants of old cargoes as well as water soluble salts. For this reason, repeated detergent washing plus abrasive blasting may be necessary. After the first blasting, a very thorough vacuum cleaning is carried out in order to see if any "cargo bleeding" occurs as well as controls for water soluble salts are made. Reference is made to separate instructions. Special care should be taken in evaluating pitted areas.

Grit blast to min Sa 2½, ISO 8501-1:1988.

To obtain full chemical resistance according to the CARGO PROTECTION GUIDE, the steel surface must be abrasive blast cleaned according to ISO 8501-1:1988, very near to white metal Sa 2½-Sa 3. In practice, this requirement is to be understood as white metal Sa 3 at the moment of abrasive blasting, but allows a slight reduction at the moment of paint application.

The resulting surface profile must be equivalent to Rugotest No. 3, min. BN 10, Keane-Tator Surface Comparator, G/S min. 3.0 or ISO/DIS 8503/1 rough MEDIUM (G).

BAJAPOX 15500

Use steel grit, aluminium silicate, or similar sharp edged abrasives of a good quality free of foreign matters, soft particles, and the like. Control for possible contamination according to separate guidelines.

In case steel grit is used this must furthermore be controlled so that a proper grain size distribution is maintained.

Steel grit with particle sizes of 0.2 - 1.2 mm or aluminium silicate of 0.4 - 1.8 mm will usually create the desired surface profile when the air pressure measured at the nozzle is 6 - 7 bar/85 -100 psi.

The compressed air must be dry and clean. The compressor must be fitted with suitable oil and water traps.

When the abrasive blasting is completed, remove residual grit and dust by vacuum cleaning. Abrasive particles not removed by vacuum cleaning are to be removed by brushing with clean brushes followed by vacuum cleaning.

The importance of systematic working must be stressed when blasting. Poorly blasted areas covered with dust are very difficult to locate during the blast inspection made after the rough cleaning.

Shopped and previously painted surfaces: All shopprimer or existing coating materials to be completely removed. Avoid the use of zinc shopprimer whenever possible.

However, if the steel is shopped with zinc, it is very important that **all** zinc is removed by abrasive blast cleaning. Separate check procedures will be necessary to demonstrate the effectiveness of removal. More blast cleaning may be deemed necessary! Use of a red zinc shopprimer will facilitate the visual check of the blast cleaning and is considered necessary in order to obtain an acceptable surface preparation.

Note: Degree of steelwork finish and surface preparation are more detailed described in BAJAK's Technical Standard for Tank Coating Work.

Application equipment:

BAJAPOX 15500 is to be applied by airless spray equipment. Stripe coating and minor repairs can be carried out by brushing.

Airless spray equipment: A large pump is preferred, with a pump capacity of 8-12 litres/minute.

Pump ratio:	Min. 45:1
Nozzle orifice:	.018"-.021"
Nozzle pressure:	200 bar (2900 psi)
Hoses:	To avoid excessive loss of pressure in long hoses, hoses with an internal diameter of up to 0.5" can be used

(Spray data are indicative and subject to adjustment).

Thinning:

If required: max. 10% of THINNER 08450, possibly higher if tendency to dust-spray will require more thinning eg at higher temperatures. Thinning should only be at the required level to avoid possible risk of solvent entrapment.

Only add thinner to the mixed paint.

Cleaning of equipment:

The whole equipment to be cleaned thoroughly with BAJAK'S TOOL CLEANER 99610 after use.



Product Data

BAJAPOX 15500

Mixing, pot life:

- Mix the entire content of corresponding base and curing agent packings. If it is necessary to mix smaller portions, this must be done properly by either weighing base and curing agent in the prescribed weight ratio: 93.8 parts by weight of base and 6.2 parts by weight of curing agent or by volume: 8.9 parts by volume base and 1.1 parts by volume curing agent.
- Stir the mixed paint thoroughly by means of a clean mechanical mixer until a homogeneous mixture is obtained.
- Allow the mixed paint to prereact before application, see table below.**
- Use all mixed paint before the pot life is exceeded. The pot life depends on the temperature of the paint as shown in table below (valid for a 20 litres can):

Temperature of mixed paint	(15°C/59°F ¹⁾)	20°C/68°F	25°C/77°F	(30°C/86°F ²⁾)
Induction time	(25 minutes)	15 minutes	10 minutes	(5 minutes)
Pot life	(4 hours)	3 hours	2 hours	(1 hour)

- At 15°C/59°F and below, the viscosity can be too high for airless spray application.
- Temperatures at 30°C/86°F and above should be avoided due to a risk of dry-spray.

Application procedure:

The first full coat is usually applied immediately after vacuum cleaning. The first stripe coat afterwards.

Film-build/continuity: With this tank coating intended for aggressive cargoes, it is of special importance that a continuous, pinhole-free paint film is obtained at application of each coat. An application technique which will ensure good film formation and no dry-spray on **all** surfaces must be adopted.

It is very important to use nozzles of the correct size, ie not too big. Select small nozzles for spray application of complicated structures, while bigger nozzles may be used for regular surfaces.

A proper, uniform distance of the spray gun to the surface, 30-50 cm, should be aimed at. To obtain good and steady atomizing, the viscosity of the paint must be suitable and the spray equipment must be sufficient in output pressure and capacity. At high working temperatures, use of extra thinner may be necessary to avoid dust-spray.

The paint layer must be applied homogeneously and as close to the specification as possible. The consumption of paint must be controlled and heavy layers must be avoided because of the risk of sags and cracks and solvent retention.

Furthermore, great care must be taken to cover edges, openings, rear sides of stiffeners etc. Thus, on these areas a stripecoat will usually be necessary.

The finished coating must appear as a homogeneous film with a smooth surface and irregularities such as dust, dry spray, abrasives, must be remedied.

Note: In the case of old, pit corroded steel, application of a diluted, extra first coat is recommended to obtain better "penetration" in the fine pits. For this purpose, it is relevant to dilute 5-10%. Application by brush is recommended and film thickness so low that the surface is "saturated" only.

Stripe coating:

All places difficult to cover properly by spray application should be stripe coated twice by brushing immediately before the spray application. Typically, first stripe coat is applied after the first full coat and the second stripe coat after the second full coat.

The second stripe coat with brush can be replaced with spray application with a small narrow nozzle, but still air slots and similar and possible undercuts (welds) and the like will require brush application.

Film thicknesses:

The final dry film thickness of the three coat system must be between 300-600 micron (450 below 15°C)/12-24 (18 below 59°F) mils.

BAJAPOX 15500

Corresponding to 100 micron/4 mils dry film thickness, the wet film thickness must be 150-175 micron/6-7 mils and must be measured regularly.

Normally up to 200 micron/8 mils per coat may be accepted for 100 micron/4 mils specifications, but **at temperatures below 15°C/59°F, it is important not to exceed 150 micron/6 mils in any area.**

Micro climate:

The actual climate conditions at the substrate during application:

The minimum surface temperature is 10°C/50°F.

To ensure an all-over steel temperature of minimum 10°C/50°F, special attention should be paid to possible "cold bridges" eg stiffeners on deck.

In case of steel temperatures lower than 10°C/50°F there is a severe risk of incomplete curing, resulting in a too open film with reduced chemical resistance.

When the outside temperature is lower than 10°C/50°F, it is therefore recommended to use insulation mats on deck and in addition to aim at a general steel temperature of 15°C/59°F to minimise the risk of (locally) too low steel temperatures.

Furthermore, the steel temperature should be kept reasonably constant - within the range of $\pm 3^{\circ}\text{C}/37^{\circ}\text{F}$ is recommended. Any changes of the outside temperature should therefore be carefully monitored and heating equipment calibrated accordingly.

A sudden drop of the steel temperature shortly after application will result in solvent entrapment and will cause a dry film containing vacuoles, ie resulting in reduced performance.

The maximum surface temperature should preferably be below approximately 30°C/86°F. In a warm climate it is recommended to carry out application during nighttime. Application at high temperatures, up to approximately 40°C/105°F, is possible, but extra care must be taken to avoid poor film formation and excessive spray dust.

The steel temperature must be above the dew point. As a rule of thumb, a steel temperature which is 3°C/5°F above the dew point can be considered safe.

In confined spaces, supply an adequate amount of fresh air during application and drying to assist the evaporation of solvent.

Drying and curing, ventilation:

In a dry film thickness of 100 micron/4 mils, with a steel temperature of 20°C/68°F, a relative air humidity of maximum 80% and adequate ventilation, BAJAPOX 15500 will be dry to touch after 4-6 hours. Under these drying conditions, the paint film will accept light traffic after approximately 16 hours.

Correct film formation depends on an adequate ventilation during drying.

A good guideline for tank coating work is to ventilate to a calculated 10% of LEL during application and until the coating is dry.

One litre undiluted BAJAPOX 15500 gives off in total 82 litres solvent **vapour** until it is completely dry.

The lower explosive limit, LEL, is 1.0%.

To reach a common safety requirement of 10% LEL, the theoretical ventilation requirement is 82 m³ per litre paint.

Because solvent vapours are heavier than atmospheric air, effective ventilation requires forced ventilation with exhaust from the lowest part of the tank.

During the following period until full curing a few air shifts per hour will suffice. Take actions to avoid "pockets" of stagnant air.

Please contact BAJAK for further advice.



Product Data

BAJAPOX 15500

Actual safety precautions may require stronger ventilation.

Curing time:

Provided that adequate ventilation, recommended relative humidity, specified film thickness, and recommended minimum recoating interval are kept, the following curing times are valid:

Steel temperature	10°C/50°F	15°C/59°F	20°C/68°F	25°C/77°F	30°C/86°F	(35°C/95°F)*
Curing time	18 days	14 days	10 days	8 days	7 days	(6 days)

*Avoid application at elevated temperatures to avoid dry-spray and poor film formation.

Post curing:

Postcuring must take place within 3 months after final acceptance of the coating/delivery of the vessel.

Postcuring is accomplished by carrying a hot cargo of mineral lube oil, vegetable oil or animal oil at 60°C/140°F for 5 days or at 50°C/122°F for 10 days.

Postcuring may also be accomplished by carrying clean seawater of minimum 45°C/113°F and maximum 50°C/122°F **provided all adjacent ballast tanks are empty and all adjacent cargo tanks are either empty or carrying a liquid cargo of minimum 40°C/104°F**. In case of seawater, postcuring time is 14 days.

Recoating intervals:

Provided observance of the above stated ventilation and relative humidity the following recoating intervals in relation to the (steel) temperature are valid:

Steel temperature	10°C/50°F	15°C/59°F	20°C/68°F	25°C/77°F	30°C/86°F
Not to be used for potable water:					
Minimum after the first coat	90 hours	60 hours	36 hours	24 hours	18 hours
after the second coat	60 hours	40 hours	24 hours	16 hours	12 hours
Maximum:	53 days	36 days	21 days	14 days	11 days

The maximum relative humidity before and between the coats should not exceed 80% and the steel temperature should always be above the dew point, in practice minimum 3°C/5°F above the dew point.

Conditions for paint application work:

Dry spray is not acceptable as this will reduce the protective characteristics of the paint and make later tank cleaning difficult. Dry spray can be avoided by using adequate stagings, spraying equipment and methods.

Hold spray gun at a right angle to and about 30-50 cm from surface making even parallel passes at a rate to produce the specified wet film thickness as per specification.

Avoid dry spray (overspray creating excessive paint mist), e.g. by using a smaller fan angle, and the lowest possible pressure. A small fan angle should also be used, if spray application is used, for "stripe coating" or for instance reverse sides of stiffeners.

Each layer must be applied homogeneously and as near above the specification of 100 micron/4 mils dry film thickness, as possible. The consumption of paint must be controlled, and heavy layers must be avoided because of the risk of sagging, cracks and solvent retention.

Surface irregularities such as dry spray, saggings, exaggerated thickness or embedded dust or abrasives will have to be remedied.

If a sandpapering between layers, for instance on the bottom, is needed, great care must be taken to avoid damage of otherwise intact surfaces. When using mechanical means only lightweight equipment should be used, orbital sander is recommended. Yet, avoid sandpapering on top of welds or irregularities or near to vertical surfaces.

BAJAPOX 15500

The finished coating must appear as a homogeneous surface without pores, runners or contamination of any kind.

Control of dry film thicknesses:

For the standard specification the following applies to the dry film thickness:

The minimum dry film thickness is 300 micron/12 mils, the maximum thickness is approximately 600 micron/24 mils (below 15°C/59°F: 450 micron/18 mils). The minimum dry film thickness is evaluated according to the "80-20" rule, ie no more than 20% of the total number of individual measurements must be lower than the minimum dry film thickness, and the lowest individual measurement must be at least 80% of the minimum dry film thickness, ie 240 micron/9.6 mils. Dry film thickness control is not to be carried out within the first 24 hours after application of final coat (20°C/68°F, sufficient ventilation). The measurement must be carried out using an electromagnetic dry film thickness gauge calibrated with shims placed on a smooth steel substrate. The maximum dry film thickness can also be evaluated according to the "80-20" rule.

Taking into use:

Do not use the tank before the coating is properly cured. Reference is made to curing time on page 5. When cured, but before taking the tank into use for **potable water**, fill twice with water each time for a period of no less than 24 hours and finally flush with fresh water.

Repairs:

It is of great importance that all damage to the coating is repaired.

Repair must be started up as soon as possible. Repair of mountings for stagings, etc. must take place in connection with the dismantling of the stagings, the tempo of which shall be adjusted to the touch-up procedure.

It is important that the repaired areas, as well as the rest of the coated areas, are fully cured before the tank is taken into use or washed by the tank cleaning system.

The extent of damage to the coating can be evaluated by a seawater test. Wash the tanks with clean seawater by means of the tank cleaning machines until profiles and/or heating coils on tanktop is covered. Allow the water to stay for minimum 3 days, after which period the tank is emptied and cleaned with clean fresh water to remove salts.

The repair process:

General: Before mechanical treatment is started, surfaces to be repaired have to be cleaned for any salts and other contamination.

Areas less than 5 x 5 cm.

The surface preparation can be executed by grinding to a clean rough metal surface, feathering edges of intact coating and slightly sanding the adjacent surface.

Clean and wash with BAJAK'S THINNER 08450.

Touch-up by brush to full film thickness with minimum 4 coats of BAJAPOX 15500

Areas up to 1 sq.m.

The surface preparation must be executed by vacuum blasting or open nozzle blasting so that the steel has a proper roughness and a cleanliness to Sa 3 according to ISO 8501:1988. The overlapping zone must be sanded or sweep blasted to ensure a good adhesion of the new paint.

Clean and wash with BAJAK'S THINNER 08450.

Touch-up by brush to full film thickness with minimum 4 coats or by spray 3 coats BAJAPOX 15500

Areas more than 1 sq.m. or areas where several damaged spots are concentrated.

Treatment: Repeat the original specification.



Product Data

BAJAPOX 15500**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.



بازاک (سهامی خاص)

BAJAPOX 15520

CURING AGENT 95080

Description: BAJAPOX 15520 is a two-component, polyamide cured epoxy paint.

Recommended use: As an intermediate coat on zinc silicates to minimize popping. BAJAPOX 15520 may also be used as a sealer coat on metal sprayed surfaces.

PHYSICAL CONSTANTS:

Colours/Shade nos:	Red/55089
Finish:	Flat
Volume Solids, %:	22%
Theoretical spreading rate:	8.8 m ² /litre - 25 microns 359sq.ft./US gallon - 1 mil
Flash point:	30°C/86°F Abel-Pensky, closed cup
Specific gravity:	1.1 kg/litre 9.2 lbs/US gallon
Surface dry:	0.5 (approx) hour at 20°C/68°F (ISO 1517)
Dry to touch:	1 (approx) hour at 20°C/68°F
Fully cured:	7 days at 20°C/68°F
Shelf life:	1 year at 20°C/68°F
V.O.C.:	715 g/litre. 6.0 lbs /US gallon

APPLICATION DETAILS:

Mixing ratio for 15520:	BASE: BAJAPOX 15520 2.0 parts by volume CURING AGENT: 95080 1.0 part by volume
Application method:	Airless spray
Thinner (max.vol.):	10870 (20%) (See REMARKS overleaf)
Pot life:	8 hours (20°C/68°F)(Nozzle Orifice: 0.021"
Nozzle pressure:	75 bar/1100 psi (Airless spray data are indicative and subject to adjustment)
Cleaning of tools:	BAJAK'S TOOL CLEANER 19961
Indicated film thickness, dry:	Indicated film thickness, wet: 125 microns/5 mils 25 microns/1 mil (See REMARKS overleaf)
Recoat interval, min:	6 hours (20°C/68°F)
Recoat interval, max:	none (See REMARKS overleaf)

Issued: March 2004

2. BAJAPOX 15520

SURFACE PREPARATION:	BAJAPOX 15520 can be applied when the "near-to-cured" stage of the ZINCSIL is reached. For ZINCSIL qualities such as 11570 - properly applied in 50 microns d.f.t. -this stage is reached after 24 hours at 20°C/68°F and 75% RH. Remove oil and grease etc., with suitable detergent. Remove salt and other contaminants by high pressure fresh water cleaning. After exposure to high humidity, zinc salts, "white rust" will have to be Carefully removed by high pressure fresh water cleaning, if necessary combined with scrubbing with stiff nylon brushes. Consult APPLICATION INSTRUCTIONS for the relevant ZINCSIL.
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 temperature. 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:	BAJAK'S ZINCSIL qualities according to specification.
SUBSEQUENT COAT:	BAJAPOX, BAJANOL, BAJATEX, or BAJATHANE qualities according to specification.
REMARKS:	Service Temperatures: Dry service temperature: max 60°C/140°F. Dry peak temperature: max. 80°C/175°F.
THINNING:	Should always be diluted at least 10% with THINNER 0870 for optimized anti-popping properties.
FILM THICKNESS:	May be specified in another film thickness than indicated depending on purpose and area of use. Normal range is 20-40 microns/0.8-1.6 mils. This will alter spreading rate and may influence amount of thinning necessary, drying time and recoating interval. Excessive film thickness should be avoided. Maximum dry film thickness recommended is 40 microns/1.6 mils.
Recoating Interval:	The use of BAJAPOX 15520 as a "sealer coat on zinc silicate" is primarily intended in case of a recoating interval between the "sealer coat" and the subsequent coat being of medium length. In case of short recoating interval of BAJAPOX 15520, ie: less than 3 days at 20°C/68°F and 75% RH, then the zinc silicate must be fully cured (see relevant product data sheet) before BAJAPOX 15520 is applied. After prolonged exposure of the zinc silicate to polluted atmosphere, remove accumulated contamination with suitable detergent, followed by high pressure fresh water cleaning and/or scrubbing and allow to dry. Observe that long time exposure of the not fully coated system (ie zinc silicate plus BAJAPOX 15520 only) to humid environment may cause "white rust" to develop beneath the thin paint film of 15520
V.O.C:	The Volatile Organic Compounds are 715 g/ltr, 6.0 lbs/US gallon.
Note:	Before over coating after exposure in contaminated environment, clean surface thoroughly by high pressure water cleaning and allow to dry. BAJAPOX 15520 is for professional use only.
Safety:	Packings are provided with applicable safety labels which should be observed. In addition, national or local safety regulations should be followed. As a general rule, inhalation of solvent vapours or paint mist, and contact of liquid paint with skin and eyes, should be avoided. Forced ventilation should be provided when applying pain in confined spaces or stagnant air. Even when ventilation is provided, respiratory, skin, and eye protection are always recommended when spraying paint.

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/: Ammonium chloride or any other passivation agent should not be present on the surface when coating the galvanized surface.
Surface preparation: Water should not be used for coating down the steel.

Application: Cleaning of steel should not be initiated unless the steel temperature is below 30°C/86°F.
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 .**

**BAJAPOX HI-BUILD 15570**

curing agent 95570

Description: BAJAPOX HI-BUILD15570 is a two-component, polyamide-adduct cured epoxy paint, which cures to a strong and highly corrosion resistant coating at temperatures down to -10°C/14°F. The Micaceous Iron Oxide pigmented light grey quality is also well suited for application under humid conditions, on damp steel surfaces, and may be applied on moist surfaces.

Recommended use:

1. As a maintenance and repair primer, intermediate, and/or finishing coat in BAJAPOX systems in severely corrosive environment. As a finishing coat where a cosmetic appearance is of less importance.
2. As a low temperature curing epoxy primer, intermediate, and/or finishing coat in paint systems according to specification. Well suited as a (blast) primer in coal tar epoxy systems.

Service temperature:

Dry: Maximum 140°C/284°F (See REMARKS overleaf)
 Ballast water service: Resists normal ambient temperature at sea*
 Other water service: 40°C/104°F (no temperature gradient)
 Other liquids: Contact BAJAK
 * Avoid long-term exposure to negative temperature gradients

PHYSICAL CONSTANTS:

Colours: Light grey (MIO) - Red
 Finish: Flat
 Volume Solids, %: 54 ± 1
 Theoretical spreading rate: 5.4 m²/litre – 100 micron
 217 sq.ft./US gallon – 4 mils
 Flash point: 25°C/77°F
 Specific gravity: 1.4 kg/litre – 11.7 lbs/US gallon
 Dry to touch: 3-4 (approx) hours at 20°C/68°F
 Fully cured: 7 days at 20°C/68°F
 V.O.C.: 430 g/litre – 3.6 lbs/US gallon
 Shelf life: 1 year (25°C) from time of production. Depending on storage conditions, mechanical stirring may be necessary before usage.

APPLICATION DETAILS:

Mixing ratio : Base 15570 : Curing agent 95570
 3 : 1 by volume

Application method:	Airless spray	Air spray	Brush
Thinner (max.vol.):	08450 (5%)	08450 (15%)	08450 (5%)
Pot life:	2 hours (25°C/68°F)		
Nozzle orifice:	.019" - .021"		
Nozzle pressure:	175 bar/2500 psi (Airless spray data are indicative and subject to adjustment)		
Cleaning of tools:	BAJAK'S TOOL CLEANER 99610		
Indicative dft:	100 micron/4 mils (See REMARKS overleaf)		
Indicative wft:	200 micron/8 mils		
Recoat interval, min:	As per separate APPLICATION INSTRUCTIONS		
Recoat interval, max:	As per 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 HI-BUILD 15570

SURFACE PREPARATION:	<p>New steel (dry conditions): Abrasive blasting to Sa2½ . 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 15570.</p> <p>Light alloys: Thorough degreasing and (light) abrasive sweeping to remove contamination and to secure adhesion – surface profile depending on later exposure.</p> <p>Stainless steel: (Eg ballast tanks of chemical carriers) to be abrasive blast cleaned to a uniform, sharp, dense profile (Rugotest No. 3, BN9a, ISO comparator Medium (G), Keane-Tator comparator 2.0 G/S) corresponding to Rz minimum 50 micron. Any salts, grease oil, etc. to be removed before abrasive blasting is commenced.</p> <p>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 (minor areas) or by abrasive blasting to minimum Sa 2, preferably to Sa 2½. Improved surface preparation will improve the performance of BAJAPOX HI-BILD 15570. As an alternative to dry cleaning, water jetting to minimum WJ-3, preferably WJ-2 (NACE No. 5/SSPC-SP 12), may be used. A flash-rust degree of FR-1 maximum FR-2 is acceptable before application. Feather edges to sound and intact areas. Dust off residues. Touch up bare spots to full film thickness when the surface has reached the condition of being damp, may be moist.</p> <p>In case of wet abrasive blasting a suitable inhibitor may be used. Surplus inhibitor and residual abrasives and sludge must be removed by (high pressure) fresh water cleaning before recoating cleaning with hot water is recommended.</p> <p>Note 1: Inhibitors are generally not recommended for surfaces which will be immersed during service.</p> <p>Note 2: Damp surfaces: Water is not readily detectable, but the temperature of the surface is below the dew point. Moist surfaces: pools of water and droplets have been removed, but there is a noticeable film of water. Wet surfaces: Droplets or pools of water are present.</p>
APPLICATION CONDITIONS:	<p>Use only where curing can proceed at temperatures above -10°C/14°F.</p> <p>At the freezing point and below be aware of the risk of ice on the surface, which will hinder the adhesion.</p> <p>The temperature of the paint itself should be 15°C/60°F or above to secure proper application properties.</p> <p>In confined spaces provide adequate ventilation during application and drying.</p> <p>Occurrence of standing water or droplets on the painted surface immediately after application may result in discolouration.</p>
PRECEDING COAT:	None, or according to specification.
SUBSEQUENT COAT:	None, BAJAPOX , BAJATHANE , BAJATEX or BAJACRYL as per specification.
REMARKS: 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:	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 is 50-125 micron/2-5 mils.
Recoating:	Recoating 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 recoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion.
Note:	BAJAPOX HI-BUILD 15570 is for professional use only.



Product Data

APPLICATION INSTRUCTIONS

For product description refer to the product data sheet

BAJAPOX 15570

CURING AGENT 95570

Physical data versus temperature:

Drying time and recoating interval vary with film thickness, temperature and later exposure conditions, thus: **In-field application:**
(100 micron/4 mils dry film thickness of BAJAPOX 15570)

Surface temperature	-10° C/14° F	0° C/32° F	10° C/50° F	20° C/68° F	30° C/86° F
Drying time, approx	36 hours	16 hours	8 hours	4 hours	3 hours
Curing time, approx	2 months	1 month	14 days	7 days	5 days
MINIMUM recoating interval related to later conditions of exposure:					
Interval for recoating with BAJATEX HI-BUILDS and 58030 (10° C/50° F or higher in the case of 58030)					
Atmospheric, medium	18 hours	9 hours	4 hours	2 hours	1½ hours
Atmospheric, severe	36 hours	18 hours	8 hours	4 hours	3 hours
Interval for recoating with BAJAPOX and BAJATHANE qualities					
Atmospheric, medium	36 hours	18 hours	8 hours	4 hours	3 hours
Atmospheric, severe	36 hours	18 hours	8 hours	4 hours	3 hours
Immersion**	3 days	36 hours	16 hours	8 hours	6 hours
MAXIMUM recoating interval related to later conditions of exposure:					
Interval for recoating with BAJATEX HI- BUILDS					
Atmospheric, medium	3 days	36 hours	16 hours	8 hours	6 hours
Atmospheric, severe	2 days	23 hours	10 hours	5 hours	4 hours
Interval for recoating with 58030					
Atmospheric, medium	Not relevant	Not relevant	6 days	3 days	1 day
Atmospheric, severe	Not relevant	Not relevant	3 days	1½ days	1 day
Interval for recoating with BAJAPOX qualities					
Atmospheric, medium	None	None	None	None	None
Atmospheric, severe	None	None	None	None	None
Immersion**	(90 days)	(90 days)	60 days	30 days	23 days
Interval for recoating with BAJATHANE qualities					
Atmospheric					
Medium	90 days	45 days	20 days	10 days	5 days
Severe	27 days	14 days	6 days	3 days	1½ days

** NOT relevant for BAJATHANE qualities.

*** Depending on actual local conditions, extended maximum recoating intervals may apply. Please contact BAJAK for further advice.

Furthermore, please see page 2.

BAJAPOX 15570

Workshop application:

(75 micron/3 mils dry film thickness of BAJAPOX 15570)

Surface temperature	10°C/50°F	20°C/68°F	30°C/86°F
Drying time, approx	4 hours	2 hours	1½ hours
Curing time, approx	14 days	7 days	5 days
MINIMUM recoating interval related to later conditions of exposure:			
Interval for recoating with BAJATEX HI-BUILDS 58030			
Atmospheric, medium	30 minutes	15 minutes	10 minutes
Atmospheric, severe	4 hours	2 hours	1½ hours
Interval for recoating with BAJAPOX and BAJATHANE qualities			
Atmospheric, medium	4 hours	2 hours	1½ hours
Atmospheric, severe	4 hours	2 hours	1½ hours
Immersion*	16 hours	8 hours	6 hours

* NOT relevant for BAJATHANE qualities

Maximum recoating intervals according to preceding table, page 1.

Maximum recoating intervals:

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 15570 within the above directions for recoating.

Long recoating intervals:

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 etting 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.

The short minimum recoating intervals when overcoated with 46330, 46370, 46410 and 58030, BAJAPOX and BAJATHANE in case of workshop application, are only possible if the finished paint system is through dry before exposure to the environment.

Before recoating after exposure in contaminated environment, irrespective of recoating interval, clean surface thoroughly e.g. by (high pressure) fresh water hosing and allow to dry.

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.

**BAJAPOX 15570L**

curing agent 95570L

Description: BAJAPOX 15570L is a two-component, polyamide cured epoxy paint, which cures to a strong and highly corrosion resistant coating at temperatures down to -10°C/14°F. The Micaceous Iron Oxide pigmented light grey quality is also well suited for application under humid conditions, on damp steel surfaces, and may be applied on moist surfaces.

Recommended use: As a maintenance and repair primer, intermediate, and/or finishing coat in BAJAPOX systems in severely corrosive environment. As a finishing coat where a cosmetic appearance is of less importance.

Service temperature:

Dry:	Maximum 140°C/284°F (See REMARKS overleaf)
Ballast water service:	Resists normal ambient temperature at sea*
Other water service:	40°C/104°F (no temperature gradient)
Other liquids:	Contact BAJAK

* Avoid long-term exposure to negative temperature gradients

PHYSICAL CONSTANTS:

Colours/Shade no:	Light redish grey (MIO)
Finish:	Flat
Volume Solids, %:	49 ± 1
Theoretical spreading rate:	5 m ² /litre – 100 micron 217 sq.ft./US gallon – 4 mils
Flash point:	25°C/77°F
Specific gravity:	1.4 kg/litre – 11.7 lbs/US gallon
Dry to touch:	3-4 (approx) hours at 20°C/68°F
Fully cured:	7 days at 20°C/68°F
V.O.C.:	430 g/litre – 3.6 lbs/US gallon

APPLICATION DETAILS:

Mixing ratio for 15570L:	Base 15570L : Curing agent 95570L 7.5 : 1 by weight , 4.4 : 1 by volume		
Application method:	Airless spray	Air spray	Brush
Thinner (max.vol.):	08450 (5%)	08450 (15%)	08450 (5%)
Pot life:	5 hours (25°C/68°F)		
Nozzle orifice:	.019" - .021"		
Nozzle pressure:	175 bar/2500 psi (Airless spray data are indicative and subject to adjustment)		
Cleaning of tools:	BAJAK'S TOOL CLEANER 99610		
Indicative dft:	100 micron/4 mils		
Indicative wft:	200 micron/8 mils		
Recoat interval, min:	As per separate APPLICATION INSTRUCTIONS		
Recoat interval, max:	As per 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 15570L

SURFACE PREPARATION:	<p>New steel (dry conditions): Abrasive blasting to Sa2½ . 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 15570L.</p> <p>Light alloys: Thorough degreasing and (light) abrasive sweeping to remove contamination and to secure adhesion – surface profile depending on later exposure.</p> <p>Stainless steel: (Eg ballast tanks of chemical carriers) to be abrasive blast cleaned to a uniform, sharp, dense profile (Rugotest No. 3, BN9a, ISO comparator Medium (G), Keane-Tator comparator 2.0 G/S) corresponding to Rz minimum 50 micron. Any salts, grease oil, etc. to be removed before abrasive blasting is commended.</p> <p>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 (minor areas) or by abrasive blasting to minimum Sa 2, preferably to Sa 2½. Improved surface preparation will improve the performance of BAJAPOX 15570L . As an alternative to dry cleaning, water jetting to minimum WJ-3, preferably WJ-2 (NACE No. 5/SSPC-SP 12), may be used. A flash-rust degree of FR-1 maximum FR-2 is acceptable before application. Feather edges to sound and intact areas. Dust off residues. Touch up bare spots to full film thickness when the surface has reached the condition of being damp, may be moist.</p> <p>In case of wet abrasive blasting a suitable inhibitor may be used. Surplus inhibitor and residual abrasives and sludge must be removed by (high pressure) fresh water cleaning before recoating cleaning with hot water is recommended.</p> <p>Note 1: Inhibitors are generally not recommended for surfaces which will be immersed during service.</p> <p>Not 2: Damp surfaces: Water is not readily detectable, but the temperature of the surface is below the dew point. Moist surfaces: pools of water and droplets have been removed, but there is a noticeable film of water. Wet surfaces: Droplets or pools of water are present.</p>
APPLICATION CONDITIONS:	<p>Use only where curing can proceed at temperatures above 10°C/50°F.</p> <p>The temperature of the paint itself should be 15°C/60°F or above to secure proper application properties.</p> <p>In confined spaces provide adequate ventilation during application and drying.</p> <p>Occurrence of standing water or droplets on the painted surface immediately after application may result in discolouration.</p>
PRECEDING COAT:	None, or according to specification.
SUBSEQUENT COAT:	None, BAJAPOX , BAJATHANE , BAJATEX or BAJACRYL as per specification.
REMARKS: Weathering/ service temperature:	<p>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.</p>
Film thicknesses:	<p>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.</p> <p>Normal range is 50-125 micron/2-5 mils.</p>
Recoating:	<p>Recoating intervals related to later conditions of exposure. Consult separate APPLICATION INSTRUCTIONS.</p> <p>Before recoating after exposure in contaminated environment, clean the surface thoroughly by (high pressure) fresh water hosing and allow to dry if the maximum recoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion.</p>
Note:	BAJAPOX 15570L is for professional use only.



بازاک (سهامی خاص)

BAJAPOX 15590

CURING AGENT 95100

Description:	BAJAPOX 15590 is a two-component, epoxy amine adduct primer especially for use on surfaces exposed to severe abrasion.
Recommended use:	As a blast primer for heavy duty epoxy systems according to specification.
Service temperatures:	maximum, dry: 140°C/284°F.
PHYSICAL CONSTANTS:	
Colours/Shade nos.:	Red/55688
Finish:	Semi-gloss
Volume solids, %	44%
Theoretical spreading rate:	11.0 m ² /litre - 40 micron 441 sq.ft./US gallon - 1.6 mils
Flash point:	26°C/79°F
Specific gravity:	1.3 kg/litre - 10.8 lbs/US gallon
Surface dry:	¾ (approx.) hour at 20°C/68°F (ISO 1517)
Dry to touch:	3 (approx.) hours at 20°C/68°F
Fully cured:	7 days at 20°C/68°F
V.O.C.:	497 g/litre - 4.2 lbs/US gallon
APPLICATION DETAILS:	
Mixing ratio for 15590:	Base 15590 : Curing agent 95100 3.7 : 1.0 by volume
Application method:	Airless spray Air spray
Thinner (max.vol.):	0845 (5%) 0845 (15%)
Pot life:	2 hours (20°C/68°F)
Nozzle orifice:	.021"
Nozzle pressure:	150 bar/2200 psi (Airless spray data are indicative and subject to adjustment)
Cleaning of tools:	BAJAK'S TOOL CLEANER 19961
Indicated film thickness, dry:	40 micron/1.6 mils
Indicated film thickness, wet:	100 micron/4 mils
Recoat interval, min:	8 hours (20°C/68°F)
Recoat interval, max:	14 days (20°C/68°F) (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.

BAJAPOX 15590

SURFACE

PREPARATION:

New steel: Abrasive blasting to Sa 2½-3, SSPC-SP-10-5, depending on area of use. Minimum surface profile corresponding to Rugotest No. 3, BN11a, Keane-Tator Comparator, 5.5 G/S, or ISO Comparator Coarse (G) - or as per the specification for the subsequent coat(s). Oil and grease must be removed with suitable detergent, salts and other contaminants by (high pressure) fresh water cleaning prior to blasting. After blasting, clean the surface carefully from abrasives and dust.

Maintenance: On old steel surfaces having been exposed to salt water, excessive amounts of salt residues in pittings may call for wet abrasive blasting followed by dry abrasive blasting. Alternatively, dry abrasive blasting, high pressure fresh water cleaning, drying, and finally, dry abrasive blasting again.

APPLICATION

CONDITION:

Clean and dry surface with a temperature above the dew point to avoid condensation. Minimum temperature 5°C/41°F, best above 10°C/50°F. Relative humidity maximum 80%, preferably below 60%. The temperature of the paint itself should preferably be between 15°C/59°F and 25°C/77°F.

In confined spaces provide adequate ventilation during application and drying.

PRECEDING

COAT:

None.

SUBSEQUENT

COAT:

BAJAPOX or according to specification.

REMARKS:

Film thicknesses:

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 30-50 micron/1.2-2 mils.

The stated maximum recoating interval implies the following to secure good adhesion and the best mechanical properties:

- The coating has been applied in a dry film thickness as near as possible to the specified 40 micron.

- The film formation has been of good quality and without any dry spray.

- The drying and curing conditions have been according to APPLICATION CONDITIONS (please see above) until full cure has been obtained.

- No kind of surface contamination exists, except loose dust, abrasive, loose dry spray, which is possible to remove by vacuum cleaning (tanks) / hosing down (exterior).

The surface **MUST** be completely clean before recoating.

- The coating has only been exposed to short periods of strong, direct sunlight (ultra violet light).

Note: Inside closed tanks the maximum recoating interval is three weeks provided that the demands for recoating otherwise are fulfilled.

- The coating is checked carefully and should be without patchy, whitish, and/or greasy formations, which can hinder adhesion of subsequent coat.

Note: Exudation of curing agent causes the mentioned patchy, whitish, and/or greasy formations which will take place if BAJAPOX 15590 is applied at low temperature without proper induction time and/or if the coating is exposed to water (rain, condensation) during drying and curing.

If the maximum recoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion. Before recoating after exposure in contaminated environment, clean surface thoroughly by (high pressure) fresh water hosing and allow to dry. BAJAPOX 15590 will resist a hosing down of the surface 8 hours after application at a steel temperature of 20°C/68°F.

Note: BAJAPOX 15590 is for professional use only.

BAJAK'S ZINCSIL 15700

BAJAK'S ZINC DUST 97170

Description: BAJAK'S ZINCSIL 15700 is a two-component, solvent-borne, self-curing, inorganic zinc silicate with outstanding resistance against weathering and abrasion. It has excellent chemical resistance within the pH range 6-9. For service temperature range, see below. Applicable by airless spray offers cathodic protection of local mechanical damage. Zinc content is min.85wt% in dry film thickness.

Recommended use:

1. As a general purpose, heavy-duty, rust-preventing primer.
2. As a single, complete coating for long-term protection of steel exposed to moderately to severely corrosive environment and to abrasion.
3. As a tank lining in accordance with the CARGO PROTECION GUIDE.

Service temperatures:

Dry conditions:

- Resistance to permanent dry temperature up to 500 °C/932 °F.
- Resistance to occasional short-term heating (peak temperature) up to 500 °C/932 °F while permanent service temperatures are otherwise below 400 °C/752 °F.

In the case of cyclic service conditions with regulars periods of low & high temperatures, the temperature should be kept below 400 °C/752 °F.

In the case of service temperature above 400 °C/752 °F, it is of advantage to apply a topcoat of BAJAK's SILICONE ALUMINIUM 55910.

Humid conditions: Please see REMARKS overleaf.

PHYSICAL CONSTANTS:

Colours/Shade nos: Metal grey - 19840

Finish: Flat

Volume solids: 64±1

Theoretical spreading rate: 12.8 m²/litre - 50 micron
513sq.ft./ US gallon

Flash point: 14°C/57°F

Specific gravity: 2.65 kg/litre – 22.1 lbs/US gallon

Dry to touch: 30Approx. min. at 20°C/68°F (65-75% RH)

Fully cured: 3 (approx.) days at 20°C/68°F (65-75% RH) See REMARKS overleaf

V.O.C.: 535 g/litre – 4.5 lbs/US gallon

Shelf life: 6 Months (25°C/77°F) from time of production.
Shelf life is depended on storage temperature. Shelf life is reduced at storage temperatures above 25°C/77°F. Do not store above 40°C/104°F. Shelf life is exceeded if the liquid is gelled or if the mixed product forms gels before application.

APPLICATION DETAILS:

Mixing ratio for 15700: Liquid 15700 : zinc dust 97170
3.2 parts by weight 6.8 parts by weight
7,4 parts by volume 2.6 parts by volume

Application method: Airless spray Air spray Brush(touch-up)

Thinner (max.vol.): 08700 (30%) 08700(50%) 08700(10%)

Pot life: 8 hours (20°C/68°F)

Nozzle orifice: .019"-.023"

Nozzle pressure: 100 bar/1500 psi
(Airless spray data are indicative and subject to adjustment)

Cleaning of tools: THINNER 08700

Indicated film thickness, dry: 50 micron/2 mils (See REMARKS overleaf)

Indicated film thickness, wet : 75 micron/3 mils

Recoat interval, min. : See REMARKS overleaf

Recoat interval, max. : None. (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 force ventilation exists when applying paint in confined spaces or when the air is stagnant.

2. BAJAK'S ZINCSIL 15700

SURFACE PREPARATION:	Remove oil and grease, Etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. Grit blasting to minimum Sa 2½ with a surface profile equivalent to Rugotest No. 3, BN10a, Kean-Tator Comparator, min. 3.0 G/S, or ISO Comparator rough MEDIUM (G). In case of new steel to be exposed to no more than medium aggressive (industrial) environment and without any extraordinary demands to lifetime, a surface preparation degree of SSPC-SP 6 may suffice. Consult separate APPLICATION INSTRUCTION, and – as relevant- the corresponding PAINTING SPECIFICATION for cargo tanks.
APPLICATION CONDITIONS:	The surface must be completely clean and dry with a temperature above the dew point to avoid condensation. At temperature ranging from -10°C/15°F to 40°C/105°F. Curing needs minimum 65% relative humidity. Consult separate APPLICATION INSTRUCTIONS.
SUBSEQUENT COAT:	As a tank coating: none. Otherwise according to specification.
REMARKS: Service Temperatures:	Note: If used as anticorrosive protection under insulation of high temperature equipment it is very important that NO moisture can penetrate during shut-down periods. This is to avoid risk of “wet corrosion” when the temperature rises. Wet service temperature, non- saline water: Maximum 60°C/140°F
Tank Coating:	Wet service temperature, other liquids: Consult the corresponding CARGO PROTECTION GUIDE. Hot sea water washing and (low pressure) steam cleaning should never be executed on coatings which have not been in service for at least one month. Contact BAJAK about temperatures permissible.
Film thickness:	If top coated with a heavy-duty system, 50 micron/2 mils dry film thickness (75 micron/3 mils wet) is recommended. Consult separate APPLICATION INSTRUCTIONS before recoating. For long-term protection without top coat, 75 micron/3 mils dry film thickness (100-125 micron/4-5 mils wet) is generally recommended. In tanks 100 micron/4 mils dry film thickness (150 micron/6 mils wet) is recommended but may be applied in 125 micron/5 mils dry film thickness (200 micron/8 mils wet).
High temperature Service :	To avoid cracking it is important to keep the dry film thickness at maximum 40-50 micron/1.6-2 mils, especially in cases where service conditions include sudden temperature changes.
Thinning:	For application at high temperatures, a special thinner is available.
Recoating:	Minimum interval at 20°C/68°F, 75% RH for recoating with : BAJAPOX (system/high-build) 3 days, full curing (see APPLICATION INSTRUCTIONS) 24 hours BAJAPOX (25 micron/1mil) Recoating intervals are strongly dependent on both temperature and humidity. Deviations from the standard condition may shorten or prolong recoating intervals. Consult separate APPLICATION INSTRUCTION. The recoating interval of 24 hours from 25 micron/1mil BAJAPOX is only valid in case the otherwise, the minimum recoating interval is the same as for system/high-build.
Curing, cargo tanks:	Before cargo tanks are taken into use, the coating must be completely through-cured. It is recommended to carry out low pressure hosing of the tanks with (fresh) water 2-3 times at ambient temperature. Let the tanks remain wet between the washings, Reference is made to APPLICATION INSTRUCTIONS.

NOTE: **BAJAK ZINCSIL 15700 is for professional use only.**

APPLICATION INSTRUCTIONS

For product description refer to product data sheet

BAJAK'S ZINCSIL 15700

Scope: These application instructions cover surface preparation, application equipment, and application of BAJAK'S ZINCSIL 15700.

The following are general rules, which may be supplemented with more detailed descriptions when needed, for instance for major new buildings/new constructions or extensive repair jobs.

For optimum performance, eg relevant for cargo tank coating, the following is recommended.

Steel work: All welding seams must have a surface finish which ensures that the quality of the paint system will be maintained in all respects. Holes in weldings seams, undercuts, cracks, etc. should be avoided. If found, they must be remedied by welding and/or grinding.

All weld spatters must be removed.

All sharp edges must be removed or rounded off in such a way that the specified film thickness can be build-up on all surfaces. The radius of the rounding should be approximately 1-2 mm. Any laminations must be removed.

The steel must be of first class quality and should not have been allowed to rust more than corresponding to grade B of ISO 8501-1:1988.

Note: Porous surfaces such as certain types of cast iron cannot be properly protected with zinc silicate. Deeply corroded steel may also be difficult to protect with a zinc silicate.

All steel work (including welding, flame cutting, grinding) must be finished before the surface preparation starts.

Surface preparation: Prior to abrasive blast cleaning of the steel, remove oil, grease, salts and other contamination with a suitable detergent followed by high pressure fresh water hosing. Alkali deposits on new welding seams as well as soap traces from pressure testing of tanks to be removed by fresh water and scrubbing with stiff brushes. Control for absence of contamination according to separate guidelines.

On repair jobs, a rough blasting to remove all loosely adhering materials may be required before degreasing / washing is carried out.

Old steel: Even after a very thorough tank cleaning, pits may typically contain contamination in the form of remnants of old cargoes as well as water soluble salts. For this reason, repeated detergent washing plus abrasive blasting may be necessary.

After the first blasting a very thorough vacuum cleaning is carried out in order to see if any "cargo bleeding" occurs as well as controls for water soluble salts are made. Reference is made to separate instructions. Special care should be taken in evaluating pitted areas. Ask for special guidelines.

Grit blast to min. Sa 2½ , ISO 8501-1:1988

To obtain full chemical resistance according to the CARGO PROTECTION GUIDE, the steel surface must be abrasive blast cleaned according to ISO 8501:1988, very near to white metal Sa 2½ - Sa 3. In practice, this requirement is to be understood as white metal Sa 3 at the moment of abrasive blasting, but allows for a slight reduction at the moment of paint application.

The resulting surface profile must be equivalent to Rugotest No.3 min. BN 10a. Keane-Tator Surface Comparator, G/S min 3.0 or ISO/DIS 8503/1 rough MEDIUM(G).

BAJAK'S ZINCSIL 15700

In case of new steel to be exposed to no more than medium aggressive (industrial) environment and without any extraordinary demands to lifetime, a surface preparation degree of SSPC-SP6 may suffice.

Note: A lower surface profile than specified will cause reduced adhesion and increased tendency to mud cracking.

Use steel grit, aluminium silicasand, or similar sharp edged abrasives of a good quality free of foreign matters, soft particles, and the like. Control for absence of contamination according to separate guidelines.

Steel grit with particle sizes of 0.2-1.2 mm or aluminium silicate of 0.4-1.8 mm will usually create the desired surface profile when the air pressure measured at the nozzle is 6-7 bar/85-100 psi.

The compressed air must be dry and clean. The compressor must be fitted with suitable oil and water traps.

When the abrasive blasting is completed, remove residual grit and dust by vacuum cleaning. Abrasive particles not removed by vacuum cleaning are to be removed by brushing with clean brushes followed by vacuum cleaning.

The importance of systematic working must be stressed when blasting. Poorly blasted areas covered with dust are very difficult to locate during the blast inspection made after the rough cleaning.

Old tank coatings: Must be completely removed. If the steel is pit corroded, the above guidelines for "Old steel" must be followed.

Shopprimed surfaces: When shoppriming is required only zinc silicate shopprimer such as BAJAK'S SHOPPRIMER ZS 15890 may be used and preferably in a reddish shade.

Before recoating with GALVOSIL 15700, intact shopprimer must be abrasive grit swept in order to obtain specified roughness. A uniform sweep-blasting is required, removing minimum 70% of the shopprimer followed by vacuum cleaning to remove accumulated dirt and zinc salts to ensure adhesion.

Welds, rusty spots, burned areas, and all areas with other types of shopprimers than zinc silicates of a type like BAJAK'S SHOPPRIMER ZS 15890 must be completely abrasive grit blasted as described above.

Application equipment: ZINCSIL 15700 can be applied by conventional spray equipment (pressure pot type), airless spray equipment, or by brush.

Conventional Spray equipment: Standard industrial spray equipment with mechanical agitator and pressure regulators, air filters, and water traps.

Air hose: 10 mm (3/8") internal diameter.
Material hose: 13 mm (1/2") internal diameter.

Hoses should be as short as possible, preferably not longer than 10 metres/30 feet.

Pot pressure: 2.5-5 bar (35-70 psi)
Atomization pressure: 1.5-2.5 bar (20-35 psi)
Nozzle orifice: 1.8-2.2 mm (.070"-.085")

(Spray-data are indicative and subject to adjustment).

Thinning, if required: max. 50% of THINNER 08700.

The pressure pot must be placed at the same level as or at a higher level than the spray gun when spraying, owing to the weight of the material. Alternatively a piston-pump (e.g. 10:1) may be used instead of the pressure pot. This will facilitate the use of longer hoses or having the spray gun at a higher level than the pump.

BAJAK'S ZINCIL 15700

When painting undersides, the spray gun will need intermittent cleaning with THINNER 08700 to prevent clogging of the nozzle.

With conventional spray application regulation of the pot and the atomizing air pressures can be made as follows:

1. Shut off the atomizing air.
2. Regulate the pressure in the pot so that the material reaches approximately 60 Cm/20" horizontally out from the gun before falling to the ground.
3. Turn on the atomizing air using lowest possible pressure.

Airless spray equipment: A large, slow-working pump is preferred, e.g. 30:1, with a pump capacity of 8-12 liters/minute. The in-line filter should be 60 meshes.

Gaskets:	Teflon
Nozzle orifice:	.019" through .023".
Fan angle:	40° through 70°.
Nozzle pressure:	100-150 bar (1400-2100 psi).

(Spray data are indicative and subject to adjustment).

Thinning, if required: max. 30% of THINNER 08700.

Thinning:

The amount of thinning necessary will depend upon prevailing conditions: Temperature, humidity, wind/ventilation, method of spraying, spray equipment, etc.

In the case of a high level of thinning and/or long stops in application, the mixed paint must be recirculated to avoid settlement of zinc particles in the spray hoses.

The coating **must** be wet and smooth just after application. Besides correct spray technique, the amount of thinner added must be selected securing this optimum film formation. Too little thinning will typically lead to dry-spray and too much thinning to sagging and settling of zinc particles in the can or in the spray hoses.

Cleaning of equipment:

The whole equipment must be cleaned thoroughly with THINNER 08700 after use.

Additionally for conventional spray-guns:

In the case of short stops, prevent packing of zinc around the needle by placing the spray gun in THINNER 08700 and let some air pass the spray gun. In the case of longer stops, clean the spray gun with THINNER 08700.

Mixing:

- a. Do not open packings until immediately before use. The entire content of the two packings must be used for each batch to ensure a correct mixture. Left-overs in the packings cannot be used later. Protect the ZINC DUST against moisture before mixing.
- b. Before mixing, shake or stir the GALVOSIL 15700 LIQUID very thoroughly.
- c. Pour the ZINC DUST slowly down into the LIQUID with constant mechanical stirring. Do not mix in the reverse order. Continue stirring until the mixture is free of lumps.
- d. Strain the mixture through a screen, 60 - 80 mesh (250 - 160 DIN Norm.41880).

Pot life:

8 hours at 20°C/68°F.

Temperature of paint:

In a hot climate it is important that the cans with LIQUID are kept out of the sun and that the temperature of the liquid is kept below 30°C/86°F in order to avoid excessive dry spray.

BAJAK'S ZINCSIL 15700

Application procedure, General:

Maintain constant agitation of the mixture until the batch is depleted.

The spray gun should be kept at a distance of 30-50 cm from the surface. Hold the spray gun at a right angle to the surface, making even, parallel passes with about 50% overlap.

Besides correct spray technique the amount of thinner added must be carefully adjusted to secure optimum film formation. **The coating must be wet and smooth just after application. It is important to avoid dry-spraying.**

Select small nozzles (small orifice and small fan angle) for spray application of complicated structures, while bigger nozzles may be used for regular surfaces.

The wet film thickness must be checked immediately after application, but it can only be used as a rough guidance because of the fast drying.

Application procedure, tank coating:

When used as a tank coating, HEMPEL'S GALVOSIL 15700 is normally specified in 1 x 100 micron/1 x 4 mils - minimum 80 micron/3.2 mils, maximum 150 micron /6mils.

To achieve a correct film formation within these limits, it is recommended to apply two coats "wet-in-almost-dry":

Apply one coat and apply the second coat within 15-30 minutes before the first coat has turned grey but is still dark.

When following this procedure, BAJAK'S ZINCSIL 15700 must be thinned approximately 15% in order to avoid too high film thicknesses.

Too high film thicknesses on welds in corners must be smoothed by a flat brush, approximately 1" wide.

When coating tanks, it is of the utmost importance to avoid dry-spray, which is a typical indication of poor film formation.

Poor film formation of a one-coat tank coating system like BAJAK'S ZINCSIL 15700 may result in immediate failure.

Any dry-sprayed areas must be smoothed by scraping with a spatula (rounded corners) or by light sandpapering or by using a cleaning sponge ("3M", "Scotch-brite" type).

After vacuum cleaning as necessary, the smoothed areas are applied a thin coat of BAJAK'S ZINCSIL 15700 achieved by using 20-25% thinning.

Note: If working conditions ask for it some hours may elapse between the first and the second coat provided that the relative humidity is kept constantly low, but it is recommended to finalize the application as soon as possible and within the same working shift.

Stripe coating:

All places difficult to cover properly by spray application must be stripe coated with a brush immediately before or after the spray application.

Microclimate:

The actual climatic conditions at the substrate during application and until acceptance:

The minimum surface temperature is -10°C/14°F.

The maximum recommended surface temperature is approx. 40°C/104°F. Higher steel temperatures are acceptable provided dry-spray is avoided by (extra thinning and) proper spray application. In extreme cases a reduction of the dry film thickness may also be necessary. In a warm climate it is recommended to carry out application during nighttime.

The steel temperature must be above the dewpoint. As a rule of thumb a steel temperature which is 3°C/5°F above the dewpoint can be considered safe.

BAJAK'S ZINCSIL 15700

With temperatures at or below 0°C/32°F beware of ice on the surface, which will hinder the adhesion, and use a capacitive RH-meter for measuring the relative humidity.

In confined spaces, supply an adequate amount of fresh air during application and drying to assist the evaporation of solvent. All surfaces must be ventilated. However, avoid ventilators blowing directly onto the freshly applied paint.

Drying and curing, Ventilation:

Correct film formation depends on an adequate ventilation during drying.

A good guideline for tank coating work is to ventilate to a calculated 10% of LEL during application and until the coating is dry.

One litre undiluted BAJAK'S ZINCSIL 15700 gives off in total 160 litres solvent **vapour** until it is completely dry.

The lower explosive limit, LEL, is 0.5%.

To reach a common safety requirement of 10% LEL, the theoretical ventilation requirement is 320 m² per litre paint.

Because solvent vapours are heavier than atmospheric air, effective ventilation requires forced ventilation with exhaust from the lowest part of the tank.

During the following period until full curing a few air shifts per hour will suffice. Take actions to avoid "pockets" of stagnant air.

Please contact BAJAK for further advice.

Actual safety precautions may require stronger ventilation.

It is recommended to keep the relative humidity low during application and drying. Thereafter, let the relative humidity raise by "natural means", i.e. the dehumidifiers are notched off and normal ventilation used. However, it is recommended to let dehumidifiers run until dry film thicknesses have been checked - and if needed -rectified by an extra paint application.

Curing time:

Curing is dependent on (steel) temperatures and relative humidities.

At 20°C/68°F and 65-75% RH, curing requires approximately 3 days. At lower temperatures and relative humidity, curing time will increase considerably. Please contact BAJAK for further instructions.

The relative humidity should be minimum 65% - and the minimum temperature -10°C/14°F- during the period of curing. Hosing down of tanks can support curing, but should if possible await the state of "near to complete" curing - please see below.

The coating will resist light showers after 1-2 hours at 20°C/68°F and 75% relative humidity. Curing may be promoted at low humidity by hosing down the surface with water 4 hours after application and keeping the surface constantly wet until curing is complete. If salt water is used, rinse with fresh water if the surface is to be overcoated.

State of curing:

Can be checked by rubbing the coating with a rag soaked in THINNER 08700. If the coating remains unaffected, state of curing is sufficient for recoating with other paint materials (when used as a cargo tank coating this state of curing may be described as "near to complete").

Full curing for cargo loading:

Before tanks are taken into use, the coating must be completely through-cured. This is secured by low pressure hosing/washing the tanks with (fresh) water 2-3 times after the above described condition of "near to complete curing" has been obtained. By using the tank washing equipment, the normal ½ hour cycle is applied with half a day to one day between washings. Let the tanks remain wet between the washing.

BAJAK'S ZINCSIL 15700

Full curing is confirmed by rubbing the coating with methyl ethyl ketone.

The coating will now be fully resistant according to the CARGO PROTECTION GUIDE, but as long as the porosities are not yet filled with zinc salts, absorption of cargoes will take place, maybe making cleaning more difficult.

Curing may also be checked by scraping with e.g. a knife or a coin which shall produce a bright mark leaving some loosened zinc dust but no irregular detachment.

Full hardness will be obtained after weathering for some time.

Recommended film thickness:

For long time protection, **when topcoated with heavy-duty systems:**
50 micron/2 mils dry; 75 micron/3 mils wet, (undiluted).

For long time protection, **without topcoat:**
75-100 micron/3-4 mils dry; 125-150 micron/5-6 mils wet, (undiluted).

In tanks: 100 micron/4 mils dry; 150 micron/6 mils wet, (undiluted), may be specified.

For a tank coating specification the film thickness should be controlled according to the 80-20 rule, is 80% of the dry film thickness measurements must be equal to or greater than the specified film thickness (100 micron/4 mils) and of those below the specified film thickness, no measurements must be lower than 80% of the 100 micron/4 mils. For narrow frames, girders and similar areas not very accessible the film thickness could be controlled according to the 70-30 rule.

Too high dry film thickness, is above approximately 150 micron/6 mils dry, should be avoided due to the risk of mud cracking or peeling. Please observe that according to accepted rules of measuring "a measurement" is to be the mean of three single point measurements taken in a close vicinity.

Note: Special care is necessary to ensure proper film thickness on welding seams, edges, corners, ribs, etc.

Extra coat (by itself):

Too low film thickness can be made good by applying an extra coat of BAJAK'S ZINCSIL 15700. Surface preparation procedure - if necessary - and dilution of paint according to page 4 "Application procedure, tank coating".

The maximum interval for applying an extra coat is 7 days **provided** that the relative humidity is kept below 60%, absolute maximum is 65%, all the time until recoating and that the painted surface is not exposed to open weather, contamination of the like.

Spreading rate:

Theoretical (on a smooth surface):

dft, micron	dft, mils	m ² /litre	sq.ft./US gallon
50	2	12.8	513
75	3	8.5	342
100	4	6.4	257

Practical (with a consumption factor of 1.8):

dft, micron	dft, mils	m ² /litre	sq.ft./US gallon
50	2	7.1	285
75	3	4.7	190
100	4	3.6	143

Recoating interval (other paints):

BAJAK'S ZINCSIL 15700 must be fully cured before recoating with a full paint system. By recoating with sealer in 25 micron/1 mil only, the interval can be reduced to eg 24 hours at 20°C/68°F and 65-75% RH provided that the following coats are applied **after** BAJAK'S ZINCSIL 15700 is **fully cured**.

Topcoating procedure:

Non-weathered zinc silicate coatings are porous and popping may occur in the subsequent coat(s).

One way to reduce the risk of popping is to apply a mist coat as the first pass of the subsequent coat, let the air escape, and then apply the remainder of the topcoat.

BAJAK'S ZINCSIL 15700

Some of BAJAK's products will substantially reduce the risk of popping when applied directly on top of the zinc silicate. See painting specification.

Advanced paint systems are recommended for topcoating, e.g. BAJAPOX qualities.

Surface cleaning:

The cleaning before topcoating depends on the condition of the surface:

1. Intact zinc silicate surface with sporadic formation of "white rust" (zinc corrosion products).
 - a. Remove oil, grease, dirt, etc. by detergent wash.
 - b. Remove "white rust" by high pressure fresh water cleaning 200-350 bar (2900-5000 psi) at a nozzle-to-surface distance of 15-20 cm (6-8").

If the surface is only slightly contaminated, corresponding to 1-2 months of exposure in a mildly corrosive environment, hosing down of the surface with fresh water and scrubbing with stiff brushes (nylon) may be sufficient and more practical. Check that the coating is through dry before recoating.

2. Zinc silicate surface with extreme formation of "white rust" which cannot be removed as described above.
 - a. Remove oil, grease, dirt, etc. by detergent wash.
 - b. Abrasive blast sweep to remove "white rust", followed by vacuum cleaning to remove abrasives and dust.
 - c. Restore the zinc layer with any solvent borne ZINCSIL quality or zinc epoxy (BAJAPOX ZINC).
3. Damaged areas, burns, weld spatters, etc.
 - a. Remove oil, grease, dirt, etc. by detergent wash.
 - b. Remove weld spatters.
 - c. Abrasive blasting to min. Sa 2½, followed by thorough removal of abrasives and dust by vacuum cleaning.
 - d. Restore the zinc layer with any solvent borne ZINCSIL quality or zinc epoxy (BAJAPOX ZINC).

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.

Issued:

Feb. 2007



BAJAK'S ZINCSIL 15780

BAJAK'S ZINC DUST 97170

باجاک (سهامی خاص)

Description:	BAJAK'S ZINCSIL 15780 is a two-component, medium-zinc, solvent-borne, self-curing inorganic zinc silicate coating. For service temperature range, see REMARKS overleaf. Applicable by airless spray.
Recommended use:	As a general purpose rust-preventing primer in "high-build" paint systems for long-life protection of steel exposed to moderately to severely corrosive environment.
Service temperatures:	Maximum service temperature is depending on the subsequent coat.

PHYSICAL CONSTANTS:

Colours/Shade nos:	Metal grey/19840
Finish:	Flat
Volume Solids, %:	62 ± 1
Zinc content in dry film (wt %):	75 ± 2
Theoretical spreading rate:	12.4 m ² /litre - 50 micron 497 sq.ft./US gallon - 2 mils
Flash point:	14°C/57°F
Specific gravity:	2.4 kg/litre - 20.0 lbs/US gallon
Dry to touch:	30 (approx.) min. at 20°C/68°F (75% RH)
Fully cured:	3(approx.) days at (20°C/68°F) (75% RH)
V.O.C.:	515g/litre – 4.3 lbs/US gallon
Shelf life:	6 months (25°C/77°F) from time of production. Shelf life is dependent on storage temperature. Shelf life is reduced at storage temperatures above 25°C/77°F. Do not store above 40°C/104°F. Shelf life is exceeded if the liquid is gelled or if the mixed product forms gels before application.

APPLICATION DETAILS:

Mixing ratio for 15780:	Liquid 15789 : Zinc dust 97170
4.1 parts by weight :	5.9 parts by weight
15.4 parts by volume :	3.8 parts by volume
Application method:	Airless spray Air spray Brush (touch-up)
Thinner (max.vol.):	08700 (30%) 08700 (50%) 08700 (10%)
Pot life:	12 hours (20°C/68°F)
Nozzle orifice:	.019" - .023"
Nozzle pressure:	100 bar/1500 psi (Airless spray data are indicative and subject to adjustment)
Cleaning of tools:	THINNER 11087
Indicated film thickness, dry:	50 micron/2 mils (See REMARKS overleaf)
Indicated film thickness, wet:	75 micron/3 mils
Recoat interval, min:	See REMARKS overleaf
Recoat interval, max:	Infinite, See SUBSEQUENT COAT overleaf

Issued: Feb. 2009

2. BAJAK'S ZINCSIL 15780

SURFACE PREPARATION : Remove oil and grease, etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. Gritblasting to minimum Sa 2½ with a surface profile equivalent to Rugotest No. 3, BN10a, Keane-Tator Comparator, min. 3.0 G/S, or ISO Comparator rough MEDIUM (G). In case of new steel to be exposed to no more than medium aggressive (industrial) environment and without any extraordinary demands to lifetime, a surface preparation degree of SSPC-SP6 may suffice. Consult separate APPLICATION INSTRUCTIONS.

APPLICATION AND CURING CONDITIONS: APPLICATION AND From -10°C/15°F to 40°C/104°F. Curing needs minimum 65% relative humidity. Consult separate APPLICATION INSTRUCTIONS.

SUBSEQUENT: COAT: BAJAPOX systems according to specification. Recoating is expected to take place within 6 months after application of BAJAK'S ZINCSIL 15780.

REMARKS:

Note: If used as anticorrosive protection under insulation of high temperature equipment it is very important that NO moisture can penetrate during slow-down periods. This to avoid risk of "wet corrosion" when the temperature rises.

FILM THICKNESS: 50 micron/2 mils dry film thickness is recommended, but 75 micron/3 mils dry film thickness (125 micron/5 mil wet) may be specified, this will alter spreading rate and may influence drying time and recoating interval.

Recoating intervals: Consult separate APPLICATION INSTRUCTIONS before recoating.

Minimum interval for recoating with:	20°C/68°F, 75% RH
BAJAPOX (system/high-build)	72 hours (when fully cured)
BAJAPOX (25 micron/1 mil)	24 hours

Recoating intervals are strongly dependent on both temperature and humidity, and deviations from the standard conditions may shorten or prolong the recoating interval. Consult separate APPLICATION INSTRUCTIONS. The recoating interval of 24 hours for 25 micron/1 mil BAJAPOX is only valid in case the subsequent coat is applied more than 1 week after (20°C/68°F), 75% RH, humid weather. Otherwise, the minimum recoating interval is the same as for system/high-build.

Note: **BAJAK'S ZINCSIL 15780 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.

Issued: Feb. 2009



BAJAK'S ZINCSIL 15780D

BAJAK'S ZINC DUST 97170

باجاک (سهامی خاص)

Description:	BAJAK'S ZINCSIL 15780D is a two-component, medium-zinc, solvent-borne, self-curing inorganic zinc silicate coating. For service temperature range, see REMARKS overleaf. Applicable by airless spray.
Recommended use:	As a general purpose rust-preventing primer in "high-build" paint systems for long-life protection of steel exposed to moderately to severely corrosive environment.
Service temperatures:	Maximum service temperature is depending on the subsequent coat.

PHYSICAL CONSTANTS:

Colours/Shade nos:	Metal grey/19840
Finish:	Flat
Volume Solids, %:	62 ± 1
Zinc content in dry film (wt %):	75 ± 2
Theoretical spreading rate:	12.4 m ² /litre - 50 micron 497 sq.ft./US gallon - 2 mils
Flash point:	14°C/57°F
Specific gravity:	2.4 kg/litre - 20.0 lbs/US gallon
Dry to touch:	30 (approx.) min. at 20°C/68°F (75% RH)
Fully cured:	3(approx.) days at (20°C/68°F) (>30% RH)
V.O.C.:	515g/litre – 4.3 lbs/US gallon
Shelf life:	3 months (25°C/77°F) from time of production. Shelf life is dependent on storage temperature. Shelf life is reduced at storage temperatures above 25°C/77°F. Do not store above 40°C/104°F. Shelf life is exceeded if the liquid is gelled or if the mixed product forms gels before application.

APPLICATION DETAILS:

Mixing ratio for 15780D:	Liquid 15780D : Zinc dust 97170
4.1 parts by weight :	5.9 parts by weight
15.4 parts by volume :	3.8 parts by volume
Application method:	Airless spray Air spray Brush (touch-up)
Thinner (max.vol.):	08700 (30%) 08700 (50%) 08700 (10%)
Pot life:	12 hours (20°C/68°F)
Nozzle orifice:	.019" - .023"
Nozzle pressure:	100 bar/1500 psi (Airless spray data are indicative and subject to adjustment)
Cleaning of tools:	THINNER 11087
Indicated film thickness, dry:	50 micron/2 mils (See REMARKS overleaf)
Indicated film thickness, wet:	75 micron/3 mils
Recoat interval, min:	See REMARKS overleaf
Recoat interval, max:	Infinitive, See SUBSEQUENT COAT overleaf

Issued: Feb. 2011

2. BAJAK'S ZINCSIL 15780D

SURFACE PREPARATION : Remove oil and grease, etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. Gritblasting to minimum Sa 2½ with a surface profile equivalent to Rugotest No. 3, BN10a, Keane-Tator Comparator, min. 3.0 G/S, or ISO Comparator rough MEDIUM (G). In case of new steel to be exposed to no more than medium aggressive (industrial) environment and without any extraordinary demands to lifetime, a surface preparation degree of SSPC-SP6 may suffice. Consult separate APPLICATION INSTRUCTIONS.

APPLICATION AND CURING CONDITIONS: APPLICATION AND From -10°C/15°F to 40°C/104°F.
Curing needs minimum 30% relative humidity. Consult separate APPLICATION INSTRUCTIONS.

SUBSEQUENT: COAT: BAJAPOX systems according to specification. Recoating is expected to take place within 6 months after application of BAJAK'S ZINCSIL 15780D.

REMARKS:

Note: If used as anticorrosive protection under insulation of high temperature equipment it is very important that NO moisture can penetrate during slow-down periods. This to avoid risk of "wet corrosion" when the temperature rises.

FILM THICKNESS: 50 micron/2 mils dry film thickness is recommended, but 75 micron/3 mils dry film thickness (125 micron/5 mil wet) may be specified, this will alter spreading rate and may influence drying time and recoating interval.

Recoating intervals: Consult separate APPLICATION INSTRUCTIONS before recoating.

Minimum interval for recoating with:	20°C/68°F, 30% RH
BAJAPOX (system/high-build)	72 hours (when fully cured)
BAJAPOX (25 micron/1 mil)	24 hours

Recoating intervals are strongly dependent on both temperature and humidity, and deviations from the standard conditions may shorten or prolong the recoating interval. Consult separate APPLICATION INSTRUCTIONS. The recoating interval of 24 hours for 25 micron/1 mil BAJAPOX is only valid in case the subsequent coat is applied more than 1 week after (20°C/68°F), 30% RH, humid weather. Otherwise, the minimum recoating interval is the same as for system/high-build.

Note: **BAJAK'S ZINCSIL 15780D 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.

Issued: Feb. 2011



بازاک (سهامی خاص)

BAJAK'S ZINC PRIMER 16490

Description:	BAJAK'S ZINC PRIMER 16490 is a one-component, high molecular weight, quick drying, phenoxy coating with a high content of zinc.
Recommended use:	1- As a protective primer on steel in severely corrosive environment. 2- For repair of ZINCSIL and other zinc rich coatings. 3- For repair of galvanized steel.
Service temperatures:	Dry : maximum: 120°C/248°F, however, depending on the subsequent coat.
Availability:	Subject to confirmation.

PHYSICAL CONSTANTS:

Colours/Shade no:	Metal Gray/19840
Finish:	Flat
Volume Solids, %:	34%
Theoretical spreading rate:	9.7 m ² /litre at 35 micron 390 sq.ft./US gallon - 1.4 mils
Flash point:	7°C/45°F
Specific gravity:	2.0 kg/litre - 16.7 lbs/US gallon
Surface dry:	15 (approx.) minutes at 20°C/68°F (ISO 1517)
Dry to touch:	30 (approx.) minutes at 20°C/68°F
V.O.C.:	593 g/litre - 4.9 lbs/US gallon

APPLICATION DETAILS:

Application method:	Airless spray	Brush
Thinner (max.vol.):	08450 or 08710 (5%)	08450 (5%)
Nozzle orifice:	0.019" - 0.021"	
Nozzle pressure:	200 bar/2900 psi (Airless spray data are indicative and subject to adjustment)	
Cleaning of tools:	THINNER 08450 or BAJAK'S TOOL CLEANER 99610	
Indicated film thickness, dry:	35 micron/1.4 mils	
Indicated film thickness, wet:	100 micron/4 mils	
Recoat interval, min:	30 minutes (20°C/68°F)	
Recoat interval, max:	None (See REMARKS overleaf)	

Issued: March 2004

2. BAJAK'S ZINC PRIMER 16490

SURFACE PREPARATION:	New steel: Abrasive blasting to minimum Sa 2½, SSPC-SP-10 with a surface profile corresponding to Rugotest No. 3, N9a to N10, preferably BN9a to BN10, Keane-Tator Comparator, 2.0 G/S or ISO Comparator, Medium (G). Repair of galvanized steel or zinc-rich coating: Remove oil and grease, etc. with suitable detergent. Remove salts and others contaminants by (high pressure) fresh water cleaning. Remove rust and loose material by abrasive blasting or power tool cleaning (avoid burnishing the surface). Dust off residues.
APPLICATION CONDITIONS:	The surface must be completely clean and dry at the time of application and its temperature must be above the dew point to avoid condensation. Tolerates low temperature application which, however, will increase drying time. At the freezing point and below be aware of the risk of ice on the surface, which will hinder the adhesion. In confined spaces provide adequate ventilation during application and drying.
PRECEDING COAT:	None.
SUBSEQUENT COAT:	Recommended are BAJAPOX or BAJATEX Systems according to specification.
REMARKS:	Note: Due to a risk of corrosion from possible moisture penetration, many experts advise against the use of zinc primers behind high temperature insulation.
FILM THICKNESS:	May be specified in another film thickness than indicated depending on purpose and area of use. Normal range is 25-35 micron/1.0-1.4 mils.
Recoating:	If the coating has been exposed to the atmosphere for some time, the surface should be thoroughly hosed down and scrubbed with a stiff brush to remove "white rust" (zinc corrosion products) in addition to the usual cleaning for dirt, oil, grease, etc. Allow surface to dry before recoating. When overcoated, the entire paint system must be through dry and fully cured before full mechanical strength is obtained. Care should be taken to avoid water contamination in the cans to prevent gelling or gassing.
Note:	BAJAK'S ZINC PRIMER 16490 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. Harmful or fatal if swallowed; immediately seek medical assistance if swallowed. Avoid inhalation of possible solvent vapours or paint mist, as well as paint contact with skin and eyes. 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. Always take precautions against the risks of fire and explosions.

Issued:

March 2004

BAJAK'S SILICONE ZINC 16900

Description:	BAJAK'S SILICONE ZINC 16900 is a heat resistant zinc pigmented silicone primer. It is air drying at ambient temperature and resists temperatures up to 400°C/750°F. (See REMARKS overleaf)
Recommended use:	As a primer for long-time corrosion protection of steel exposed to high temperatures (from 100°C/210°F to 400°C/750°F).
Service temperatures:	Maximum service temperature is depending on the subsequent coat. When topcoated with BAJAK'S SILICONE ALUMINIUM 56910 dry service temperature is max. 400°C/750°F.
Availability:	Part of Group Assortment. Local availability subject to confirmation.

PHYSICAL CONSTANTS:

Colours/Shade nos:	Metal grey/19840
Finish:	Flat
Volume solids, %:	57 ± 1
Theoretical spreading rate:	14.3 m ² /litre - 40 micron 571 sq.ft./US gallon - 1.6 mil
Flash point:	25°C/77°F
Specific gravity:	2.6 kg/litre - 21.7 lbs/US gallon
Surface dry:	1 (approx.) hours at 20°C/68°F (ISO 1517)
Dry to touch:	2-3 hours at 20°C/68°F
V.O.C.:	390 g/litre - 3.2 lbs/US gallon

APPLICATION DETAILS:

Application method:	Airless spray Air spray Brush
Thinner (max.vol.):	08080 (5%) 08080 (15%) 08080 (5%)
Nozzle orifice:	.017"
Nozzle pressure:	125 bar/1800 psi (Airless spray data are indicative and subject to adjustment)
Cleaning of tools:	THINNER 08080
Indicated film thickness, dry:	40 micron/1.6 mil
Indicated film thickness, wet:	75 micron/3 mils
Recoat interval, min:	4 hours (20°C/68°F) (See REMARKS overleaf)
Recoat interval, max:	None (See REMARKS overleaf)

Issued: March 2004

2. BAJAK'S SILICONE ZINC 16900

SURFACE PREPARATION:	Remove oil and grease etc. thoroughly with suitable detergent. Remove salts and other contaminants by high pressure fresh water cleaning. Abrasive blasting to Sa 2½. If shopprimer is required, only zinc silicate type is recommended.
APPLICATION CONDITIONS:	Clean and dry surface with a temperature above the dew point to avoid condensation. In confined spaces provide adequate ventilation during application and drying.
PRECEDING COAT:	None, or zinc silicate shopprimer.
SUBSEQUENT COAT:	BAJAK'S SILICONE TOPCOAT 56900, BAJAK'S SILICONE ALUMINIUM 56910, BAJAK'S SILICONE ACRYLIC 56940 or similar according to specification.
REMARKS	Note: If used as anticorrosive protection under insulation of high temperature equipment it is very important that NO moisture can penetrate during slow-down periods. This to avoid risk of "wet corrosion" when the temperature rises. Do not expose the paint system to heat before it is through dry (minimum 24 hours at 20°C/68°F).
Film thicknesses:	It is recommended to avoid too high thicknesses of the paint as this will give a risk of blistering at later heating. For high temperature service, the total dry film thickness of the paintsystem should preferably be kept at 75 micron/3 mils.
Recoating intervals:	May be recoated both at ambient temperature and after being heated for one hour to a temperature above 200°C/392°F. Before recoating after exposure in contaminated environment, clean surface thoroughly by high pressure fresh water hosing and allow to dry.
Note:	BAJAK'S SILICONE ZINC 16900 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.

Issued: March 2004



بازاک (سهامی خاص)

BAJAPOX ZINC17360

CURING AGENT 97040

- Description:** BAJAPOX ZINC 17360 is a two-component, zinc rich epoxy primer. It cures to a hard wearing and highly weather-resistant coating. Offers cathodic protection of local mechanical damage. Zinc content is min 85% in dry film.
- Recommended use:** As a "V.O.C.-compliant" , versatile, long-term primer on steel for epoxy, vinyl and acrylic coating systems in medium to severely corrosive environment.
- Service temperatures:** Maximum ,Dry: 160°C/320°F , however, depending on the subsequent coat.

PHYSICAL CONSTANTS:

Colours/Shade nos:	Red-grey
Finish:	Flat
Volume Solids, %:	65±1
Theoretical spreading rate:	13.0 m ² /litre - 50 micron 521 sq.ft./US gallon- 2 mils
Flash point:	38°C
Specific gravity:	2.8±0.1 kg/litre – 22.5 lbs/US gallon
Surface dry:	½(approx.) hour at 20°C/68°F (ISO 1517)
Dry to touch:	1 (approx.) hour at 20°C/68°F
Fully cured:	7 days at 20°C/68°F
V.O.C.:	335 g/litre – 2.8 lbs/US gallon

APPLICATION DETAILS:

Mixing ratio for 17360:	Base 17360 : Curing agent 97040 4 : 1 by volume		
Application method:	Airless spray	Air spray	Brush
Thinner (max.vol.):	08450 (5%)	08450 (15%)	08450 (5%) (See REMARKS overleaf)
Pot life:	6 hours (20°C/68°F)		
Nozzle orifice:	.017"-.021"		
Nozzle pressure:	150 bar/2200 psi (Airless spray data are indicative and subject to adjustment)		
Cleaning of tools:	BAJAK's TOOL CLEANER 99610		
Indicated film thickness, dry:	50 micron/2 mils (See REMARKS overleaf)		
Indicated film thickness, wet:	75 micron/3 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. 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 ZINC 17360

SURFACE PREPARATION: Remove oil and grease thoroughly with suitable detergent. Remove salt and other contaminants by high pressure fresh water cleaning. Abrasive blasting to Sa2½ with a sharp-edged surface profile corresponding to Rugotest No. 3, BN9a, Keane-Tator comparator, 2.0 G/S, 2 S, or ISO comparator, Medium (G).

APPLICATION CONDITIONS: Use only where application and curing can proceed at temperatures above -10°C/15°F. The temperature of the surface must also be above this limit. The paint itself should be 15°C/59°F or above. 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.

SUBSEQUENT COAT: As listed below in accordance with specification.

REMARKS: **Note:** If used as anticorrosive protection under insulation of high temperature equipment it is very important that NO moisture can penetrate during slow-down periods. This to avoid risk of "wet corrosion" when the temperature rises.

Film thickness: May be specified in another film thickness than indicated depending on purpose and area of use. Most typical range is 40-50 micron/1.6-2 mils, but thickness down to 15 micron/0.6 mils (extra thinning) and up to 80 micron/3.2 mils may be possible. This will alter spreading rate and may influence amount of thinning necessary, drying time, and recoating interval.

Recoating: Recoating intervals, 50 micron dry film thickness for BAJAPOX ZINC 17360.

	Minimum			Maximum		
Surface temperature	20°C/68°F			20°C/68°F		
	Atmospheric		Water immersion	Atmospheric		Water immersion**
Recoating with (quality numbers only)	Medium	Severe		Medium	Severe	
58030	30 minutes	1 hour	Not relevant	12 hours	8 hours	Not relevant
46410 – 46370	30 minutes	1 hour	Not relevant	8 hours	5 hours	Not relevant
46330	30 minutes	1 hour	Not relevant	12 hours	8 hours	Not relevant
17630	2 hours	4 hours	4 hours	None	30 days*	30 days*
45880	2 hours	4 hours	Not relevant	None	30 days*	Not relevant

* Depending on actual local conditions, extended maximum recoating intervals may apply.

** Water immersion service is only recommended if BAJAPOX ZINC 17360 is applied in maximum 30-40 micron 1.2-1.6 mils and recoated with an epoxy coating system in 250-300 micron/10-12 mils.

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

Note: Before recoating after exposure in contaminated environment, clean the surface thoroughly by high pressure fresh water hosing and allow to dry. In addition, scrubbing with a stiff brush may be necessary to remove zinc corrosion products (white rust). **BAJAPOX ZINC 17360 is for professional use only.**



BAJAPOX 17630 BAJAPOX 17633

Medium to high temperature: 17630 with CURING AGENT 97330

Low to medium temperature: 17630 with CURING AGENT 98420

Description:	BAJAPOX 17630/17633 is a two-component, high-build, polyamide adduct-cured epoxy paint which cures to a hard and tough coating with good resistance to abrasion seawater and crude oils.	
Recommended use:	As a selfprimed coating for ballast water tanks and similar. As a primer for epoxy systems for atmospheric or in-water service. Suitable for application down to -10°C/15°F. BAJAPOX 17633 is intended for use in cold/temperate climates, BAJAPOX 17630 is intended for use in temperate to warm climates.	
Service temperatures:	Dry:	Maximum 120°C/248°F (See REMARKS overleaf)
	Ballast water service:	Resists normal ambient temperatures at sea*
	Other water service:	40°C/104°F (no temperature gradient)
	Other liquids:	Contact BAJAK
	*Avoid long-term exposure to negative temperature gradients.	

PHYSICAL CONSTANTS:

	17630	17633
Mixed product:	Grey - cream	Grey - cream
Colours:	Semi-flat	Semi-flat
Finish:	68±1	68±1
Volume Solids, %:	4.5 m ² /litre - 150 micron	4.5 m ² /litre - 150 micron
Theoretical spreading rate:	182 sq.ft./US gallon - 6 mils	182 sq.ft./US gallon - 6 mils
Flash point:	32°C/90°F	32°C/90°F
Specific gravity:	1.4 kg/litre – 11.7 lbs/US gallon	1.4 kg/litre – 11.7 lbs/US gallon
Dry to touch:	7-8 hours at 20°C/68°F	20 hours (app.) at 5°C/41°F
Fully cured:	7 days at 20°C/68°F	20 days at 5°C/41°F
V.O.C.:	315 g/litre – 2.6 lbs/US gallon	315 g/litre – 2.6 lbs/US gallon

APPLICATION DETAILS:

	17630	17633
Mixing ratio:	Base 17630 : Curing agent 97330 4 : 1 parts by volume	Base 17633 : Curing agent 98420 4 : 1 parts by volume
Application method:	Airless spray Brush	Air spray Brush
Thinner (max.vol.):	08450 (5%) 08450 (5%)	08450 (5%) 08450 (5%)
Pot life:	2 hours (20°C/68°F)	
Induction time:	See REMARKS overleaf	
Nozzle orifice:	0.019" – 0.023"	
Nozzle pressure:	250 bar/3600 psi (Airless spray data are indicative and subject to adjustment)	
Cleaning of tools:	BAJAK'S TOOL CLEANER 99610	
Indicated dft:	150 micron/6 mils	
Indicated wft:	225 micron/9 mils	
Recoat interval, min:	8 hours (20°C/68°F)	
Recoat interval, max:	See separate APPLICATION INSTRUCTIONS	

BAJAPOX 17630/17633

SURFACE PREPARATION:	<p>New steel: Remove oil and grease, etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. Abrasive blasting to Sa 2½. For temporary protection, if required, use a 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 17630.</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 St 3 (minor areas) or by abrasive blasting to min. Sa 2, preferably to Sa 2½. Improved surface preparation will improve the performance of BAJAPOX 17630/17633.</p> <p>As an alternative to dry cleaning, water jetting to sound, well adhering coat and/or to steel. Intact coat must appear with roughened surface after the water jetting. By water jetting to steel, cleanliness shall be WJ-3 to WJ-2 (atmospheric exposure)/minimum WJ-2 (immersion) (NACE No. 5/SSPC-SP12). A flash-rust degree of maximum FR-2 (atmospheric exposure) / FR-2, preferably FR-1 (immersion) (BAJAK standard) is acceptable before application. Feather edges to sound and intact paint. Dust off residues. Touch up to full film thickness.</p> <p>On pit-corroded surfaces, excessive amounts of salt residues may call for water jetting or wet abrasive blasting, alternatively dry abrasive blasting followed by high pressure fresh water hosing, drying, and finally, dry abrasive blasting again.</p>
APPLICATION CONDITIONS:	<p>Use only where application and curing can proceed at temperatures above -10°C/14°F (curing agent 98420) and 0°C/32°F (curing agent 97330). The temperature of the paint itself should be above 15°C/59°F for proper application. Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation.</p> <p>In confined spaces provide adequate ventilation during application and drying.</p>
SUBSEQUENT COAT:	None or according to specification.
REMARKS:	
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.
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 125-200 micron/5-8 mils.
Mixing/ Induction time:	To facilitate proper application properties it is recommended to allow the thoroughly mixed BASE and CURING AGENT to prereact before application. In case two-component spray-equipment is used, paint material is to be heated. Consult separate APPLICATION INSTRUCTIONS.
Note:	BAJAPOX 17630/17633 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.

**BAJAK'S SEALER 20026****BAJAK'S SEALER 20027**

CURING AGENT 90026

CURING AGENT 90027

Description:

BAJAK'S SEALER 20026 & 20027 is a solvent-base, two-component polyamine epoxy coating. With low molecular weight and good penetration property on dry or damp & humid, fully cured concrete structures.

Recommended use:

20026 can be used as a high performance sealer with excellent adhesion to wide range of mechanically cleaned absorbance surface like concrete in dry condition. And 20027 can be used for damp & humid concrete surfaces

PHYSICAL CONSTANTS:

Colours/Shade No:	Transparent /0116
Finish:	Glossy
Volume Solids, %:	65
Theoretical spreading rate:	10 m ² /litre – 65 micron
Flash point:	37°C
Specific gravity:	1 kg/liter – 8.3 lbs/US gallon
Surface dry:	1 Hour 20°C/68°F
Dry to touch:	2-4 hours at 20°C/68°F
Fully cured:	5 days at 20°C/68°F

The physical constants are subject to normal manufacturing tolerances.

APPLICATION DETAILS:

Mixing ratio for 20026:	Base 20026 : Curing Agent 90026 10 : 3 by weight	
Mixing ratio for 20027:	Base 20027 : Curing Agent 90027 10 : 3 by weight	
Application method:	Brush	Roller
Thinner (max.vol.):	08020 (20%)	08020 (25%)
Pot life:	2 hours (20°C/68°F)	
Cleaning of tools:	BAJAK'S THINNER 08020	
Indicated film thickness:	As per specification.	
Recoat interval, min:	4 hours (20°C/68°F)	
Recoat interval, max:	5 days (20°C/68°F)	

2-BAJAK'S SEALER 20026-20027

SURFACE PREPARATION:	<p>Steel: Abrasive blasting to minimum ISO 8501-1:1988 standard Sa 2½ - 3, depending on area of use. Emulsifier cleaning and salts must remove minimum roughness corresponding to Rugotest No. 3, BN11. Oil and grease by high pressure hosing prior to blasting. After blasting, clean the surface carefully from abrasive and dust.</p> <p>Concrete: Fully cured</p> <p>The concrete must be of good quality and fully cured. Minimum pull-off value should normally be 20 kilopond/cm² measured after surface preparation.</p> <p>Cracks, crevices and voids must be repaired. The surface must be free from dust, grease, etc. Laitance layer and loose particles must be removed, preferably by abrasive sweeping. The blasted or otherwise treated surfaces must be cleaned from dust abrasive, etc., preferably by high pressure water hosing, whereupon complete drying must take place for 20026 quality.</p>
APPLICATION CONDITIONS:	Minimum temperature of material and substrate during application should be 15°C/59°F while curing will proceed down to 10°C/50°F. Clean and dry surface with a temperature above the dew point to avoid condensation.
PRECEDING COAT:	According to specification.
SUBSEQUENT COAT:	BAJAPOX 33820, BAJAPOX HIGH-STRENGTH 35530 Bajapox Hi-Build 45200 or according to specification.
REMARKS:	Maximum recoating interval is 5 days without film formation on sealed surface and 8 hrs if glossy film is formed.
APPLICATION:	For further application details, consult the application instructions or contact the BAJAK office.

Note: **Bajak's sealer 20026-20027 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. Harmful or fatal if swallowed; Immediately seek medical assistance if swallowed, Avoid inhalation of possible solvent vapours or paint mist, as well as paint contact with skin and eyes. 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. Always take precautions against the risks of fire and explosions.

Issued: Oct. 2008

BAJAK STYRENE ACRYLIC PRIMER/SEALER 21541

Description:	BAJAK STYRENE ACRYLIC PRIMER/SEALER 21541 is a water- borne alkali resistant acrylic primer/sealer with excellent penetration and dust binding properties. For use under solvent-borne as well as under water- borne coatings.		
Area of use:	Interior and exterior: Walls, ceilings, partitions, etc.		
Substrates:	Concrete, masonry, cement rendering, plaster, wood, etc.		

PHYSICAL CONSTANTS:

Colour/Shade nos:	Milky		
Finish:	Gloss		
Volume Solids, %:	11%		
Theoretical spreading rate:	37.0 m ² /litre at 30 micron*		
Specific gravity:	1.1 kg/litre		
Dry to touch:	2 hours (10°C)	1 hour (20°C)	30 minutes (40°C)

***The spreading rate** has been calculated theoretically for application onto a primed and smooth surface. The actual rates may differ significantly as the primer/sealer is intended to be applied to rough and porous substrates. The actual rates will also depend on the extent of thinning, the application method and the relevant consumption factor.

The physical constants are subject to normal manufacturing tolerances. Further reference is made to "Explanatory Notes".

APPLICATION DETAILS:

Application method:	Brush/roller		
Thinner (max. vol.):	Distilled water		
Cleaning of tools:	Distilled water		
Recoat interval, min:	2 hours (10°C)	30 minutes (40°C)	
Recoat interval, max:	None	None	

Surface condition: The surface should be stable, firm, dry and free of dust, sand, loose old paint, laitance, dirt, grease and oil.

Remarks: Drying data given is on the assumption that proper ventilation is provided.

Note: **BAJAK STYRENE ACRYLIC PRIMER/SEALER 21541 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. Harmful or fatal if swallowed; immediately seek medical assistance if swallowed. Avoid inhalation of possible solvent vapours or paint mist, as well as paint contact with skin and eyes. 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. Always take precautions against the risks of fire and explosions.

2. BAJAK STYRENE ACRYLIC PRIMER/SEALER 21541

SURFACE PREPARATION : Remove all possible dirt & contamination like oil, grease, dust, loose material and make sure that the surface is completely cured than apply the sealer on it.

APPLICATION CONDITIONS: The concrete must be fully cured, eg 28 days for normal Portland cement, and completely dry with a humidity content in the surface below 4%. The concrete must also be controlled for absence of capillary water action or for subsoil water.
Use only where application and curing can proceed at temperatures above 10°C/50°F. Apply only on a dry surface, free of dust, grease, oil and other contamination - as described above. In confined spaces provide adequate ventilation during application and drying.

Issued: November 2010



بازاک (سهامی خاص)

BAJAFIRE 26225

Description: BAJAFIRE 26225 is intumescent fire protection coating with an excellent thermal efficiency in today's market. From a design standpoint, it is now possible to achieve 60 Minutes fire protection to steel structural with only 1.1 mm. thickness.

Recommended use: As an intermediate and topcoat on primed steel to protect that from fire.

Service temperature: Dry: Maximum 50°C

Approval: Approved as a fire retardant coating by Amir Kabir University of Technology (Polytechnic) & also approved by Houshing & Urban Development Research Center.

PHYSICAL CONSTANTS:

Colors/Shade No: White/9034
Finish: Flat
Volume solid: 50%
Theoretical spreading rate: 1.67 m²/liter – DFT: 300 µm
Flash point: 22°C
Specific gravity: App. 1.3 kg/liter
Surface dry: Max. 2 hours at 20°C (ISO 1517)
Dry to touch: Max. 4 hours at 20°C
Fully cured: 15 days
Shelf life: 1 Year (25°C/77°F) from time of production. Depending on storage condition, mechanical stirring may be necessary before usage.

APPLICATION DETAILS:

Application method:	Airless sprays	Brush (touch-up)
Thinner (max. vol.)	1101 (5%)	1101 (5%)
Nozzle orifice:	0.023	
Nozzle pressure:	260 bar / 3770 Psi	
	(Airless spray data are indicative and subject to adjustment)	
Cleaning of tools:	1101	
Indicated film thickness, dry:	300 microns	
Indicated film thickness, wet:	600 microns	
Recoat interval, min:	8 hours (20°C)	
Recoat interval, max:	None	

Issued: July 2009

Bajafire 26225

SURFACE PREPARATION:	Remove oil and grease, etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. Abrasive blasting to Sa 2½ SSPC-SP-10, with a sharp-edged surface profile corresponding to Rugotest No. 3, BN9a, Keane-Tator Comparator, 2.0 G/S, 2 S, or ISO Comparator, Medium (G) corresponding to Segment 2.
APPLICATION AND CURING CONDITIONS:	The surface must be completely clean and dry at the time of application. And its temperature must be above the dew point to avoid condensation. Minimum temperature for curing is 5°C/41 °F. At the freezing point and below, be aware of the risk of ice on the surface which will hinder the adhesion. High humidity and/or condensation during application and the following 16 hours (20°C/68°F) may adversely affect the film formation. In confined spaces provide adequate ventilation during application and drying.
PRECEDING COAT:	BAJAK zinc phosphate 15300
SUBSEQUENT COAT:	26225
REMARKS:	
Film thicknesses:	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 is 300 microns/12 mils. For more than 2 hours fire protection more coats should be applied.
Thinning:	The type and amount of thinner depends on application conditions, application method, temperature, ventilation, and substrate. Thinner 1101 is recommended in general. A completely clean surface is mandatory to ensure inter coat adhesion, especially at long recoating intervals. Any dirt, oil, and grease have to be removed, e.g. with suitable detergent. Salts to be removed by fresh water hosing. To check an adequate quality of the surface cleaning a test patch is recommended before actual recoating.
SAFETY:	Handle with care. Before and during use, observe all safety labels on packing and paint containers, consult BAJAK material safety data sheets and follow all local and national safety regulations. Harmful or fatal if swallowed; immediately seek medical assistance swallowed. Avoid inhalations of possible solvent vapors or paint mist, as well as paint contact with skin and eyes. Apply only on well-ventilated areas and ensure that adequate forced ventilation exists when applying paint in confined spaces or when the air is stagnant. Always take precautions against the risks of fire and explosions.
Issued:	July 2009



BAJAK'S SILTEX SEALER 26600

Description: BAJAK'S SILTEX SELAER 26600 is an alkali resistant, acrylic primer/sealer. Excellent penetration and dust binding properties on mineral substrates. Especially developed for use in BAJAK'S CONTEX anti-carbonation systems.

Area of use: **Exterior:** Walls.

Substrates: Concrete, masonry, cement rendering, asbestos, etc.

PHYSICAL CONSTANTS:

Colour/Shade nos:	White		
Finish:	Flat		
Volume Solids, %:	29%		
Theoretical spreading rate:	9.7 m ² /litre at 30 micron*		
Flash point:	38°C		
Specific gravity:	1.1 kg/litre		
Dry to touch:	2 hours (10°C)	1 hour (20°C)	30 minutes (40°C)

***The theoretical spreading rate** has been calculated for application on a primed and smooth surface. The actual rates may differ significantly as the sealer is intended to be applied to rough and porous substrates. The actual rates will also depend on the extent of thinning, the application method and the relevant consumption factor.

The physical constants are subject to normal manufacturing tolerances. Further reference is made to "Explanatory Notes".

APPLICATION DETAILS:

Application method:	Airless spray	Brush/roller
Thinner (max. vol.):	08080 (15%)	08080 (15%)
Nozzle orifice:	.017" - .021"	
Nozzle pressure:	100 bar/1450 psi (Airless spray data are indicative and subject to adjustment)	
Cleaning of tools:	THINNER 08080	
Recoat interval, min:	2 hours (10°C)	1 hour (20°C)
Recoat interval, max:	None	

Surface condition: The surface should be stable, firm, dry and free of dust, sand, loose old paint, laitance, dirt, grease and oil.

Remarks: Drying data given is on the assumption that proper ventilation is provided.

Note: **BAJAK'S SILTEX SEALER 26600 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. Harmful or fatal if swallowed; immediately seek medical assistance if swallowed. Avoid inhalation of possible solvent vapours or paint mist, as well as paint contact with skin and eyes. 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. Always take precautions against the risks of fire and explosions.

2. BAJAK'S SILTEX SEALER 26600

SURFACE PREPARATION :	<p>All possible slip agent, oil, grease and other contaminants must be removed by eg abrasive blasting, volatilizing by flame cleaning or treatment with suitable detergent. Last mentioned in the following way: Saturation of the surface with fresh water. Washing with detergent followed by fresh water hosing.</p> <p>Depending on construction and purpose, abrasive blast, high pressure water jet or treat the concrete with power tools to obtain a rough and firm surface free of scum layer and other contamination. Remove dust and loose material. If mechanical treatment is impossible, the surface may be treated with acid etching. For this purpose an approx. 5% w/w nitric or phosphoric acid solution is recommended. Note: Strong acids, take necessary precautions, make sure that safety regulations are obeyed! Prior to etching the concrete should be saturated with fresh water to prevent acid corrosion of the reinforcement bars. Leave the acid to act for 3-4 minutes and hose down the surface with fresh water - preferably first a 5% w/w sodium hydroxide solution - and scrub carefully. After that the surface must dry homogeneously and appear as an even, rough surface free of a loose outer layer. The surface must have a pH reaction of between 6.5-8.0. If any of these conditions are not fulfilled, the process must be repeated. The surface must be dried with good ventilation for at least 2 days (65% relative humidity and 20°C/68°F). The pretreatment is controlled by scraping with a strong knife. The surface shall feel solid and hard, and the knife must only leave a clear scratch mark.</p>
APPLICATION CONDITIONS:	<p>The concrete must be fully cured, eg 28 days for normal Portland cement, and completely dry with a humidity content in the surface below 4%. The concrete must also be controlled for absence of capillary water action or for subsoil water.</p> <p>Use only where application and curing can proceed at temperatures above 10°C/50°F. Apply only on a dry surface, free of dust, grease, oil and other contamination - as described above. In confined spaces provide adequate ventilation during application and drying.</p>
Issued:	August 2004– 26600



BAJAK'S ANTI-SLIP CLEAR COAT 29020

CURING AGENT 63822

Description: BAJAK'S ANTI-SLIP CLEAR COAT 29020 is a solvent-free, two-component polyamine epoxy coating. On concrete structures.

Recommended use: 29020 can be used as a high performance anti-slip top coat with excellent adhesion to wide range of existing coatings on steel and concrete

PHYSICAL CONSTANTS:

Colours/Shade nos:	Transparent /0000
Finish:	Glossy and Textured
Volume Solids, %:	100
Theoretical spreading rate:	10 m ² /litre – 100 micron
Flash point:	95°C
Specific gravity:	1.1 kg/liter – 6.0 lbs/US gallon
Surface dry :	3-4 Hours
Dry to touch:	24 hours at 20°C/68°F
Fully cured:	7 days at 20°C/68°F

The physical constants are subject to normal manufacturing tolerances.

APPLICATION DETAILS:

Mixing ratio for 29020:	Base 29020 : Curing Agent 63822	
	2: 1 by weight	
Application method:	Roller	Brush
Thinner (max.vol.):	Do not dilute	Do not dilute
Pot life:	2 hours (20°C/68°F)	
Cleaning of tools:	BAJAK'S TOOL CLEANER 99610	
Indicated film thickness:	As per specification.	
Recoat interval, min:	24 hours (20°C/68°F)	
Recoat interval, max:	3 days (20°C/68°F)	

Issued:

March 2014

2-BAJAK'S ANTI-SLIP CLEAR COAT 29020

SURFACE PREPARATION :	Coated concrete and Steel : Cracks, crevices and voids must be repaired. The surface must be dry and free from dust, grease, etc. Laitance layer and loose particles must be removed, preferably by abrasive sweeping. The blasted or otherwise treated surfaces must be cleaned from dust abrasive, etc. , preferably by high pressure water hosing, whereupon complete drying must take place.
APPLICATION CONDITIONS:	Minimum temperature of material and substrate during application should be 15°C/59°F while curing will proceed down to 10°C/50°F. Clean and dry surface with a temperature above the dew point to avoid condensation.
PRECEDING COAT:	BAJAPOX FLOORING, BAJATHANE FLOORING or According to specification.
SUBSEQUENT COAT:	None.
REMARKS:	
APPLICATION:	For further application details, consult the application instructions or contact the BAJAK office.

Note: **BAJAK'S ANTI-SLIP CLEAR COAT 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. Harmful or fatal if swallowed; Immediately seek medical assistance if swallowed, Avoid inhalation of possible solvent vapors or paint mist, as well as paint contact with skin and eyes. 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. Always take precautions against the risks of fire and explosions.

Issued: March 2014



بازاک (سهامی خاص)

BAJAK'S VINYL CHLORIDE TOPCOAT NO.29334

Description:	BAJAK'S 29334 is topcoat vinyl chloride coating .
Recommended use:	Steel and concrete structures Exposed to moderate corrosive environments .
Service temperature:	Maximum, dry: 80 ℃

PHYSICAL CONSTANTS:

Colors/Shade No:	Any shade is available according RAL catalogue
Finish:	Semi gloss to glossy.
Volume Solid:	App. 35 %
Theoretical spreading rate:	10 sqm/ltr in dft 35 micron
Flash point:	24 ℃
Specific gravity:	1.20 - 1.25 according to shade.
Surface dry:	20min/20 ℃
Dry to touch:	Max. 2 hours at 20 ℃
V.O.C.:	560 gr/liter
Shelf life:	1 Year (25 ℃/77 ℉) from time of production. Depending on storage condition, mechar stirring may be necessary before usage.

APPLICATION DETAILS:

Application method:	Airless spray	Brush
Thinner (max. vol.):	S 1043 (5%)	S 1043 (30%)
Nozzle orifice:	0.018 - 0.027"(0.46 - 0.69)	
Nozzle pressure:	15Mpa 15KP/Sq.Cm(2100 Psi) (Airless spray data are indicative and subject to adjustment)	
Cleaning of tools:	S 1043	
Indicated film thickness, dry:	35 microns	
Indicated film thickness, wet:	100 microns	
Recoat interval, min:	2 hours (20 ℃)	
Recoat interval, max:	30 days (20 ℃), See REMARKS overleaf	

Issued: Feb. 2007

2.BAJAK'S VINYL CHLORIDE TOPCOAT 29334

APPLICATION AND CURING CONDITIONS: The surface must be completely clean and dry at the time of application, And its temperature must be above the dew point to avoid condensation. At the freezing point and below, be ware of the risk of ice on the surface which will hinder the adhesion. High humidity and/or condensation during application and the following 16 hours (20°C/68 f) may adversely affect the film formation. In confined spaces provide adequate ventilation during application and drying.

SUBSEQUENT COAT: May be specified in another film thickness than indicated depending on purpose and area of use.
REMARKS:
Film thicknesses: This will alter spreading rate and may influence drying time and recoating interval. Normal range is 35 microns.

Film thicknesses:
Thinning: The type and amount of thinner depend on application conditions, application method, temperature, ventilation, and substrate. Thinner S 1043 is recommended in general.

Recoating
And drying/curing Time:

Physical data versus temperatures:	Minimum		Maximum	
Steel temperature	20°C/68f		20°C/68f	
Recoated with	Atmospheric		Atmospheric	
	Mild	Medium	Mild	Medium
Chlorinated rubber system	1 hour	2 hour	None	30 days

A completely clean surface is mandatory to ensure intercoat adhesion, especially at long recoating intervals. Any dirt,oil,and grease have to be removed, e.g. with suitable detergent Salts to be removed by fresh water hosing. To check an adequate quality of the surface cleaning a test patch is recommended before actual recoating.

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 and national safety regulations. Harmful or fatal if swallowed; immediately seek medical assistance swallowed. Avoid inhalations of possible solvent vapors or paint mist, as well as paint contact with skin and eyes. Apply only on well-ventilated areas and ensure that adequate forced ventilation exists when applying paint in confined spaces or when the air is stagnant. Always take precautions against the risks of fire and explosions.

Issued: Feb. 2007



بازاک (سهامی خاص)

BAJAK'S VINYL CHLORIDE PRIMER NO.29634

Description:	BAJAK'S 29634 is a high solid protective primer.
Recommended use:	Steel and concrete structures Exposed to moderate environments.
Service temperature:	Maximum, dry: 80 °C

PHYSICAL CONSTANTS:

Colors/Shade No:	Gray
Finish:	flat
Volume Solid:	App. 37 %
Theoretical spreading rate:	4.9 sqm/ltr in dft 75 micron
Flash point:	24 °C
Specific gravity:	1.25 - 1.3
Surface dry:	20min/20 °C
Dry to touch:	Max. 2 hours at 20 °C
V.O.C.:	572 gr/liter
Shelf life:	1 Year (25 °C/77 °F) from time of production. Depending on storage condition, mechanical stirring may be necessary before usage.

APPLICATION DETAILS:

Application method:	Airless spray	Brush
Thinner (max. vol.):	S 1043 (5%)	S 1043 (30%)
Nozzle orifice:	0.018" - 0.027" (0.46 - 0.69)	
Nozzle pressure:	15Mpa 15KP/Sq.Cm(2100 Psi) (Airless spray data are indicative and subject to adjustment)	
Cleaning of tools:	S 1043	
Indicated film thickness, dry:	75 microns	
Indicated film thickness, wet:	200 microns	
Recoat interval, min:	2 hours (20 °C)	
Recoat interval, max:	30 days (20 °C), See REMARKS overleaf	

Issued: April 2001

2. BAJAK'S VINYL CHLORIDE PRIMER 29634

APPLICATION AND CURING CONDITIONS: The surface must be completely clean and dry at the time of application, And its temperature must be above the dew point to avoid condensation.
:At the freezing point and below, be ware of the risk of ice on the surface which will hinder the adhesion. High humidity and/or condensation during application and the following 16 hours (20C/68 F) may adversely affect the film formation.
In confined spaces provide adequate ventilation during application and drying.

SUBSEQUENT COAT: Vinyl Chloride systems according to specification.

REMARKS:
Film thicknesses: 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 is 40-75 microns.

Thinning: The type and amount of thinner depend on application conditions, application method, temperature, ventilation, and substrate. Thinner S 1043 is recommended in general.

Recoating
And drying/curing
Time:

Physical data versus temperatures:	Minimum		Maximum	
Steel temperature	20C/68F		20C/68F	
Recoated with:	Atmospheric		Atmospheric	
	Mild	Medium	Mild	Medium
Chlorinated rubber system	1 hour	2 hour	None	30 days

A completely clean surface is mandatory to ensure intercoat adhesion, especially at long recoating intervals. Any dirt, oil, and grease have to be removed, e.g. with suitable detergent.

Salts to be removed by fresh water hosing. To check an adequate quality of the surface cleaning a test patch is recommended before actual recoating.

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 and national safety regulations. Harmful or fatal if swallowed; immediately seek medical assistance swallowed. Avoid inhalations of possible solvent vapors or paint mist, as well as paint contact with skin and eyes. Apply only on well-ventilated areas and ensure that adequate forced ventilation exists when applying paint in confined spaces or when the air is stagnant. Always take precautions against the risks of fire and explosions.

Issued: April 2001

2.BAJAK'S VINYL CHLORIDE MIDCOAT 29834

APPLICATION
AND CURING
CONDITIONS:

The surface must be completely clean and dry at the time of application, And its temperature must be above the dew point to avoid condensation.
At the freezing point and below, be ware of the risk of ice on the surface which will hinder the adhesion. High humidity and/or condensation during application and the following 16 hours (20C/68 F) may adversely affect the film formation.
In confined spaces provide adequate ventilation during application and drying.

SUBSEQUENT
COAT:

Vinyl chloride primer 29834
Vinyl Chloride systems according to specification.

REMARKS:

Film thicknesses:

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 is 40 microns.

Thinning:

The type and amount of thinner depend on application conditions, application method, temperature, ventilation, and substrate. Thinner S 1043 is recommended in general.

Recoating
And drying/curing
Time:

Physical data versus temperatures:	Minimum		Maximum	
Steel temperature	20C/68F		20C/68F	
Recoated with	Atmospheric		Atmospheric	
	Mild	Medium	Mild	Medium
Chlorinated rubber system	1 hour	2 hour	None	30 days

A completely clean surface is mandatory to ensure intercoat adhesion, especially at long.

Recoating intervals. Any dirt,oil,and grease have to be removed, e.g. with suitable detergent.

Salts to be removed by fresh water hosing. To check an adequate quality of the surface cleaning a test patch is recommended before actual recoating.

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 and national safety regulations. Harmful or fatal if swallowed; immediately seek medical assistance swallowed. Avoid inhalations of possible solvent vapors or paint mist, as well as paint contact with skin and eyes. Apply only on well-ventilated areas and ensure that adequate forced ventilation exists when applying paint in confined spaces or when the air is stagnant. Always take precautions against the risks of fire and explosions.

Issued:

Feb. 2007



BAJAK INTERMEDIATE AND TOPCOAT 30820

Description:

BAJAK 30820 is a two-component epoxy polyamide intermediate and finish with good wetting properties and low water permeability, which cures to a hard wearing and good resistance against abrasion and impact as well as to seawater, mineral oils, aliphatic hydrocarbons and splashes from petrol.

Recommended use:

1. As a intermediate and topcoat on primed steel.
2. For repair and maintenance work.
3. As a finishing coat where a cosmetic appearance is of less importance.

Service temperatures:

	Dry:	Wet:
Maximum:	140°C	40°C

TECHNICAL DATAS:

Binders:	Epoxy resin and polyamide.
Pigments:	TiO ₂ , extender and colored pigment.
Solvents:	Ketons, Alcohols and aromatic hydrocarbons.
Hardener:	60021

PHYSICAL CONSTANTS:

Mixed product:	30820
Colours/Shade no:	Grey
Finish:	Semi gloss, when expose to weather return to semi-flat
Volume Solids, %:	App. 60
Theoretical spreading rate:	10 m ² /litre – 60 micron DFT
Flash point:	26°C
Specific gravity:	App. 1.3 kg/litre
Surface dry:	Max. 2 hrs-20°C (ISO 1517)
Dry to touch:	Max. 7 hrs-20°C
Fully cured:	Max. 7 days-20°C
V.O.C.:	App. 385 g/litre

APPLICATION DETAILS:

Mixing ratio for 30820:	Base 30820 : Curing agent 60021 4 : 1 by volume		
Application method:	Airless spray	Air spray	Brush
Thinner (max.vol.):	S1040 (5%)	S1040 (15%)	S1040 (5%)
Pot life:	8 hours (20°C) (airless)		
Nozzle orifice:	.019" - .023"		
Nozzle pressure:	200 bar/3000 psi		
Cleaning of tools:	S1040		
Indicative dft:	60 micron		
Indicative wft:	100 micron		
Recoat interval, min:	8 hrs-20°C		
Recoat interval, max:	7 days-20°C		

2. BAJAK INTERMEDIATE AND TOPCOAT 30820

SURFACE PREPARATION:	Abrasive blasting to sa2½ with a surface profile corresponding to rugotest No. 3, BN10, Kean-Tator comparator, Rough medium (G).
APPLICATION CONDITIONS:	Use only where application and curing can proceed at temperature of the surface and that of the paint itself must be above 10°C. The temperature of the surface and that of the paint itself must be above this limit. Optimum results are obtained at 17°C. Apply only on a dry and clean surface with a 17°C. Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. Relative humidity max. 80%, preferably 40-60%.
PRECEDING COAT:	None, or as per specification.
SUBSEQUENT COAT:	None, or as per specification.
REMARKS: Recoating:	If the maximum recoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion.
Note:	BAJAK INTERMEDIATE AND TOPCOAT 30820 is for professional use only.
Safety:	Handle with care. Before and during use, observe all safety labels on packaging and paint containers. Avoid inhalation of possible solvent vapours or paint mist, as well as paint contact with skin and eyes. Apply only in well ventilated areas.
Issued:	Feb. 2000



BAJAK MASONARY PUTTY 31540

Description: BAJAK 31540 is a quick drying water base putty which has good applicability and easy to sand paper.

Recommended use: As a general purpose putty for Bajalin and Bajatex systems on concrete surfaces in moderately corrosive environments.

PHYSICAL CONSTANTS:

Mixed product:	31540
Colours/Shade no:	White/9034 series
Finish:	Flat
Volume Solids, %:	50
Theoretical spreading rate:	2 m ² /liter at 250 mic. D.F.T.
Flash point:	None
Specific gravity:	Approx. 1.6 kg/litre
Surface dry:	1 hour at 20°C (ISO 1517)
Dry to touch:	Max. 90 min. at 20°C
V.O.C.:	30 g/liter

APPLICATION DETAILS:

Application method:	Trowel & blade
Thinner (max.vol.):	None
Cleaning of tools:	water
Indicative dft:	250 microns/10 mils
Indicative wft:	500 microns/20 mils
Sand paper time:	4 hours

2. BAJAK MASONARY PUTTY 31540

SURFACE PREPARATION:	A clean surface which is coated with sealer or primer as specified in the specification is mandatory.
APPLICATION CONDITIONS:	As detected by normal good painting practice. In confined spaces provide adequate ventilation during application and drying.
PRECEDING COAT:	Bajalin primer 13200.
SUBSEQUENT COAT:	BAJAK alkyd or acrylic emulsion systems according to specification.
REMARKS: Over coating:	Before over coating use sand paper to remove edges, trowel lines and all irregularities and remove dust from the surface.
Note:	BAJAK MASONARY PUTTY 31540 is 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. Harmful or fatal if swallowed; immediately seek medical assistance swallowed. Avoid inhalations of possible solvent vapors or paint mist, as well as paint contact with skin and eyes. Apply only on well-ventilated areas and ensure that adequate forced ventilation exists when applying paint in confined spaces or when the air is stagnant. Always take precautions against the risks of fire and explosions.
Issued:	July 2019



BAJAK'S SUPER POLYESTER PUTTY 31582

CURING AGENT 61080

Description:	Bajak's Super Polyester Putty 31582 is a two-component, flexible unsaturated polyester putty which could be used for filling pits cracks and voids in steel, concrete, wood and other surfaces. Has a unique ability to be mixed, applied and cured above 10°C with an excellent abrading property in thick layer in automotive industry.
Recommended use:	As a hand applied repair compound for application on clean or primed steel and concrete to fill and smooth the surface.
Surface Preparation:	Remove oil and grease, etc. with suitable detergent. Remove salt and other contaminants by (high press
Application Condition:	Apply only on a dry and clean surface with a temperature 3°C above the dew point to avoid condensation. To facilitate stirring, the material temperatures should in no case be l
PHYSICAL CONSTANTS:	
Mixed product:	31582
Colours/Shade no:	Grey 7009
Finish:	Flat
Volume Solids, %:	99±1
Theoretical spreading rate:	4.95 m ² /litre at 200 μ 3.3 m ² /litre at 300μ
Recommended dry film thickness:	200 – 300 μ
Specific gravity:	1.70±0.05 kg/litre
Dry to sanding:	60 min. At 20°C
APPLICATION DATA:	
Mixing ratio for 31582:	BASE 31582 : Curing agent 61080 50 : 1 by weight
Application method:	Hand molding or palette knife
Thinner:	None
Get time:	5-10 min. At 20°C
Shelf life:	12 months
Packing:	
31582	In 1.8 kg can
Curing agent 61080	In 25 x 2 gr tube
	Other packing available on request
Subsequent Coat:	Epoxy coating or baking coating.
Preceding coat;	None
REMARKS:	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 film thickness is 200 - 300 micron.
Safety:	Handle with care. Before and during use, observe all safety labels on packaging and paint containers, our 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 directs 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.



BAJAK WASH PRIMER 31655

CURING AGENT 61100

Designation:

BAJAK WASH PRIMER 31655 is a two component polyvinyl butyral wash primer/etch primer which ensures adhesion of the paint to the surface and improves resistance against corrosion.

First priming for well-cleaned surfaces of Iron, Zinc, and Aluminum.

PHYSICAL CONSTANTS:

Colours:	Yellow
Finish:	Flat
Volume Solids, %:	6-10%
Theoretical spreading rate:	7 m ² /litre , 10 mic
Flash point:	12°C
Specific gravity:	0.823-0.863 kg/litre
Surface dry :	20 min
Shelf life:	6 month and over at 20°C

APPLICATION DETAILS:

Mixing ratio:	Base 31655 : Curing agent 61100 1 : 2 by weight		
Application method:	Airless spray	Air spray	Roller/Brush (touch-up)
Thinner (max.vol.):	Don't diluted	Don't diluted	Don't diluted
Pot life :	8 hours		
Nozzle orifice:	0.017" - 0.019"		
Nozzle pressure:	75 bar/1100 psi		
Cleaning of tools:	Thinner 08570		
Indicated dft:	5-10 microns/0.2-0.4 mil		
Indicated wft:	Not relevant		
Recoat interval, min:	1 hour (20°C/68°F)		
Recoat interval, max:	30 days (20°C/68°F)		

Issued: Feb. 2007

2. BAJAK WASH PRIMER 31655

SURFACE	Stainless steel: Steam cleaning
PREPARATION:	Galvanized steel: Steam cleaning or ammonia wash. Non-anodized aluminium: Steam cleaning or washing with non-alkaline, chlorine-free detergent. Possible remnants of detergent to be removed by scrubbing and fresh water hosing. Carbon steel: Remove oil & grease, etc. with suitable detergent. Remove salt and other contaminants by high pressure fresh water cleaning. Abrasive blasting to cleaning degree specified usually Sa 2½.
APPLICATION CONDITIONS:	Suitable for application in temperature between 10-55°C. Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation.
SUBSEQUENT COAT:	Bajapox, Bajalin, Bajapox, ... qualities or according specification.
REMARKS:	
Surface temperature:	Dry service temperature maximum 85°C/185°F.
Film thickness:	The wash primer is to be applied in a dry film thickness of only 5-10 microns by spray gun.
Mixing & pot life:	WASH PRIMER 31655 and CURING AGENT 61100 have an ultimate can stability but after mixing with the curing agent. The pot life is only 8 hours. After this time the mixture loses its ability of good adhesion although the mixed paint does not gel. Any left overs of mixed wash primer must be disposed off after 8 hours.
Issued:	Feb. 2007

2-BAJAK'S PRIMER 33620

SURFACE PREPARATION :	Steel : Abrasive blasting to minimum ISO 8501-1:1988 standard Sa 2½ - 3, depending on area of use. Minimum roughness corresponding to Rugotest No. 3, BN11. Oil and grease must be removed by emulsifier cleaning and salts by high pressure hosing prior to blasting. After blasting, clean the surface carefully from abrasive and dust. Concrete: (Dry, fully cured) The concrete must be of good quality and fully cured. Minimum pull-off value should normally be 20 kilopond/cm ² measured after surface preparation. Cracks, crevices and voids must be repaired. The surface must be dry and free from dust, grease, etc. Laitance layer and loose particles must be removed, preferably by abrasive sweeping. The blasted or otherwise treated surfaces must be cleaned from dust abrasive, etc. , preferably by high pressure water hosing, whereupon complete drying must take place.
APPLICATION CONDITIONS:	Minimum temperature of material and substrate during application should be 15°C/59°F while curing will proceed down to 10°C/50°F. Clean and dry surface with a temperature above the dew point to avoid condensation.
PRECEDING COAT:	According to specification.
SUBSEQUENT COAT:	None or BAJAPOX 33820, BAJAPOX HIGH-STRENGTH 35530 Bajapox Hi-Build 45200 or according to specification.
REMARKS: APPLICATION:	For further application details, consult the application instructions or contact the BAJAK office.

Note: **bajak's primer 33620 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. Harmful or fatal if swallowed; Immediately seek medical assistance if swallowed, Avoid inhalation of possible solvent vapours or paint mist, as well as paint contact with skin and eyes. 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. Always take precautions against the risks of fire and explosions.

Issued: March 2004

**BAJAK EPOXY PUTTY 33720**

CURING AGENT 63726

Description:	Bajak 33720 is a two-component solvent free epoxy polyamine putty for repairing pits cracks and voids in steel, concrete, wood and other surfaces.	
Recommended use:	As a hand applied repair compound for application to blasted steel and concrete.	
Service temperature:	Maximum Wet: 50°C/ 122°F	Dry: 93°C/ 200°F

PHYSICAL CONSTANTS:

Colours:	Light gray
Finish:	Semi Flat
Volume Solid:	100%
Theoretical spreading rate:	1 M2 /Liter - 1000 micron DFT.
Flash point:	100 °C/212° F
Specific gravity:	1.6 – 1.7 kg/liter
Surface dry:	2 hours at 20 °C/68 °F(ISO 1517)
Dry to touch:	2 -3 hours at 20 °C/68°F. (ISO 1517)
Dry to handle:	8 hrs.at 20 °C/68°F.

The physical constants are subject to normal manufacturing tolerances.

APPLICATION DETAILS:

	Base 33720 : Curing agent 63726	
Mixing ratio:	2 : 1 by volume	
Application method:	Hand molding or palette knife	
Pot life:	Working time at 20°C :	
	Golfball size mix:	40 minutes
	Baseball size mix:	30 minutes
	½ gallon mix:	15 minutes
	Working time is reduced by half at temperature above 27°C.	
Cleaning of tools:	THINNER 08020	
Indicated dft:	1000 microns / 40 mils	

2.BAJAK PUTTY 33720

SURFACE

New Steel: Abrasive blasting to minimum Sa 2½ or high pressure water blasting is recommended. The surface must be completely clean at the time of application.

PREPARATION:

A surface profile of 3-4mils (75-100 microns) is recommended.

For applying to bare steel under water or permanently in wet conditions the surface should be prepared by power diskling or by needle gun to achieved a clean, roughened surface in accordance with SSPC-SPI 1, power tool cleaning.

Repair and maintenance: Remove oil and grease, etc with suitable detergent. Clean damaged areas thoroughly by power tool cleaning to St 3 (minor areas) or by abrasive blasting to min. Sa 2, preferably to Sa2½.

Concrete: Abrasive blasting. The surface must be completely clean at the time of application.

APPLICATION CONDITION:

Use only on a clean surface. To facilitate stirring, the material temperature should in case be less than approx. 20°C/68°F. Use one 5 liters can of mixed at a time.

PRECEDEING COAT:

None.

SUBSEQUENT COAT:

None.

REMARKS:

Film thicknesses:

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 DFT is 1000 microns/ 40 mils.

Note:

BAJAK PUTTY 33720 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 and national safety regulations. Harmful or fatal if swallowed; immediately seek medical assistance swallowed. Avoid inhalations of possible solvent vapors or paint mist, as well as paint contact with skin and eyes. Apply only on well-ventilated areas and ensure that adequate forced ventilation exists when applying paint in confined spaces or when the air is stagnant. Always take precautions against the risks of fire and explosions.



EPOXY FLOORING 33820

CURING AGENT 63822

Description: BAJAK'S 33820 is a two component epoxy flooring base on epoxy and polyamine resins with an excellent abrasion resistance on concrete surface.

Recommended use: As a flooring on sealed indoor concrete surface.

Service temperature: Dry : Maximum 80°C Wet: Maximum 50°C

PHYSICAL CONSTANTS:

Colours/Shade no: Light Green
 Finish: Gloss
 Volume Solids: Min. 97%
 Weight Solid: Min. 98%
 Theoretical spreading rate: 1.0 m²/liter – 1000 mic. Dft.
 Flash point: >100°C
 Specific gravity: 1.4-1.45 kg/liter
 Surface dry: Max. 8 hours at 20°C (ISO 1517)
 Dry to touch: Max. 24 hours at 20°C
 Fully cured: 7 days at 20°C
 V.O.C: Max. 40 gr/liter

Shelf life: 1 years (25°C/77°F) from time of production. Depending on storage condition, mechanical stirring may be necessary before usage.

APPLICATION DETAILS:

Mixing ratio for 33820: Base 33820: 4 by weight
 Curing agent 63822: 1 by weight

Application method: Blade and roll
Thinner (max.vol.): Not recommended
Pot life: 30 min. (20°C/68°F) 50 milliliter
Cleaning of tools: S1040
Indicated film thickness ,dry: 1000 microns
Indicated film thickness ,wet: 1000 microns
Recoat interval, min: 24 hours (20°C)
Recoat interval, max: 7 days (20°C) , See REMARKS overleaf

2.EPOXY FLOORING 33820

APPLICATION AND CURING CONDITIONS: The surface must be completely clean and dry at the time of application. And its temperature must be above the dew point to avoid condensation. Minimum temperature for curing is 15°C/59°F.

At the freezing point and below, beware of the risk of ice on the surface which will hinder the adhesion. High humidity and/or condensation during application and the following 16 hours (20°C/68°F) may adversely affect the film formation. Maximum concrete moisture content should be 4%.

In confined spaces provide adequate ventilation during application and drying.

PRECEDING COAT: BAJAK'S EPOXY SEALER 15026 OR 33620

SUBSEQUENT COAT: None.

REMARKS:
Film thicknesses: 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 is 1000 microns/40 mils.

Thinning: Not recommend.
Physical property:

Type of Physical property:	Result	Unit	Standard
Pressure strength	800	Kgf/cm ²	ASTM D695M
Elongation strength	350	Kgf/cm ²	ASTM D638M
Hardness persos	250	Sec	ASTM D4366
Abrasion Resistance	50 mg	1000 cycle	ASTM D4060
Adhesion pull off	200	MPa ON STEEL	ASTM D4541

A completely clean surface is mandatory to ensure intercoat adhesion, especially at long recoating intervals. Any dirt,oil,and grease have to be removed, e.g. with suitable detergent.

Salts to be removed by fresh water hosing. To check an adequate quality of the surface cleaning a test patch is recommended before actual recoating.

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 and national safety regulations. Harmful or fatal if swallowed; immediately seek medical assistance swallowed. Avoid inhalations of possible solvent vapors or paint mist, as well as paint contact with skin and eyes. Apply only on well-ventilated areas and ensure that adequate forced ventilation exists when applying paint in confined spaces or when the air is stagnant. Always take precautions against the risks of fire and explosions.

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2. EPOXY FLOORING 33820A

APPLICATION AND CURING CONDITIONS:	<p>The surface must be completely clean and dry at the time of application. And its temperature must be above the dew point to avoid condensation. Minimum temperature for curing is 15°C/59°F.</p> <p>At the freezing point and below, beware of the risk of ice on the surface which will hinder the adhesion. High humidity and/or condensation during application and the following 16 hours (20°C/68°F) may adversely affect the film formation. Maximum concrete moisture content should be 4%.</p> <p>In confined spaces provide adequate ventilation during application and drying.</p>
PRECEDING COAT:	BAJAK'S EPOXY SEALER 15026 OR 33620
SUBSEQUENT COAT:	None.
REMARKS:	
Film thicknesses:	<p>May be specified in another film thickness than indicated depending on purpose and area of use.</p> <p>This will alter spreading rate and may influence drying time and recoating interval. Normal range is 1000 microns/40 mills.</p>
Thinning:	Not recommend.
Physical property:	

Type of Physical property:	Result	Unit	Standard
Pressure strength	800	Kgf/cm ²	ASTM D695M
Elongation strength	350	Kgf/cm ²	ASTM D638M
Hardness persos	250	Sec	ASTM D4366
Abrasion Resistance	50 mg	1000 cycle	ASTM D4060
Adhesion pull off	20	MPa ON STEEL	ASTM D4541

A completely clean surface is mandatory to ensure inter coat adhesion, especially at long recoating intervals. Any dirt, oil and grease have to be removed, e.g. with suitable detergent.

Salts to be removed by fresh water hosing. To check an adequate quality of the surface cleaning a test patch is recommended before actual recoating.

SAFETY:	<p>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 and national safety regulations. Harmful or fatal if swallowed; immediately seek medical assistance swallowed. Avoid inhalations of possible solvent vapors or paint mist, as well as paint contact with skin and eyes. Apply only on well-ventilated areas and ensure that adequate forced ventilation exists when applying paint in confined spaces or when the air is stagnant. Always take precautions against the risks of fire and explosions.</p>
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Issued:	June 2020
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BAJAPOX® GF 33826

CURING AGENT 63026

DESCRIPTION:

BAJAPOX GF 33826 is a two component, high solids, glass flake pigmented polyamine cured epoxy paint with good wetting properties and low water permeability. It is self priming and forms a hard and tough coating which has good resistance against abrasion and impact as well as to seawater, mineral oils, aliphatic hydrocarbons and splashes from petrol, jet fuel, lubrication oil and related products. Application in thick coats by standard heavy duty airless spray equipment up to 500 micron/20 mils in one working process is possible.

RECOMMENDED USE:

As a coating for steel exposed to abrasion and/or severe corrosive environment.
As a self-primed, high build coating primarily for areas subject to abrasion and/or to a highly corrosive environment. E.g. splash zones, jetty pilings, crude oil and condensate tanks, and working decks.

CERTIFICATES & APPROVALS:

Approved by Germanischer Lloyd as a coating for above mentioned applications.

PHYSICAL CONSTANTS:

Colours:	Yellow	Grey	
Finish:	Semi-gloss. Slightly structured Surface.		
Volume by solid:	90%	90%	
Theoretical	3.6	3.6	m ² /litre-250 micron
Spreading rate:	144	144	sq.ft/US gallon 10mils
Flash point:	50-60	50-60	C/F Abel-pensky.close cup
Specific gravity:	1.4	1.4	kg/litre
	13.4	13.4	lbs/US gallon
Surface dry:	10(approx.)	10(approx.)	hours at 20 °C/68°F (ISO 1517)
Dry to touch:	12(approx.)	12(approx.)	hours at 20 °C/68°F
Fully cured:	7	7	days at 20 °C/68°F

APPLICATION DETAILS:

Mixing Ratio:	BASE: BAJAPOX GF 33826 CURING AGENT: 63026	3.3 part by volume 1.0 part by volume
Application Method:	Airless Spray	Brush (See application instructions)
Thinner (max.vol):	See application instructions	
Pot-Life:	1 hour (20°C/68°F)	1 1/2 hours (20°C/68°F) (See REMARKS overleaf)
Nozzle Orifice:	0.045" reversible nozzle	(See application instructions)
Nozzle Pressure:	250 bar/3600 psi	(Airless spray data are indicative and
Adjustment	subject to	
Cleaning of Tools:	BAJAK TOOL CLEANER 99610	
Indicated film thickness, wet:	500 microns/20 mils	(See REMARKS overleaf)
Indicated film thickness, dry:	450 microns/20 mils	(See REMARKS overleaf)
Recoat Interval, min:	10 hours (20°C/68°F)	(See application instructions)
Recoat interval, max:	7 days (20°C/68°F)	(See application instructions)

BAJAPOX® GF 33826

Surface Preparation: **Spot Repair & Maintenance:** Remove oil and grease etc., with suitable detergent. Remove salt and other contaminants by high pressure Fresh water cleaning. Abrasive blasting to minimum Sa 2½, SSPC-SP 10. Surface profile corresponding to Rugotest No. 3, BN 11, Keane-After blasting, clean the Surface carefully from abrasives and dust.

On pit-corroded surfaces: excessive amounts of salt residues may call for dry Abrasive blasting, high pressure fresh water hosing, drying, and finally, dry abrasive blasting again alternatively, jet cleaning, drying and dry abrasive Blasting.

Application Conditions: Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. Use only where application and curing can proceed at Temperatures above approximately 15tC/59tF. The temperature of the paint itself should also be minimum 15tC/59tF. At high temperature 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 BAJAPOX 15590

Subsequent Coat: None, or according to specification.

Remarks: Refer to separate APPLICATION INSTRUCTIONS.

Service Temperature: Dry service temperature: max: 120°C/248°F
Dry peak temperature: max. 140°C/284°F.

Film Thickness: May be specified in another film thickness than indicated depending on purpose and area of use. Normal range is 350-500 Mic. (14-20 mil.). This will alter spreading rate and may influence drying time and reciting interval. Concerning measurement of wet film thickness, please consult separate APPLICATION INSTRUCTIONS. For optimum performance three layers, each 350 micron/14 mils dry film thickness is recommended.

Pot-life: The pot life is dependent upon packing size and temperature. For temperature at 35tC/95tF the pot life will be reduced to approximately 15 minutes.

Note: **BAJAPOX GF 33826 is for professional use only.**

Safety: Packing is provided with applicable safety labels, which should be observed. In addition, Material Safety Data Sheet(s) should be consulted and national or local regulations should be followed. As a general rule, inhalation of solvent vapors or paint mist, and contact of liquid paint with skin and eyes should be avoided. Forced ventilation should be provided when applying paint in confined spaces or stagnant air. Even when ventilation is provided, respiratory, skin, and eye protection are always recommended when spraying paint. Necessary precautions against the risk of fire or explosion must be taken.

APPLICATION INSTRUCTIONS

For product description refer to the product data

BAJAPOX®GF 33826

CURING AGENT 63026

- Scope:** For product description refer to the product data sheet. These Application Instructions cover surface preparation, application equipment and application details for BAJAPOX GF 35826.
- Surface Preparation:** Remove oil and grease with suitable detergent. Remove salt and other contaminants by high pressure fresh water hosing. Abrasive blasting to Sa 2½, ISO 8501-1:1988, SSPC-SP-10. Surface profile corresponding to Rugotest No. 3, BN 11, Keane-Tator Comparator, 5.5 G/S, or ISO Comparator Coarse (G). After blasting, clean the surface carefully from abrasive and dust. BAJAPOX 15590 may be used as "blast primer".
- Note:** On old pit-corroded surfaces, excessive amounts of salt residues may call for wet abrasive blasting, alternatively dry abrasive blasting, high pressure fresh water hosing, drying, and finally, dry abrasive blasting again. Alternatively, jet-cleaning, drying and dry abrasive blasting.
- Application Equipment:** BAJAPOX GF 33826 being a high viscosity material, will require special measures to be taken at application.
- Recommended Airless Spray Equipment:
- | | |
|-----------------|---|
| Pump ratio: | min 60:1 |
| Pump output: | 12 litres/minute (theoretical) |
| Packings: | nylon or teflon |
| Input pressure: | min. 6 bar/90 psi |
| Spray hoses: | max. 30 metres/100 feet, 3/8" internal diameter
max. 6 metres/ 20 feet, 1/4" internal diameter |
| In-line filter: | The filter element must be removed |
| Nozzle size: | 0.045", reversible |
| Fan angle: | 40-60 |
- After finishing the application, clean the equipment immediately with BAJAK'S TOOL CLEANER 99610.
- Thinning:** It is recommended not to use any thinning as this may delay the drying and curing. If deemed necessary, anyhow up to 2% methel ethyl ketone may be used.
- Pot Life:** When measured under standard conditions the pot life is 1 hour at 20°C/68°F.
- However, when used under warm climate conditions (up to approximately 35°C/95°F) the heat developed by the chemical reaction between BASE and CURING AGENT will make the corresponding practical pot life shorter.
- Therefore:
- 1) Irrespective of equipment, use the paint immediately after mixing. Otherwise there will be a risk of sagging when applied at high film thicknesses, especially at higher temperatures.
 - 2) It is strongly recommended to store the product protected against strong sunlight, if necessary under cooled conditions to avoid material temperature above approximately 25°C/77°F.

BAJAPOX®GF 33826

Application: Film-build/continuity: With this paint material applied in one/few coat(s), it is of special importance that a continuous, pinhole-free paint film is obtained at application. Great care must be taken to cover edges, openings, rear sides of stiffeners etc. Thus, on these areas a stripecoat will usually be necessary. It is of equal importance that all bare areas are covered with sufficient paint material - otherwise the result may be early pin-point rusting. If the slightest doubt exists about sufficient paint film thickness applied, an extra application should be performed. Despite being applicable in one layer up to approximately 1000 microns/40 mils, a two layer specification is recommended whenever possible. Each layer to be applied with a cross-spray technique in order to obtain the most uniform film thickness.

Wet/Dry Film Thickness: Please note that the thixotropic nature of BAJAPOX GF 33826 may give a rather "wavy" surface of the paint just after application. This smoothens at drying but can make it necessary to let the wet film readings be of a higher value than indicated. In many cases the wft reading should be 50-100 microns/2-4 mils higher than calculated. As the wavy surface becomes more smooth at drying this extra wft reading will not cause a higher paint consumption than otherwise stipulated.

**Recoating
Overcoating Interval:** The following recoating intervals apply to obtain optimum performance (500 microns/20 mils dft - sufficient ventilation - maximum 90% Relative Humidity).

Temp. of steel		15°C/59°F	20°C/68°F	30°C/86°F	40°C/108°F
Bajathane qualities	Min.	16 hours	10 hours	7 hours	4 hours
	Max.	5 days	3 days	2 day	30 hours
Bajapox qualities	Min.	16 hours	16 hours	7 hours	4 hours
	Max.	15 days	7 days	4 days	2 days

Before recoating, clean the surface thoroughly of all contamination. Especially at long intervals before overcoating a very careful cleaning is necessary. To check adequate quality of the preparatory cleaning a test patch is recommended before actual overcoating.

Curing Table: The following curing times apply:

Temperature of steel:	°C/°F	15/59	20/68	25/77	30/86	35/95	40/104
Fully cured, days:		12	7	5	3	2½	2

Safety: Packings are provided with applicable safety labels which should be observed. In addition, Material Safety Data Sheet(s) should be consulted and national or local safety regulations should be followed. As a general rule, inhalation of possible solvent vapours or paint mist, and contact of liquid paint with skin and eyes, should be avoided. Forced ventilation should be provided when applying paint in confined spaces or stagnant air. Even when ventilation is provided, respiratory, skin, and eye protection are always recommended when spraying paint. Necessary precautions against the risk of fire or explosions must be taken.

ISSUED: Feb. 2007

BAJAPOX® GF 33826 SF

CURING AGENT 63026

DESCRIPTION:

BAJAPOX GF 33826 is a two component, solvent free, glass flake pigmented polyamine cured epoxy paint with good wetting properties and low water permeability. It is self priming and forms a hard and tough coating which has good resistance against abrasion and impact as well as to seawater, mineral oils, aliphatic hydrocarbons and splashes from petrol, jet fuel, lubrication oil and related products. Application in thick coats by standard heavy duty airless spray equipment up to 500 micron/20 mils in one working process is possible.

RECOMMENDED USE:

As a coating for steel exposed to abrasion and/or severe corrosive environment.

As a self-primed, high build coating primarily for areas subject to abrasion and/or to a highly corrosive environment. E.g. splash zones, jetty pilings, crude oil and condensate tanks, and working decks.

CERTIFICATES & APPROVALS:

Approved by Germanischer Lloyd as a coating for above mentioned applications.

PHYSICAL CONSTANTS:

Colours:	Yellow	Grey	
Finish:	Semi-gloss. Slightly structured Surface.		
Volume by solid:	100%	90%	
Theoretical			
Spreading rate:	500	500	m ² /litre-500 micron
Flash point:	25/77	25/77	C/F Abel-pensky.close cup
Specific gravity:	1.45	1.45	kg/litre
Surface dry:	10(approx.)	10(approx.)	hours at 20 °C/68°F (ISO 1517)
Dry to touch:	12(approx.)	12(approx.)	hours at 20 °C/68°F
Fully cured:	7	7	days at 20 °C/68°F

APPLICATION DETAILS:

Mixing Ratio:	BASE: BAJAPOX GF 33826	3.0 part by volume
	CURING AGENT: 63026	1.0 part by volume
Application Method:	Airless Spray	Brush (See application instructions)
Thinner (max.vol):	See application instructions	
Pot-Life:	1 hour (20°C/68°F)	1 1/2 hours (20°C/68°F) (See REMARKS overleaf)
Nozzle Orifice:	0.045" reversible nozzle	(See application instructions)
Nozzle Pressure:	250 bar/3600 psi	(Airless spray data are indicative and
Adjustment	subject to	
Cleaning of Tools:	BAJAK TOOL CLEANER 99610	
Indicated film thickness, wet:	500 microns/20 mils	(See REMARKS overleaf)
Indicated film thickness, dry:	500 microns/20 mils	(See REMARKS overleaf)
Recoat Interval, min:	10 hours (20°C/68°F)	(See application instructions)
Recoat interval, max:	7 days (20°C/68°F)	(See application instructions)

BAJAPOX® GF 33826

Surface Preparation: **Spot Repair & Maintenance:** Remove oil and grease etc., with suitable detergent. Remove salt and other contaminants by high pressure Fresh water cleaning. Abrasive blasting to minimum Sa 2½, SSPC-SP 10. Surface profile corresponding to Rugotest No. 3, BN 11, Keane-After blasting, clean the Surface carefully from abrasives and dust.

On pit-corroded surfaces: excessive amounts of salt residues may call for dry Abrasive blasting, high pressure fresh water hosing, drying, and finally, dry abrasive blasting again alternatively, jet cleaning, drying and dry abrasive Blasting.

Application Conditions: Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. Use only where application and curing can proceed at Temperatures above approximately 15tC/59tF. The temperature of the paint itself should also be minimum 15tC/59tF. At high temperature 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 BAJAPOX 15590

Subsequent Coat: None, or according to specification.

Remarks: Refer to separate APPLICATION INSTRUCTIONS.

Service Temperature: Dry service temperature: max: 120°C/248°F
Dry peak temperature: max. 140°C/284°F.

Film Thickness: May be specified in another film thickness than indicated depending on purpose and area of use. Normal range is 500-1000 Mic. (20-40 mil.). This will alter spreading rate and may influence drying time and reciting interval. Concerning measurement of wet film thickness, please consult separate APPLICATION INSTRUCTIONS. For optimum performance three layers, each 350 micron/14 mils dry film thickness is recommended.

Pot-life: The pot life is dependent upon packing size and temperature. For temperature at 35tC/95tF the pot life will be reduced to approximately 15 minutes.

Note: **BAJAPOX GF 33826SF is for professional use only.**

Safety: Packing is provided with applicable safety labels, which should be observed. In addition, Material Safety Data Sheet(s) should be consulted and national or local regulations should be followed. As a general rule, inhalation of solvent vapors or paint mist, and contact of liquid paint with skin and eyes should be avoided. Forced ventilation should be provided when applying paint in confined spaces or stagnant air. Even when ventilation is provided, respiratory, skin, and eye protection are always recommended when spraying paint. Necessary precautions against the risk of fire or explosion must be taken.



Product Data

BAJAPOX FILLER 35250

CURING AGENT 95250

Description:

BAJAPOX FILLER 35250 is a two-component, solvent-free, epoxy filler, which - when fully cured - is resistant to water, aliphatic hydrocarbons, and related products. Can be applied in thick coats up to approximately 5 mm without runs or sags.

Recommended use:

1. As a filler for metals, hardwood, and other rigid materials.
2. For filling of pinholes in weldings and similar irregularities in steel work not later exposed to strong chemicals.

Service temperatures:

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

PHYSICAL CONSTANTS:

Colours :	Light grey
Finish:	Semi-gloss
Solids content:	100%
Flash point:	92°C/198°F
Specific gravity:	1.6 kg/litre - 13.4 lbs/US gallon
Dry to touch:	8 (approx.) hours at 20°C/68°F
Fully cured:	5 (approx.) days at 20°C/68°F
V.O.C.:	10 g/litre - 0.1 lbs/US gallon

APPLICATION DETAILS:

Mixing ratio for 35250:	Base 35250 : Curing agent 95250 1 : 1 by volume
Application method:	Putty knife, or similar.
Thinner (max.vol.):	Do not dilute
Pot life:	1 hour (20°C/68°F)
Cleaning of tools:	BAJAK'S TOOL CLEANER 99610
Recoat interval, min:	8 hours (20°C/68°F)
Recoat interval, max:	24 hours (20°C/68°F)(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. 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.

BAJAPOX FILLER 35250

SURFACE PREPARATION: **Metal:** Remove oil and grease, etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. Abrasive blasting, power tool cleaning or sanding, depending on material and condition of the surface. Pitted steel should be blast cleaned and/or ground with high speed burrs. Round off sharp edges. Finally clean the area with BAJAK'S THINNER 08450. Priming after abrasive blast cleaning can be done with a thin layer of eg BAJAPOX 15590.

APPLICATION CONDITIONS: Use only where application and curing can proceed at temperatures above 5°C/41°F. The temperature of the substrate should also be above this limit. Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation.

SUBSEQUENT COAT: Can be recoated with BAJALIN, BAJATEX or BAJAPOX qualities according to specification. High-gloss finishes such as BAJATHANE TOPCOAT, should not be applied directly on top of BAJAPOX FILLER 35250. An intermediate coat eg of a suitable BAJAPOX coating is recommended.

REMARKS: Mix and stir the two components thoroughly until an even light grey colour is achieved, whereafter the filler is ready for use.
Do not mix more than is necessary for use within the pot life.
If the maximum recoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion.
May be sanded after 16 hours (20°C/68°F).

Note: **BAJAPOX FILLER 35250 is for professional use only.**



Product Data

BAJAPOX HIGH-GUARD 35490 BAJAPOX HIGH-GUARD 35493

High temperatures: 35490 with CURING AGENT 95690
Medium temperatures: 35493 with CURING AGENT 95790

Description:	BAJAPOX HIGH-GUARD 35490/35493 is a solvent-free, two-component, epoxy coating. It cures to a hard, abrasion-resistant, protective coating. It can be spray applied in one coat at a minimum film thickness of 2.5 mm (100 mils).	
Recommended use:	As a heavy duty coating on steel and concrete exposed to severe corrosive conditions and/or abrasion such as splashzones, decks and ramps. Colour retention will be of minor importance. CURING AGENT 95690 suited for application at temperatures above 20°C/68°F. CURING AGENT 95790 suited for application at temperatures between 10°C/50°F and 20°C/68°F. Conforms with NORSOK M-501, system no. 4 (high temperature version).	
Service temperatures:	Dry: Maximum: 140°C/284°F See REMARKS overleaf.	In water (no temperature gradient): 35°C/95°F

PHYSICAL CONSTANTS:

Colours :	Grey-green
Finish:	Semi-gloss, textured
Solids content:	100%
Theoretical spreading rate:	0.4 m ² /litre - 2.5 mm 16.0 sq.ft./US gallon - 100 mils
Flash point:	> 60°C/140°F
Specific gravity:	1.9 kg/litre - 15.8 lbs/US gallon
Surface dry:	See REMARKS overleaf
Dry to touch:	See REMARKS overleaf
Fully cured:	See REMARKS overleaf
V.O.C.:	0 g/litre - 0 lbs/US gallon

APPLICATION DETAILS:

	35490	35493
Mixing ratio:	Base 35490 : Curing agent 95690 5.6 : 1.0 by volume; 23.0 : 2.0 by weight	Base 35493 : Curing agent 95790 5.7 : 1.0 by volume; 23.0 : 2.15 by weight
Application method:	Spray (small areas: notched trowel) (Consult separate Application Instructions)	Spray (small areas: notched trowel) (Consult separate Application Instructions)
Thinner (max. vol.):	Do not dilute (see REMARKS overleaf)	Do not dilute (see REMARKS overleaf)
Pot life:	See REMARKS overleaf	See REMARKS overleaf
Recommended equipment:	Air spray by worm-pump equipment, by hose pump or by modified piston pump. (Consult separate Application Instructions)	See REMARKS overleaf
Cleaning of tools:	For small areas quick Spray Hopper Gun. BAJAK'S TOOL CLEANER 99610.	
Indicated film thickness, dry:	2.5 mm/100 mils	
Indicated film thickness, wet:	2.5 mm/100 mils	
Recoating interval, min:	See REMARKS overleaf	
Recoating 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.



BAJAPOX® MULTI-STRENGTH® 35525

CURING AGENT 95630

Description: BAJAPOX MULTI-STRENGTH 35525 is a solvent-free, two-component, high-build, polyamine cured epoxy paint, which cures to a coating with good resistance to fresh water, sea water, crude oil, and to abrasion. Applicable in thick coats by standard heavy duty airless spray equipment. Can be exposed to water within 30 min after application.

Recommended use:

1. As a heavy duty coating on steel exposed to abrasion where solvent-free materials are required. Full colour retention will be of secondary importance.
2. As a coating formulated for splash zones, Jetty pilings and tidal zones.

Service temperatures:

Dry:
Maximum: 140°C/284°F

PHYSICAL CONSTANTS:

Colours/Shade nos: Grey/10500 - Red/51320
Finish: Semi-gloss
Solids Content, %: 100
Theoretical spreading rate: 1 m²/litre - 1000 micron
134 sq.ft./US gallon - 12 mils
Flash point: 100°C/212°F
Specific gravity: 1.3 kg/litre - 10.8 lbs/US gallon
Surface dry: 12 (approx.) hrs at 20°C/68°F (ISO 1517) , 6 hrs at 30°C , 3 hrs at 40°C
Dry to touch: 24 (approx.) hours at 20°C/68°F
Fully cured: 7 days at 20°C/68°F
V.O.C.: 0 g/litre - 0 lbs/US gallon

APPLICATION DETAILS:

Mixing ratio for 35525: Base 35539 : Curing agent 95530
3 : 1 by volume
Stir CURING AGENT before adding it to the BASE

Application method: Airless spray Brush (touch up)
(Consult the separate APPLICATION INSTRUCTIONS)

Thinner (max.vol.): Do not dilute (Consult the separate APPLICATION INSTRUCTIONS)

Pot life: 1 hour (20°C/68°F) (Consult the separate APPLICATION INSTRUCTIONS)

Nozzle orifice: .031"

Nozzle pressure: 250 bar/3600 psi
(Airless spray data are indicative and subject to adjustment)

Cleaning of tools: BAJAK'S TOOL CLEANER 99610

Indicated film thickness, dry: 1000 micron/40 mils (See REMARKS overleaf)

Indicated film thickness, wet: 1000 micron/40 mils

Recoat interval, min: See REMARKS overleaf and separate APPLICATION INSTRUCTIONS

Recoat interval, max: See REMARKS overleaf and separate APPLICATION INSTRUCTIONS

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2. BAJAPOX MULTI-STRENGTH 35525

SURFACE PREPARATION: When used as a heavy duty coating:
 Abrasive blasting to min. Sa 2½. Grit-blasted surfaces: recommended profile is Rz 150 micron/6 mils corresponding to ISO Comparator Coarse (G). Oil and grease must be removed with suitable detergent, salts and other contaminants by (high pressure) fresh water hosing prior to blasting. After blasting, clean the surface carefully from abrasives and dust.
 On old steel surfaces having been exposed to salt water, excessive amounts of salt residues in pittings may call for abrasive blasting, high pressure fresh water hosing, drying, and finally, dry abrasive blasting again. Alternatively, water jetting may be used provided the steel surface has already the surface profile as described above.
 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, flame cleaning or acid etching. Seal surface with suitable sealer, eg BAJAPOX SEALER 05970 (furthermore, please see Product Data Sheet for 05970).

APPLICATION CONDITIONS: Use only where application and curing can proceed at temperatures above 10°C/50°F. The temperature of the paint itself must be above 15°C/59°F for proper application. In-can temperature of the paint should preferably be below 25°C/77°F. Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. Relative humidity max 85%.

PRECEDING COAT: None, BAJAPOX SEALER 05970, BAJAPOX 15590 or according to specification.

SUBSEQUENT COAT: None, BAJAPOX or BAJATHANE qualities as per specification.

REMARKS 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.

Weathering/service temperatures: Film thicknesses: 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 1000-1250 micron/40-50 mils.

Recoating: Recoating intervals related to later conditions of exposure: (1000 micron/40 mils dry film thickness of BAJAPOX MULTI-STRENGTH 35525)

Physical data versus temperatures:				
	Minimum		Maximum	
SURFACE TEMPERATURE	20°C/68°F		20°C/68°F	
	Atmospheric		Atmospheric	
Recoated with	Severe		Severe	
BAJAPOX	24 hours		5 days	
BAJATHANE	12 hours		24 hours	

Mix and stir the two components until an even colour is achieved, where after the paint is ready for use. If improved colour stability is requested for exposure to sunshine, it is recommended to topcoat with e.g. BAJATHANE TOPCOAT 55210.

Potable water tanks: Do not put tanks into service before the coating is properly cured. When cured but before taking tank into use for potable water, fill twice with water, each time for a period of not less than 24 hours, and finally flush with fresh water. Alternatively hose down with warm fresh water (max. 50°C/122°F). Such cleaning may be subject to local/individual specification or regulation.

Note: BAJAPOX MULTI-STRENGTH 35525 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.

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Product Data

APPLICATION INSTRUCTIONS

For product description refer to product data sheet

BAJAPOX HIGH-STRENGTH 35530

CURING AGENT 95530

Scope: These application instructions cover surface preparation, application equipment, and application details for BAJAPOX 35530.

Surface preparation: **Steel:** Abrasive blasting to min. Sa 2 $\frac{1}{2}$. Gr it-blasted surfaces: recommended profile is Rz minimum 100 micron/4 mils - maximum 150 micron/6 mils corresponding to ISO Comparator Coarse (G). Oil and grease must be removed with suitable detergent, salts and other contaminants by (high pressure) fresh water hosing prior to blasting. After blasting, clean the surface carefully from abrasives and dust. BAJAPOX 15590 may be used as a blast primer/hold-coat.

On old steel surfaces having been exposed to salt water, excessive amounts of salt residues in pittings may call for dry abrasive blasting, high pressure fresh water hosing, drying, and finally, dry abrasive blasting again. Alternatively, water jetting may be used provided the steel surface has already the surface profile as described above.

In case of extensively pit-corroded surfaces (tank bottoms): Remove oil and grease with suitable detergent. Blasting to Sa 2, ISO 8501-1:1988. Pitting on tank bottoms are often omega-shaped (typically in the case of chloride-induced corrosion) for which reason the following procedure is recommended:

After rough cleaning for dust and abrasive, the tank surfaces are to be thoroughly high pressure fresh water hosed. Let the water remain in the tank so that all pit corroded areas are covered by approx 5 cm/2" of water.

After 24 hours the water is removed by wet vacuum cleaning and the tank is dried. If needed, i.e. if there is still salt contamination to be found in the pits, the washing treatment has to be repeated. After cleaning, the surfaces are blasted to min. Sa 2 $\frac{1}{2}$ with a surface roughness profile as described above. After blasting clean the surface carefully for abrasives and dust. Special care must be taken when cleaning the tank bottom.

Concrete: The concrete must be of good quality and fully cured, e.g. 28 days for normal Portland cement, and completely dry with a humidity content in the surface below 4%. The concrete must also be controlled for absence of capillary water action or for subsoil water.

Minimum pull-off value should normally be 20 kilopond/cm² measured after surface preparation. Any cracks, crevices and voids must be repaired.

All possible slip agent, oil, grease and other contaminants must be removed by e.g. abrasive blasting, volatilizing by flame cleaning or treatment with suitable detergent. The last mentioned in the following way: Saturation of the surface with fresh water. Washing with suitable detergent followed by fresh water hosing.

Depending on construction and purpose, abrasive blast, high pressure water jet or treat the concrete with power tools to obtain a rough and firm surface free of scum layer and other contamination. Remove dust and loose material.

If mechanical treatment is impossible, the surface may be treated with acid etching. For this purpose an approx. 5% w/w nitric or phosphoric acid solution is recommended.

Note: Strong acids, take necessary precautions, make sure that safety regulations are obeyed!

Standard airless heavy duty spray equipment:

Pump ratio: min 45:1 (See Note below)
Pump output: 12 litres/minute (theoretical)
Input pressure: min 6 bar/90 psi
Spray hoses: max 15 metres/50 feet, 3/8" internal diameter
max 3 metres/10 feet, 1/4" internal diameter

Regular surfaces:
Nozzle size: .023" through .031"
Fan angle: 40-60°.

Complicated surfaces:
Nozzle size: .019" through .023"
Fan angle: 40°

Note: Avoid the use of a suction hose. Use an interchangeable pipe, which makes it possible to remove cured paint. If longer spray hoses are necessary the pump ratio must be raised to 60:1 or more, yet the high output capacity of the pump must be maintained.

Thinning: Alternatively 1-2% THINNER 08450 may be added, but thinning must be done with care as the antisagging properties are drastically reduced by overthinning. **Do NOT use thinning when coating potable water tanks.**

Airless spray data are indicative and subject to adjustment.

Mixing: Stir the CURING AGENT 95530 well before mixing with BASE. Continue the mixing until a complete uniform colour is achieved.

Hot airless spray equipment:

Use the same airless spray pump as described above.

On the output side of the pump an electrically heated, explosion proof, high pressure, material heater is fitted. For instance 2500 Watt, max. working pressure well above 300 bar (4-1 safety factor) equipment.

Spray hoses: 45 metres/150 feet, 3/8" internal diameter.
3 metres/10 feet, 1/4" internal diameter.

Regular surfaces:
Nozzle size: .023" through .031"
Fan angle: 40-60°

Complicated surfaces:
Nozzle size: .019" through .023".
Fan angle: 40°.

Procedure for hot airless spray:

- a) Follow the supplier's instructions for the use of the heater.
- b) At surrounding temperatures below approximately 15°C/59°F start by heating up the hoses by recirculation of THINNER 08450 or BAJAK'S TOOL CLEANER 99610.
- c) Keep THINNER 08450 or BAJAK'S TOOL CLEANER 99610 readily available for fast cleaning of the equipment.
- d) Start spraying immediately after proper mixing and mechanical stirring of BASE 35530 and CURING AGENT 95530.
- e) Adjust the heater to approximately 50°C/122°F and check this temperature at short intervals.

Product Data



BAJAPOX HIGH-STRENGTH 35530

- f) The spraying should as far as possible run continuously. At any break longer than 2-3 minutes, switch off the heat and flush the equipment immediately and thoroughly with one of the solvents mentioned above under c).
- g) After finishing the application, switch off the heat and clean the equipment immediately with THINNER 0845 0 or BAJAK'S TOOL CLEANER 99610. Continue the cleaning by re-circulation for at least 30 minutes.

Pot life:

When measured under standard conditions the pot life is one hour at 20°C/68°F. However, for a 20 litres/5 US gallons mix, the heat developed by the chemical reaction between BASE and CURING AGENT is so intense that the corresponding practical pot life is **substantially shorter**.

Therefore:

- Irrespective of equipment, use the paint immediately after mixing. At a normal application speed the 20 litres/5 US gallons are used in approx. 10 minutes.
- Keep an eye on the paint temperature frequently for instance by touching the can with your hand. If it feels more than hand warm, discard the paint and flush the equipment immediately irrespective of type of spray equipment.

Paint temperature:

If the in-can temperature is below approximately 15°C/59°F viscosity will be too high for application. If the paint temperature at mixing is 25°C/77°F or higher a substantial risk of shortened pot life and curing in can/spray equipment exists. **when working in warm sub-tropical/ tropical climates a refrigerated container can be used for storing/ cooling of the paint before application.**

Application:

Film-build/continuity: With this typical one-coat tank coating it is of great importance that a continuous, pinhole-free paint film is obtained. An application technique which will ensure good film formation on **all** surfaces must be adopted. It is very important to use nozzles of the correct size, not too big, and to have a proper, uniform distance of the spray gun to the surface, 30-50 cm should be aimed at. Furthermore, great care must be taken to cover edges, openings, rear sides of stiffeners etc. The usual way of obtaining this result is to spray-coat all these areas separately followed by a full coat all over. Furthermore, stripe coating by brush will typically be required. To obtain good and steady atomizing, the viscosity of the paint must be suitable and the spray equipment must be sufficient in output pressure and capacity.

The paint layer must be applied homogeneously and as close to the specification as possible. The consumption of paint must be controlled to avoid exaggerated film thickness, eg by controlling paint consumption and/or measuring wet film thickness.

The finished coating must appear as a homogeneous film with a smooth surface and irregularities such as dust, dry spray, abrasives, should be remedied.

Stripe coating:

Edges, corners, manual welds, and places difficult to cover properly by spray application should be stripe coated (touched up) either before or after the spray application.

One or two stripe coats will usually be necessary, but depending on actual conditions.

BAJAPOX HIGH-STRENGTH 35530 may be slightly thinned with THINNER 08450, except for stripe coating in potable water tanks.

Extra film thickness:

Extra thickness - extra layer(s) - may be necessary in case of severely pitted and/or where very high degrees of antiabrasive properties are needed.

Two-coat application:

When applied in two coats it is an advantage to apply the first coat thicker than the second coat, for instance 300 micron for first, 200 micron for the second layer.



Product Data

BAJAPOX HIGH-STRENGTH 35530

CURING AGENT 95530

Description: BAJAPOX HIGH-STRENGTH 35530 is a solvent-free, two-component, high-build, polyamine cured epoxy paint, which cures to a coating with good resistance to fresh water, sea water, crude oil, and to abrasion. Applicable in thick coats by standard heavy duty airless spray equipment. Harmless to grain cargo.

Recommended use:

1. As a heavy duty coating on steel exposed to abrasion where solvent-free materials are required. Full colour retention will be of secondary importance. If solvent containing paints are accepted, BAJAPOX HIGH-STRENGTH 45751 substitutes.
2. As an approved lining in potable water tanks by Niroo Research Institute (MATN). For application in warm climates. Please see APPLICATION CONDITIONS overleaf.

Service temperatures:

Dry:	In fresh water (directly on steel):
Maximum: 140°C/284°F	35°C/95°F (no temperature gradient)
See REMARKS overleaf.	

PHYSICAL CONSTANTS:

Colours :	Grey - Red
Finish:	Semi-gloss
Solids content:	100%
Theoretical spreading rate:	3.3 m ² /litre - 300 micron 134 sq.ft./US gallon - 12 mils
Flash point:	> 100°C/212°F
Specific gravity:	1.3 kg/litre - 10.8 lbs/US gallon
Surface dry:	12 (approx.) hrs at 20°C/68°F (ISO 1517)
Dry to touch:	24 (approx.) hours at 20°C/68°F
Fully cured:	7 days at 20°C/68°F
V.O.C.:	0 g/litre - 0 lbs/US gallon

APPLICATION DETAILS:

Mixing ratio :	Base 35530 : Curing agent 95530 3 : 1 by volume Stir CURING AGENT before adding it to the BASE.
Application method:	Airless spray Brush (touch up) (Consult the separate APPLICATION INSTRUCTIONS)
Thinner (max.vol.):	Do not dilute (Consult the separate APPLICATION INSTRUCTIONS)
Pot life:	1 hour (20°C/68°F) (Consult the separate APPLICATION INSTRUCTIONS)
Nozzle orifice:	.019" - .031"
Nozzle pressure:	min. 250 bar/3600 psi (Airless spray data are indicative and subject to adjustment)
Cleaning of tools:	BAJAK'S TOOL CLEANER 99610
Indicated film thickness, dry:	300 micron/12 mils (See REMARKS overleaf)
Indicated film thickness, wet:	300 micron/12 mils
Recoat interval, min:	See REMARKS overleaf and separate APPLICATION INSTRUCTIONS
Recoat interval, max:	See REMARKS overleaf and 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.

BAJAPOX HIGH-STRENGTH 35530

SURFACE PREPARATION: **When used as a heavy duty coating or in potable water tanks and pipe lines:** Abrasive blasting to min. Sa 2½. Grit-blasted surfaces: recommended profile is Rz minimum 100 micron/4 mils - maximum 150 micron/6 mils corresponding to ISO Comparator Coarse (G). Oil and grease must be removed with suitable detergent, salts and other contaminants by (high pressure) fresh water hosing prior to blasting. After blasting, clean the surface carefully from abrasives and dust.

On old steel surfaces having been exposed to salt water, excessive amounts of salt residues in pittings may call for abrasive blasting, high pressure fresh water hosing, drying, and finally, dry abrasive blasting again. Alternatively, water etting may be used provided the steel surface has already the surface profile as described above.

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, flame cleaning or acid etching. Seal surface with suitable sealer, eg BAJAPOX SEALER 05970 (furthermore, please see Product Data Sheet for 05970).

APPLICATION CONDITIONS: Use only where application and curing can proceed at temperatures above 10°C/50°F. The temperature of the paint itself must be above 15°C/59°F for proper application. In-can temperature of the paint should preferably be below 25°C/77°F. Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. Relative humidity max 85%. For application in warm climates, BAJAPOX HIGH-STRENGTH 45751 may preferably replace BAJAPOX HIGH-STRENGTH 35530 as a heavy duty coating. For potable water tanks and pipes please check local product assortment.

PRECEDING COAT: None, BAJAPOX SEALER 05970, BAJAPOX 15590 or according to specification.

SUBSEQUENT COAT: None, BAJAPOX or BAJATHANE qualities as per specification.

Weathering/ service temperatures: The natural tendency of epoxy coatings to chalk in outdoor exposure and to become more sensitive mechanical damage and chemical exposure at elevated temperatures is also reflected in this product.

Film thicknesses: 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 200-300 micron/8-12 mils.

Recoating: Recoating intervals related to later conditions of exposure:
(300 micron/12 mils dry film thickness of BAJAPOX HIGH-STRENGTH 35530)

	Minimum		Maximum	
	20°C/68°F		20°C/68°F	
Recoated with	Atmospheric	Water immersion	Atmospheric	Water immersion
	BAJAPOX	Severe		Severe
BAJATHANE	24 hours	24 hours	5 days	5 days
	12 hours	Not relevant	24 hours	Not relevant

Mix and stir the two components until an even colour is achieved, whereafter the paint is ready for use. If improved colour stability is requested for exposure to sunshine, it is recommended to topcoat with e.g. BAJATHANE TOPCOAT 55210.

Potable water tanks: Do not put tanks into service before the coating is properly cured. When cured but before taking tank into use for potable water, fill twice with water, each time for a period of not less than 24 hours, and finally flush with fresh water. Alternatively hose down with warm fresh water (max. 50°C/122°F). Such cleaning may be subject to local/individual specification or regulation.

Note: **BAJAPOX HIGH-STRENGTH 35530 is for professional use only.**



BAJAPOX® MULTI-STRENGTH® 35530

CURING AGENT 95630

- Description:** BAJAPOX MULTI-STRENGTH 35530 is a solvent-free, two-component, high-build polyamine cured epoxy paint, which cures to a coating with good resistance to fresh water, sea water, crude oil, and to abrasion. Applicable in thick coats by standard heavy duty airless spray equipment. Harmless to grain cargo.
- Recommended use:**
1. As a heavy duty coating on steel exposed to abrasion where solvent-free materials are required. Full colour retention will be of secondary importance. If solvent containing paints are accepted, BAJAPOX MULTI-STRENGTH 45750 substitutes.
 2. As a lining in potable water tanks. Please see Certificates/Approvals. For application in warm climates. Please see APPLICATION CONDITIONS overleaf.
- Service temperatures:**
- | | | |
|----------|-----------------------|-------------------------------------|
| | Dry: | In fresh water (directly on steel): |
| Maximum: | 140°C/284°F | 35°C/95°F (no temperature gradient) |
| | See REMARKS overleaf. | |
- Availability:** Part of Group Assortment. Local availability subject to confirmation.

PHYSICAL CONSTANTS:

Colours/Shade nos:	Grey/10500 - Red/51320
Finish:	Semi-gloss
Solids Content, %:	100
Theoretical spreading rate:	3.3 m ² /litre - 300 micron 134 sq.ft./US gallon - 12 mils
Flash point:	100°C/212°F
Specific gravity:	1.3 kg/litre - 10.8 lbs/US gallon
Surface dry:	12 (approx.) hrs at 20°C/68°F (ISO 1517)
Dry to touch:	
Fully cured:	24 (approx.) hours at 20°C/68°F
V.O.C.:	7 days at 20°C/68°F 0 g/litre - 0 lbs/US gallon

APPLICATION DETAILS:

Mixing ratio for 35530:	Base 35539 : Curing agent 95530 3 : 1 by volume Stir CURING AGENT before adding it to the BASE
Application method:	Airless spray Brush (touch up) (Consult the separate APPLICATION INSTRUCTIONS)
Thinner (max.vol.):	Do not dilute (Consult the separate APPLICATION INSTRUCTIONS)
Pot life:	1 hour (20°C/68°F) (Consult the separate APPLICATION INSTRUCTIONS)
Nozzle orifice:	.019"-.031"
Nozzle pressure:	250 bar/3600 psi (Airless spray data are indicative and subject to adjustment)
Cleaning of tools:	BAJAK'S TOOL CLEANER 99610
Indicated film thickness, dry:	300 micron/12 mils (See REMARKS overleaf)
Indicated film thickness, wet:	300 micron/12 mils
Recoat interval, min:	See REMARKS overleaf and separate APPLICATION INSTRUCTIONS
Recoat interval, max:	See REMARKS overleaf and separate APPLICATION INSTRUCTIONS

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2. BAJAPOX MULTI-STRENGTH 35530

SURFACE PREPARATION:	<p>When used as a heavy duty coating or in potable water tanks: Abrasive blasting to min. Sa 2½. Grit-blasted surfaces: recommended profile is Rz minimum 100 micron/4 mils - maximum 150 micron/6 mils corresponding to ISO Comparator Coarse (G). Oil and grease must be removed with suitable detergent, salts and other contaminants by (high pressure) fresh water hosing prior to blasting. After blasting, clean the surface carefully from abrasives and dust.</p> <p>On old steel surfaces having been exposed to salt water, excessive amounts of salt residues in pittings may call for abrasive blasting, high pressure fresh water hosing, drying, and finally, dry abrasive blasting again. Alternatively, water jetting may be used provided the steel surface has already the surface profile as described above.</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, flame cleaning or acid etching. Seal surface with suitable sealer, eg BAJAPOX SEALER 05970 (furthermore, please see Product Data Sheet for 05970).</p>
APPLICATION CONDITIONS:	<p>Use only where application and curing can proceed at temperatures above 10°C/50°F. The temperature of the paint itself must be above 15°C/59°F for proper application. In-can temperature of the paint should preferably be below 25°C/77°F.</p> <p>Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. Relative humidity max 85%.</p> <p>For application in warm climates, BAJAPOX MULTI-STRENGTH 45750 may preferably replace BAJAPOX MULTI-STRENGTH 35530 as a heavy duty coating. For potable water tanks please check local product assortment.</p>
PRECEDING COAT:	None, BAJAPOX SEALER 05970, BAJAPOX 15590 or according to specification.
SUBSEQUENT COAT:	None, BAJAPOX or BAJATHANE qualities as per specification.
REMARKS 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.
Film thicknesses:	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 200-300 micron/8-12 mils.
Recoating:	Recoating intervals related to later conditions of exposure: (300 micron/12 mils dry film thickness of BAJAPOX MULTI-STRENGTH 35530)

Physical data versus temperatures:				
	Minimum		Maximum	
SURFACE TEMPERATURE	20°C/68°F		20°C/68°F	
	Atmospheric	Water immersion	Atmospheric	Water immersion
Recoated with	Severe		Severe	
BAJAPOX	24 hours	24 hours	5 days	5 days
BAJATHANE	12 hours	Not relevant	24 hours	Not relevant

Mix and stir the two components until an even colour is achieved, where after the paint is ready for use. If improved colour stability is requested for exposure to sunshine, it is recommended to topcoat with e.g. BAJATHANE TOPCOAT 55210.

Potable water tanks:	Do not put tanks into service before the coating is properly cured. When cured but before taking into use for potable water, fill twice with water, each time for a period of not less than 24 hours, and finally flush with fresh water. Alternatively hose down with warm fresh water (max. 50°C/122°F). Such cleaning may be subject to local/individual specification or regulation.
Note:	BAJAPOX MULTI-STRENGTH 35530 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.

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BAJAK'S POLYESTER GF 35920

HARDENER 99020

Description: BAJAK'S POLYESTER GF 35920 is a high solid, two-component, heavy duty lining system based on isophthalic polyester acrylic copolymer reinforced with glass flakes. Applicable in thick coats by standard heavy duty airless spray equipment.

Recommended use:

1. As rust preventing coating for areas exposed to high abrasion and impact.
2. As rust preventing coating for areas requiring short interval between application and seawater immersion – 6 hours at 20°C/68°F is required.

Service temperatures:

Dry:	In water (maximum temperature gradient 35°C/63°F):
Maximum:	140°C/284°F 80°C/176°F.

PHYSICAL CONSTANTS:

Colours/Shade no:	Off-white / Yellow
Finish:	Flat
Volume solids, %:	90 (see REMARKS overleaf)
Theoretical spreading rate:	1.4 m ² /litre – 650 micron 56 sq.ft./US gallon - 26 mils
Flash point:	26°C/79°F
Specific gravity:	1.2 kg/litre - 10.2 lbs/US gallon
Dry to touch:	4 (approx.) hours at 20°C/68°F
Fully cured:	7 days at 20°C/68°F
V.O.C.:	35 g/litre – 0.3 lbs/US gallon

Shelf life: 6 months 25°C/77°F from time of production.
Shelf life is dependent on storage temperature. Shelf life is reduced at storage temperatures above 25°C/77°F. Do not store above 40°C/104°F

APPLICATION DETAILS:

Mixing ratio for 35920:	Base 35920 : hardener 99020 97.5: 1.5 by volume
Application method:	Airless spray Brush/roller (See separate Application instructions)
Thinner (max. vol.):	Do not dilute (See separate Application instructions)
Pot life:	45 minutes (20°C/68°F) (See separate Application instructions)
Nozzle orifice:	.030"-.060" (Reversible)
Nozzle pressure:	Min 275 bar/4000 psi (Airless spray data are indicative and subject to adjustment)
Cleaning of tools:	Styrene and methyl ethyl ketone (See separate Application instructions)
Indicated film thickness, dry:	650 micron/26 mils
Indicated film thickness, wet:	725 micron/29 mils
Recoat interval, min:	With itself: 2 hours (20°C/68°F); others 16 hours (20°C/68°F)
Recoat interval, max:	3 days (20°C/68°F)

Issued: March 2004

2. BAJAK POLYESTER GF 35920

SURFACE PREPARATION:	<p>New steel: Abrasive blasting to min. Sa 2½.</p> <p>Minimum surface profile corresponding to Rugotest No. 3, BN 11, Keane-Tator Comparator, 5.5 G/S, or ISO Comparator Coarse (G). Oil and grease must be removed by suitable detergent, salts and other contaminants by (high-pressure) fresh water hosing prior to blasting. After blasting clean the surface carefully from abrasives and dust.</p> <p>Maintenance: On old exposed areas excessive amounts of soluble salt residues (in pittings) may call for water jet cleaning or wet abrasive blasting followed by dry abrasive blasting. Alternatively dry abrasive blasting, high pressure fresh water hosing, drying and finally, dry abrasive blasting again.</p>
APPLICATION CONDITIONS:	<p>Use only when application and curing can proceed at temperatures above 10°C/50°F.</p> <p>The in-can temperature of the polyester material should be between 15°C/59°F and 25°C/77°F to facilitate proper application properties.</p> <p>Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. Relative humidity max. 85%. In confined spaces provide adequate ventilation during application and curing.</p>
PRECEDING COAT:	None.
SUBSEQUENT COAT:	None, or solvent-based coatings as per specification.
REMARKS:	
Film thicknesses:	<p>May be specified in another film thickness than indicated depending on purpose and area of use. Normal range dry is 650-750 micron/26-30 mils. Absolute minimum is 500 micron/20 mils. Maximum not more than 1250 micron/50 mils.</p>
Volume solid:	<p>Theoretically, the products contain 100% solid.</p> <p>By practical spray application, however, one of the reactive components added in surplus will be lost as volatile in an amount of approx. 0.035 kg per litre.</p> <p>Furthermore, the curing process is accompanied by a contraction of approximately 6%. These two factors result in a volume solid of 90% and a spreading rate of 1.4 m²/l at 650 micron.</p> <p>By extremely unfavourable application conditions, higher losses may result in a "theoretical" spreading rate of approximately 1.2 m²/l at 650 micron. The curing is, however, not affected by the higher loss.</p>
Note:	BAJAK'S POLYESTER GF 35920 is for professional use only.
Safety:	<p>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.</p>



BAJAK'S VINYLESTER GF 35920

HARDENER 99020

Description: BAJAK'S VINILESTER GF 35920 is a high solid, two-component, heavy duty lining system based on vinylester copolymer reinforced with glass flakes. Applicable in thick coats by standard heavy duty airless spray equipment.

Recommended use:

1. As rust preventing coating for areas exposed to high abrasion and impact.
2. As rust preventing coating for areas requiring short interval between application and seawater immersion – 6 hours at 20°C/68°F is required.

Service temperatures:

Dry:	In water (maximum temperature gradient 35°C/63°F):
Maximum: 140°C/284°F	80°C/176°F.

PHYSICAL CONSTANTS:

Colours/Shade no:	Off-white / Yellow
Finish:	Flat
Volume solids, %:	90 (see REMARKS overleaf)
Theoretical spreading rate:	1.4 m ² /litre – 650 micron 56 sq.ft./US gallon - 26 mils
Flash point:	26°C/79°F
Specific gravity:	1.2 kg/litre - 10.2 lbs/US gallon
Dry to touch:	4 (approx.) hours at 20°C/68°F
Fully cured:	7 days at 20°C/68°F
V.O.C.:	35 g/litre – 0.3 lbs/US gallon

Shelf life: 6 months 25°C/77°F from time of production.
Shelf life is dependent on storage temperature. Shelf life is reduced at storage temperatures above 25°C/77°F. Do not store above 40°C/104°F

APPLICATION DETAILS:

Mixing ratio for 35920:	Base 35920 : hardener 99020 97.5: 1.5 by volume
Application method:	Airless spray Brush/roller (See separate Application instructions)
Thinner (max. vol.):	Do not dilute (See separate Application instructions)
Pot life:	45 minutes (20°C/68°F) (See separate Application instructions)
Nozzle orifice:	.030"-.060" (Reversible)
Nozzle pressure:	Min 275 bar/4000 psi (Airless spray data are indicative and subject to adjustment)
Cleaning of tools:	Styrene and methyl ethyl ketone (See separate Application instructions)
Indicated film thickness, dry:	650 micron/26 mils
Indicated film thickness, wet:	725 micron/29 mils
Recoat interval, min:	With itself: 2 hours (20°C/68°F); others 16 hours (20°C/68°F)
Recoat interval, max:	3 days (20°C/68°F)

Issued: March 2004

2. BAJAK VINYLESTER GF 35920

SURFACE PREPARATION:	<p>New steel: Abrasive blasting to min. Sa 2½.</p> <p>Minimum surface profile corresponding to Rugotest No. 3, BN 11, Keane-Tator Comparator, 5.5 G/S, or ISO Comparator Coarse (G). Oil and grease must be removed by suitable detergent, salts and other contaminants by (high-pressure) fresh water hosing prior to blasting. After blasting clean the surface carefully from abrasives and dust.</p> <p>Maintenance: On old exposed areas excessive amounts of soluble salt residues (in pittings) may call for water jet cleaning or wet abrasive blasting followed by dry abrasive blasting. Alternatively dry abrasive blasting, high pressure fresh water hosing, drying and finally, dry abrasive blasting again.</p>
APPLICATION CONDITIONS:	<p>Use only when application and curing can proceed at temperatures above 10°C/50°F.</p> <p>The in-can temperature of the vinylester material should be between 15°C/59°F and 25°C/77°F to facilitate proper application properties.</p> <p>Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. Relative humidity max. 85%. In confined spaces provide adequate ventilation during application and curing.</p>
PRECEDING COAT:	None.
SUBSEQUENT COAT:	None, or solvent-based coatings as per specification.
REMARKS:	
Film thicknesses:	<p>May be specified in another film thickness than indicated depending on purpose and area of use. Normal range dry is 650-750 micron/26-30 mils. Absolute minimum is 500 micron/20 mils. Maximum not more than 1250 micron/50 mils.</p>
Volume solid:	<p>Theoretically, the products contain 100% solid.</p> <p>By practical spray application, however, one of the reactive components added in surplus will be lost as volatile in an amount of approx. 0.035 kg per litre.</p> <p>Furthermore, the curing process is accompanied by a contraction of approximately 6%. These two factors result in a volume solid of 90% and a spreading rate of 1.4 m²/l at 650 micron.</p> <p>By extremely unfavourable application conditions, higher losses may result in a "theoretical" spreading rate of approximately 1.2 m²/l at 650 micron. The curing is, however, not affected by the higher loss.</p>
Note:	BAJAK'S VINYLESTER GF 35920 is for professional use only.
Safety:	<p>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.</p>



Product Data

APPLICATION INSTRUCTIONS

For product description refer to the product data sheet

BAJAK'S POLYESTER GF 35920

HARDENER 99020

Scope: These Application Instructions cover surface preparation, application equipment, and application details for BAJAK'S POLYESTER GF 35920.

Surface preparation: **New steel:** Remove oil and grease, etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. Abrasive blasting to Sa 2½. Minimum surface profile corresponding to Rugotest No. 3, BN11, Keane-Tator Comparator, 5.5 G/S, or ISO Comparator Coarse (G). After blasting, clean the surface carefully from abrasives and dust.

On pit-corroded surfaces, excessive amounts of salt residues may call for dry abrasive blasting, high pressure fresh water hosing, drying, and finally, dry abrasive blasting again as described above.

Application equipment: BAJAK'S POLYESTER GF 35920, being a high-viscosity material, requires special measures to be taken at application.

Standard airless heavy-duty spray equipment:

Pump ratio: min 45:1 (See Note below)
 Pump output: min. 12 litres/minute (theoretical)
 Input pressure: min. 6 bar/90 psi
 Spray hoses: max. 15 metres/50 feet, 3/8" internal diameter, nylon lined
 max. 3 metres/10 feet, 1/4" internal diameter

Regular surfaces:
 Nozzle size: .030" through .060"
 reversible tip
 Fan angle: 40-60°

Note: Avoid the use of a suction hose. Use an interchangeable pipe, which makes it possible to remove cured paint.

The pump should preferably be fitted with leather seals although Teflon (PTFE) seals are acceptable for small jobs.

If longer spray hoses are necessary, up to 50 metres/150 feet hose (½" internal diameter) can be added. The pump ratio must be raised to 60:1 or more, yet, the high output capacity of the pump must be maintained. Before application starts, the filter should be removed and hoses should be washed with styrene.

Thinning: Alternatively max. 5% styrene may be added, but thinning must be done with care as the anti-sagging properties are drastically reduced by overthinning.

Airless spray data are indicative and subject to adjustment.

Mixing: **Steel temperature between 10°C/50°F and 20°C/68°F:**
 Add ½ a bottle of HARDENER 99020 into the BASE 35920 and mix for 1 minute. Add the second half of HARDENER 99020 and continue to stir until contents are thoroughly mixed (approx. 2 minutes).

Before start-up, the pump must be flushed with styrene.

At spray stop the equipment should be flushed out using a small amount of styrene, followed by methyl ethyl ketone (MEK) for at least 15 minutes. Where spraying is to continue, flush with styrene.

BAJAK'S POLYESTER GF 35920

The pump should work fast during flushing operations and care taken to ensure that equipment is thoroughly cleaned.

Steel temperature at and above 20°C/68°F:

1. Add the content of 1 bottle of RETARDER 99190 and mix thoroughly by mechanical agitation with BASE 35920 only.

After mixing RETARDER 99190 with BASE 35920 it is essential that at least 5 minutes are allowed before commencing the addition of the HARDENER 99020.

2. HARDENER 99020 should then be added as described on page 1.

UNDER NO CIRCUMSTANCES RETARDER 99190 SHOULD BE ADDED AFTER THE HARDENER 99020 HAS BEEN ADDED. THIS WILL TOTALLY NEGATE THE CURING REACTION.

Pot life:

When measured under standard conditions the pot life is 45 minutes at 20°C/68°F. However, for a 20 litres/5 US gallons mix, the heat developed by the chemical reaction is so intense that the corresponding practical pot life is substantially shorter.

Therefore:

- Irrespective of equipment, use the paint immediately after mixing. At a normal application speed the 20 litres/5 US gallons are used in approx. 10 minutes.
- Keep an eye on the paint temperature frequently for instance by touching the can with your hand. If it feels more than hand warm, discard the paint and flush the equipment immediately irrespective of type of spray equipment.

Paint temperature:

If the temperature in the can is below approximately 15°C/59°F, the viscosity will be too high for application. If the paint temperature when mixing is 25°C/77°F or higher, a substantial risk of shortened pot life and curing in can/spray equipment exists. When working in warm, subtropical/tropical climates a refrigerated container can be used for storing/cooling of the paint before application.

Stripe coating:

Edges, corners, manual welds, and places difficult to cover properly by spray application should be stripe coated (touched up) either before or after the spray application.

One or two stripe coats will usually be necessary, but depending on actual conditions.

Extra film thickness:

Extra thickness - extra layer(s) - may be necessary in case of severely pitted and/or where very high degrees of antiabrasive properties are needed.

Indicated film thickness:

1500 micron on splash zone areas, 1000 micron on immersed areas below splash zone, and 750 micron on decks are recommend.

Recoating intervals:

Within a maximum of 85% Relative Humidity the following recoating intervals apply:

Steel temperature		10°C/50°F	15°C/59°F	20°C/68°F	25°C/77°F	30°C/86°F	(35°C/95°F)
With 35920	Min	5 hours	3 hours	2 hours	1½ hours	1 hour	(45 min.)
	Max	7½ days	5 days	3 days	2 days	1½ hour	(1 day)
With other paints (solvent-based)	Min	32 hours	24 hours	16 hours	12 hours	8 hours	(6 hours)
	Max	7½ days	5 days	3 days	2 days	1½ days	(1 day)

The polyester MUST NOT be exposed to (steel) temperatures below 10°C/50°F nor to condensation or Relative Humidity higher than 85% before recoating.

Cleaning of tools:

The equipment should be flushed out and cleaned using styrene followed by methyl ethyl ketone (MEK).



Product Data

BAJAK'S POLYESTER GF 35920

Curing table:

The following curing times apply:

Steel temperature	10°C/50°F	15°C/59°F	20°C/68°F	25°C/77°F	30°C/86°F	(35°C/95°F)
Fully cured	18 days	11 days	7 days	5 days	3½ days	(2½ days)

Time before taking into service:

When the painted surface will be exposed to heavy duty service (e.g. exposure to chemicals, heavy wear and tear), the recommended minimum curing time is:

Steel temperature	10°C/50°F	15°C/59°F	20°C/68°F	25°C/77°F	30°C/86°F	(35°C/95°F)
Minimum	7½ days	5 days	3 days	2 days	1½ days	(1 day)

If not exposed to heavy duty service (eg exposure to light traffic only):

Steel temperature	10°C/50°F	15°C/59°F	20°C/68°F	25°C/77°F	30°C/86°F	(35°C/95°F)
Minimum	60 hours	40 hours	24 hours	16 hours	12 hours	(8 hours)

BAJAK'S POLYESTER GF 35920 is resistant to immersion in calm seawater after an initial curing time as listed hereunder.

Steel temperature	10°C/50°F	15°C/59°F	20°C/68°F	25°C/77°F	30°C/86°F	(35°C/95°F)
Minimum	15 hours	10 hours	6 hours	5 hours	4 hours	(3 hours)

Notes:

1. The temperatures in the tables above are mean values, but the temperature during curing should at no time come below 10°C/50°F.
2. Curing will proceed under water when the water temperature is above 10°C/50°F.
3. Less curing than stated above before exposure to seawater may result in significant discoloration of the surface.

Remarks:

Stripe coating is recommended on surfaces difficult to cover properly by spray. In case of deep pittings higher film thickness is recommended on areas with pittings. To secure sufficient curing at low surface temperatures as well as to secure a pinhole-free paint film at any temperature, the product should always be applied in a wet film thickness above 600 micron.

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.



بازاک (سهامی خاص)

BAJAK'S VINYLESTER 35922

HARDENER 99022

Description: BAJAK'S VINYLESTER 35922 is a solvent free, two-component, heavy duty lining system based on epoxy vinyl ester copolymer.
Applicable in thick coats by standard heavy duty airless spray equipment.

Recommended use:

1. As a high chemical resistance coating for chemical plant over concrete and steel substrates.
2. As a high abrasion coating for severe corrosion environment.
3. Excellent impact strength.
4. High tensile elongation.

Service temperatures: Maximum dry: 140°C/284°F In water (maximum temperature gradient 35°C/63°F): 80°C/176°F.

PHYSICAL CONSTANTS:

Colours/Shade no: Transparent
Finish: Gloss
Volume solids, %: 100 (curable material)
Theoretical spreading rate: 1.4 m²/litre – 650 micron
56 sq.ft./US gallon - 26 mils
Flash point: 26°C/79°F
Specific gravity: 1 kg/litre – 8.7 lbs/US gallon
Dry to touch: 2 (approx.) hours at 20°C/68°F
Fully cured: 1 days at 20°C/68°F
V.O.C.: 35 g/litre – 0.3 lbs/US gallon

Shelf life: 4 months 25°C/77°F from time of production.
Shelf life is dependent on storage temperature. Shelf life is reduced at storage temperatures above 25°C/77°F. Do not store above 40°C/104°F

APPLICATION DETAILS:

Mixing ratio for 35922: Base 35922 : hardener 99022
97.5: 1.5 by weight

Application method: Can be used with hand lay-up, spray-up, and filament winding.
Thinner (max. vol.): Do not dilute (See separate Application instructions)
Pot life: 15 minutes (20°C/68°F) (See separate Application instructions)
Nozzle orifice: .030"-.060" (Reversible)
Nozzle pressure: Min 275 bar/4000 psi
(Airless spray data are indicative and subject to adjustment)

Cleaning of tools: Methyl ethyl ketone (See separate Application instructions)
Indicated film thickness, dry: 650 micron/26 mils
Recoat interval, min: **With itself:** 2 hours (20°C/68°F); **others** 16 hours (20°C/68°F)
Recoat interval, max: 3 days (20°C/68°F)

Issued: Jan. 2009

2. BAJAK'S VINYLESTER 35922

APPLICATION CONDITIONS:	Use only when application and curing can proceed at temperatures above 10°C/50°F. The in-can temperature of the vinylester material should be between 15°C/59°F and 25°C/77°F to facilitate proper application properties. Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. Relative humidity max. 85%. In confined spaces provide adequate ventilation during application and curing.
PRECEDING COAT:	None.
SUBSEQUENT COAT:	Concrete 05500 for steel 15300.
Film thicknesses:	May be specified in another film thickness than indicated depending on purpose and area of use. Normal range dry is 650-750 micron/26-30 mils. Maximum not more than 1250 micron/50 mils.
Volume solid:	Theoretically, the products contain 100% solid. By practical spray application, however, one of the reactive components added in surplus will be lost as volatile in an amount of approx. 0.035 kg per litre. Furthermore, the curing process is accompanied by a contraction of approximately 6%. These two factors result in a volume solid of 90% and a spreading rate of 1.4 m ² /l at 650 micron. By extremely unfavourable application conditions, higher losses may result in a "theoretical" spreading rate of approximately 1.2 m ² /l at 650 micron. The curing is, however, not affected by the higher loss.
Note:	BAJAK'S VINYLESTER 35922 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.



بازاک (سهامی خاص)

BAJAK'S VINYLESTER GF 35925

HARDENER 99022

- Description:** BAJAK'S VINYLESTER GF 35925 is a solvent free, two-component, heavy duty lining system based on epoxy vinylester copolymer and glass flake pigment with barrier effect.
- Recommended use:** Applicable in thick coats by standard heavy duty airless spray equipment.
1. As a high chemical resistance coating for chemical plant over concrete and steel substrates.
 2. As a high abrasion coating for severe corrosion environment.
 3. Excellent impact strength.

Service temperatures: Maximum dry: 140°C/284°F In water (maximum temperature gradient 35°C/63°F): 95°C/203°F.

PHYSICAL CONSTANTS:

Colours/Shade no: Gray
Finish: Semi Gloss
Volume solids, %: 100 (curable material)
Theoretical spreading rate: 1.4 m²/litre – 650 micron dft
56 sq.ft./US gallon - 26 mils
Flash point: 26°C/79°F
Specific gravity: 1.25 kg/litre – 10.4 lbs/US gallon
Dry to touch: 2 (approx.) hours at 20°C/68°F
Fully cured: 1 days at 20°C/68°F
V.O.C.: 35 g/litre – 0.3 lbs/US gallon

Shelf life: 4 months 25°C/77°F from time of production.
Shelf life is dependent on storage temperature. Shelf life is reduced at storage temperatures above 25°C/77°F. Do not store above 40°C/104°F

APPLICATION DETAILS:

Mixing ratio for 35922: Base 35925 : hardener 99022
97.5: 1.5 by volume

Application method: Can be used with hand lay-up, spray-up, and filament winding.

Thinner (max. vol.): Do not dilute (See separate Application instructions)

Pot life: 15 minutes (20°C/68°F) (See separate Application instructions)

Nozzle orifice: .030"-.060" (Reversible)

Nozzle pressure: Min 275 bar/4000 psi
(Airless spray data are indicative and subject to adjustment)

Cleaning of tools: Methyl ethyl ketone (See separate Application instructions)

Indicated film thickness, dry: 700 micron/28 mils

Recoat interval, min: **With itself:** 2 hours (20°C/68°F); **others** 16 hours (20°C/68°F)

Recoat interval, max: 3 days (20°C/68°F)

Issued: Jan. 2009

2. BAJAK'S VINYLESTER GF 35925

APPLICATION CONDITIONS:	Use only when application and curing can proceed at temperatures above 10°C/50°F. The in-can temperature of the vinylester material should be between 15°C/59°F and 25°C/77°F to facilitate proper application properties. Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. Relative humidity max. 85%. In confined spaces provide adequate ventilation during application and curing.
PRECEDING COAT:	None.
SUBSEQUENT COAT:	Concrete 05970 for steel 15300.
Film thicknesses:	May be specified in another film thickness than indicated depending on purpose and area of use. Normal range dry is 650-750 micron/26-30 mils. Maximum not more than 1250 micron/50 mils.
Volume solid:	Theoretically, the products contain 100% solid. By practical spray application, however, one of the reactive components added in surplus will be lost as volatile in an amount of approx. 0.035 kg per litre. Furthermore, the curing process is accompanied by a contraction of approximately 6%. These two factors result in a volume solid of 90% and a spreading rate of 1.4 m ² /l at 650 micron. By extremely unfavourable application conditions, higher losses may result in a "theoretical" spreading rate of approximately 1.2 m ² /l at 650 micron. The curing is, however, not affected by the higher loss.
Note:	BAJAK'S VINYLESTER GF 35925 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.



BAJAK UNDER WATER PUTTY 36826

CURING AGENT 66826

Description:	Bajak 36826 is a two-component solvent free epoxy polyamine putty for repairing pits cracks and voids in steel, concrete, wood and other surfaces. Has a unique ability to be mixed, applied and cured under water with an excellent anticorrosive efficiency in thick layer in severe corrosive environment.	
Recommended use:	As a hand applied repair compound for application to under water blasted steel and concrete and splash zone areas to protect against corrosion.	
CERTIFICATE & APPROVAL:	Approved and applied by Iranian Off-shore Oil Company (IOOC).	
Service temperature:	Maximum Wet: 50°C/ 122°F	Dry: 93°C/ 200°F

PHYSICAL CONSTANTS:

Colours:	Olive Green
Finish:	Flat
Volume Solid:	100%
Theoretical spreading rate:	0.16 M2 /Liter - 6000 micron DFT.
Flash point:	100 °C/212° F
Specific gravity:	1.7 kg/liter
Surface dry:	2 hours at 20 °C/68 °F(ISO 1517) in dry condition.
Dry to touch:	2 -3 hours at 20 °C/68°F. (ISO 1517) in dry condition.
Dry to handle:	8 hrs.at 20 °C/68°F. in dry condition.

The physical constants are subject to normal manufacturing tolerances.

APPLICATION DETAILS:

	Base 36826 : Curing agent 66826
Mixing ratio:	1 . 1 by volume
Application method:	Hand molding or palette knife
Pot life:	Working time at 20°C, below and above water:
	Golfball size mix: 40 minutes
	Baseball size mix: 30 minutes
	½ gallon mix: 15 minutes
	Working time is reduced by half at temperature above 27°C.
Cleaning of tools:	THINNER 08020
Indicated dft:	6000 microns / 240 mils

2.BAJAK PUTTY 36826

SURFACE

New Steel: Abrasive blasting to minimum Sa 2½ or high pressure water blasting is recommended. The surface must be completely clean at the time of application.

PREPARATION:

A surface profile of 3-4mils (75-100 microns) is recommended.

For applying to bare steel under water or permanently in wet conditions the surface should be prepared by power diskling or by needle gun to achieved a clean, roughened surface in accordance with SSPC-SPI 1, power tool cleaning.

Repair and maintenance: Remove oil and grease, etc with suitable detergent. Clean damaged areas thoroughly by power tool cleaning to St 3 (minor areas) or by abrasive blasting to min. Sa 2, preferably to Sa2½.

Concrete: Abrasive blasting. The surface must be completely clean at the time of application.

APPLICATION CONDITION:

Use only on a clean surface. To facilitate stirring, the material temperature should in o case be less than approx. 20°C/68°F. Use one 5 liters can of mixed at a time.

PRECEDEING COAT:

None.

SUBSEQUENT COAT:

None.

REMARKS:

Film thicknesses:

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 DFT is 6000 microns/ 240 mils.

Note:

BAJAK PUTTY 336826 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 and national safety regulations. Harmful or fatal if swallowed; immediately seek medical assistance swallowed. Avoid inhalations of possible solvent vapors or paint mist, as well as paint contact with skin and eyes. Apply only on well-ventilated areas and ensure that adequate forced ventilation exists when applying paint in confined spaces or when the air is stagnant. Always take precautions against the risks of fire and explosions.

3.BAJAK PUTTY 36826

Application procedure:

Apply by hand, trowel or broad knife. Spread material smoothly onto the surface in a 3.1 to 6.4 mm thick layer using enough pressure to displace water and air bubble. Smooth out the area by hand. When starting another mix, start spreading at and away from the previous applied film. This will help prevent trapped air bubbles or leaving an area uncoated.

When applied underwater or when wetted with water during application, the surface of 36826 will form an emulsified lighter green "scum" layer. This layer is normal and facilitates application. The film under the scum layer remains undisturbed and will cure properly. The scum layer will cure and become part of the finish when 36826 is cured above water, however, this layer will remain soft and uncured when the 36826 is kept underwater during curing.

Mixing & Thinning:

Mixing:

Mix part A (36826) to one part B (66826) by volume. Mix by hand scooping a quantity of the A component from the can and then scoop the same quantity of the B component from its can. Mix and knead the two components by hand until the yellow and black colors have combined to make a uniform olive green color. Apply this mixture immediately after mixing; no sweat-in time is required. To assist in mixing, keep the gloved hands and the materials wet with water during the mixing process.

Thinning:

Not recommended.

Do not mix more material than can be applied in the working times listed. The material may still appear to be workable after the time limit is exceeded, but it will not properly adhere to the substrate after application and curing.



بازاک (سهامی خاص)

BAJAK MIO EPOXY 42421

CURING AGENT 60021

Description: BAJAK 42421 is a two component , epoxy polyamide primer and intermediate which cures to a coating based on MIO with excellent resistance to corrosive environments.

Recommended use:

- 1- As a general purpose primer or intermediate for Bajak epoxy systems on steel and directly on primed surfaces.
- 2- As a blast primer for temporary protection of steel blast cleaned on site.

Service temperatures: Dry :
maximum: 140°C

TECHNICAL DATAS:

Binders: Epoxy resin and polyamide hardener,
Pigments: TiO₂ , Micasious Iron Oxide, colored pigment and extenders no soluble in water.
Solvents: Ketones, Alcohols and aromatic hydrocarbons.
Hardener: 60021

PHYSICAL CONSTANTS:

Mixed product: 42421
Colours/Shade no: Beige/8036
Finish: Semi Matt
Volume Solids, %: 61%
Theoretical spreading rate: 6.1 m²/litre at 100 microns dft.
Flash point: 25°C
Specific gravity: app. 1.5 kg/litre
Surface dry : app. 3 hrs at 20°C (ISO 1517)
Dry to touch : 8 – 10 hrs at 20°C
Fully cured : 7 days at 20°C
V.O.C : 490 g/litre

APPLICATION DETAILS:

Mixing ratio for 11160:	BASE 42421 5.5 : 1	: Curing agent 60021 by weight	
Application method:	Airless spray	air spray	Brush (touch-up)
Thinner (max.vol.):	08020 (10%)	8020 (25%)	8020 (5%)
Pot life :	8 hours (20°C)	8 hours (20°C)	6 hours (20°C)
Nozzle orifice:	0.021" - 0.023"		
Nozzle pressure:	200 bar/3000 psi		
Cleaning of tools:	8020		
Indicated dft:	120 microns		
Indicated wft:	200 microns		
Recoat interval, min:	8 hrs at 20°C		
Recoat interval, max:	7 days at 20°C		

2. BAJAK MIO EPOXY 42421

SURFACE Abrasive blasting, to SA 2½ with a surface profile corresponding to rugotest No. 3 , BN10,
PREPARATION: Kean-Tator Comparator , Rough Medium (G) .

APPLICATION Use only where application and curing can proceed at temperatures above 10°C .
CONDITIONS: The temperature of the surface and that of the paint itself must be above this limit. Optimum
 results are obtained at 17°C .Apply only on a dry and clean surfaces with a temperature/
 3°C above the dew point to avoid condensation Relative humidity max. 80% , preferably
 40-60% .

PRECEDING 11160, or as per specificaiton.
COAT:

SUBSEQUENT: 11590, or as per specification.
COAT:

REMARKS:

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

Safety: Handle with care. Before and during use, observe all safety labels on packaging and paint
 containers. Avoid inhalation of possible solvent vapors or paint mist, as well as paint contact
 with skin and eyes. Apply only in well ventilated areas.

Issued:

Feb. 2004

Product Data



BAJALIN UNDERCOAT 42460

- Description:** BAJALIN UNDERCOAT 42460 is a fairly quick-drying alkyd paint.
- Recommended use:** As a general purpose undercoating in alkyd paint systems on exterior and interior steelwork, wood, plaster, etc. in mildly to moderately corrosive environment.
- Service temperatures:** Maximum, dry: 120°C/248°F.

PHYSICAL CONSTANTS:

- Colours : White
 Finish: Flat
 Volume solids, %: 53 ± 1
 Theoretical spreading rate: 13.3 m²/litre - 40 micron
 531 sq.ft./US gallon - 1.6 mils
 Flash point: 38°C/100°F
 Specific gravity: 1.4 kg/litre - 11.7 lbs/US gallon
 Dry to touch: 4 (approx.) hours at 20°C/68°F
 V.O.C.: 385 g/litre - 3.2 lbs/US gallon

APPLICATION DETAILS:

- | | | | | |
|--------------------------------|--|-------------|------------|------------------------|
| Application method: | Airless spray | Air spray | Brush | |
| Thinner (max.vol.): | 08230 (5%) | 08230 (15%) | 08230 (5%) | (See REMARKS overleaf) |
| Nozzle orifice: | .015"-.018" | | | |
| Nozzle pressure: | 150 bar/2200 psi | | | |
| | <i>(Airless spray data are indicative and subject to adjustment)</i> | | | |
| Cleaning of tools: | THINNER 08230 | | | |
| Indicated film thickness, dry: | 40 micron/1.6 mils | | | |
| Indicated film thickness, wet: | 75 micron/3 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.

BAJALIN UNDERCOAT 42460

APPLICATION CONDITIONS: As dictated by normal good painting practice.
In confined spaces provide adequate ventilation during application and drying.

PRECEDING COAT: BAJALIN PRIMERS or according to specification.

SUBSEQUENT COAT: BAJALIN ENAMELS or according to specification.

Film thicknesses: 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 30-40 micron/1.2-1.6 mils.

Thinning: THINNER 08080 may be used for spray application, however, with a certain risk of wrinkling of a preceding **fresh** BAJALIN coat.

Recoating: Recoating intervals related to later conditions of exposure:
(40 micron/1.6 mils film thickness of BAJALIN UNDERCOAT 42460)

	Minimum		Maximum	
Surface Temperature	20°C/68°F		20°C/68°F	
Recoated with	Atmospheric		Atmospheric	
	Mild	Medium	Mild	Medium
BAJALIN (white spirit only)	5 hours	8 hours	None	7 days

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

Before recoating after exposure in contaminated environment, clean surface thoroughly by (high pressure) fresh water cleaning and allow to dry.

Note: **BAJALIN UNDERCOAT 42460 is for professional use only.**

BAJAPOX MIDCOAT 42523

CURING AGENT 62020A

Description:	BAJAK'S 42523 is a two component epoxy midcoat based on epoxy and polyamide resins and colored pigments with an excellent barrier protective efficiency in moderate to severe environments.	
Recommended use:	As a midcoat in epoxy systems .	
Service temperature:	Dry: Maximum 130 °C	Wet: Maximum 50 °C

PHYSICAL CONSTANTS:

Colors/Shade No:	Grey
Finish:	Semi-Flat
Volume Solid:	Min. 50
Weight Solid:	66%-70%
Theoretical spreading rate:	12.5 m ² /liter 40 Mic. Dft.
Flash point:	32 °C
Specific gravity:	1.31-1.37 kg/liter
Surface dry:	Max. 2 hours at 20 °C (ISO 1517)
Dry to touch:	Max. 4 hours at 20 °C
Fully cured:	7 days at 20 °C
V.O.C.:	Max 420 gr/liter
Shelf life:	1 Years (25 °C/77 °F) from time of production. Depending on storage condition, mechanical stirring may be necessary before usage.

APPLICATION DETAILS:

Mixing ratio for 11320	Base 42523 : Curing agent 6202A 6 : 1 by weight	
Application method:	Curtain	Brush (touch-up)
Thinner (max. vol.)	08026(25%)	08026 (5%)
Pot life:	6 hours (20 °C / 68 °F)	8hours (20 °C / 68 °F)
Nozzle orifice:		
Nozzle pressure:		
Cleaning of tools:	08026	
Indicated film thickness, dry:	40 microns	
Indicated film thickness, wet:	80 microns	
Recoat interval, min:	8 hours (20 °C)	
Recoat interval, max:	7 days (20 °C), See REMARKS overleaf	

Issued: Feb. 2018

2. BAJAK'S EPOXY FLOW PRIMER 42523

**APPLICATION AND
CURING CONDITIONS:**

Primed steel: The surface must be completely clean and dry at the time of application. And its temperature must be above the dew point to avoid condensation. At the freezing point and below, be ware of the risk of ice on the surface which will hinder the adhesion. High humidity and/or condensation during application and the following 16 hours (20°C/68°F) may adversely affect the film formation. In confined spaces provide adequate ventilation during application and drying.

**PRECEDING
COAT:**

12323, or as per specification.

**SUBSEQUENT
COAT:**

BAJAK'S POLYURETHANE TOP COAT 52552, or as per specification.

REMARKS:

Film thicknesses:

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 is 40 microns/ 1.6 mils.

Thinning:

The type and amount of thinner depend on application conditions, application method, temperature, ventilation, and substrate. Thinner 08026 is recommended in general.

**Physical data versus
temperatures:**

Recoating And drying/curing Time:					
Surface temperature		5°C /41°F	10°C /50°F	20°C /68°F	30°C /86°F
Dry to touch approx.		12 hours	8 hours	4 hours	3 hours
Resist condensing humidity/ light showers after		4 days	2 days	24 hours	12 hours
Fully cured		20 days	14 days	7 days	5 days
Recoating interval, Recoating with 52552	Min	24 hours	16 hours	8 hours	4 hours
	Max	15 days	12 days	5 days	3 days

A completely clean surface is mandatory to ensure intercoat adhesion, especially at long recoating intervals. Any dirt,oil,and grease have to be removed, e.g. with suitable detergent.

Salts to be removed by fresh water hosing. To check an adequate quality of the surface cleaning a test patch is recommended before actual recoating.

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 and national safety regulations. Harmful or fatal if swallowed; immediately seek medical assistance swallowed. Avoid inhalations of possible solvent vapors or paint mist, as well as paint contact with skin and eyes. Apply only on well-ventilated areas and ensure that adequate forced ventilation exists when applying paint in confined spaces or when the air is stagnant. Always take precautions against the risks of fire and explosions.



BAJAPOX MULTI-STRENGTH 42525

CURING AGENT 62025

Description:	BAJAPOX MULTI-STRENGTH 42525 is a self-priming, two-component, high-build, polyamide/amine cured epoxy paint which cures to an abrasion resistant coating with good resistance to seawater. Applicable by standard heavy duty airless spray equipment. Minimum curing temperature 10°C/50°F.
Approval:	Approved by Germanischer Lloyd (GL) as ballast tank coating and ship hull coating.
Recommended use:	As a heavy duty coating for areas exposed to abrasion such as ramps, ship hulls and holds of bulk carriers. As a ballast tank coating for special purposes such as chemical carriers carrying hot cargoes. As a finishing coat where a cosmetic appearance is of less importance.
Service temperatures:	Dry: Maximum 140°C/284°F (See REMARKS overleaf) Ballast water service: Resists normal ambient temperatures at sea* Other water service: 50°C/140°F (no temperature gradient) Other liquids: Contact BAJAK *Avoid long-term exposure to negative temperature gradients.

PHYSICAL CONSTANTS:

Colours/Shade nos:	Grey - Red
Finish:	Semi-gloss
Volume Solids, %:	81 ± 1
Theoretical spreading rate:	4.1 m ² /litre – 200 micron 162 sq.ft./US gallon - 8 mils
Flash point:	27°C/81°F
Specific gravity:	1.6 kg/litre – 13.4 lbs/US gallon
Dry to touch:	7-8 hours at 20°C/68°F
Fully cured:	7 days at 20°C/68°F
V.O.C.:	205 g/litre - 1.7 lbs/US gallon

APPLICATION DETAILS:

Mixing ratio:	Base 42525 : Curing agent 62025 4 : 1 by volume
Application method:	Airless spray Brush (touch-up)
Thinner (max.vol.):	08450 (2%) 08450 (2%)
Pot life:	1 hour (20°C/68°F)
Nozzle orifice:	.023"-.027"
Nozzle pressure:	250 bar/3600 psi (Airless spray data are indicative and subject to adjustment)
Cleaning of tools:	BAJAK'S TOOL CLEANER 99610
Indicated film thickness, dry:	200 micron/8 mils
Indicated film thickness, wet:	250 micron/10 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. 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.
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Issued: March 2009

2- BAJAPOX MULTI-STRENGTH 42525

SURFACE PREPARATION:	<p>New steel, " heavy duty use ": Abrasive blasting to min. Sa 2½. Grit-blasted surfaces: recommended profile is Rz minimum 100 micron – maximum 150 micron, corresponding to ISO Comparator Coarse (G). Oil and grease must be removed with suitable detergent, salts and other contaminants by (high pressure) fresh water hosing prior to blasting. After blasting, clean the surface carefully from abrasive and dust.</p> <p>New steel, ballast tanks and similar areas: Abrasive blasting to Sa 2½. For temporary protection, if required, use a suitable shopprimer. Damage of shopprimer and contamination from storage and fabrication should be thoroughly cleaned prior to final painting. The best performance will be obtained by abrasive spot-blasting of welds, rusty spots, etc. and by abrasive sweep blasting of the intact shopprimer. For repair and touch-up use BAJAPOX MULTI-STRENGTH 42525. Stainless steel: (Ballast tanks in chemical carriers) to be abrasive blasted to a uniform, sharp, dense profile, ISO Comparator Medium (G), corresponding to Rz minimum 50 micron. Any salts, grease, oil, etc. to be removed before abrasive blasting is commenced.</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 abrasive blasting or power tool cleaning (minor areas only). Feather edges to sound intact areas.</p> <p>Dust off residues. Touch-up to full film thickness.</p> <p>On old ship bottoms and similar pit corroded surfaces, excessive amounts of salt residues may call for dry abrasive blasting, high pressure fresh water hosing, drying, and finally, dry abrasive blasting again. Alternatively, water jetting may be used provided the steel surface has already the surface profile as described above: New steel, "heavy duty use".</p>
APPLICATION CONDITIONS:	Use only where application and curing can proceed at temperatures above 10°C/50°F. The temperature of the paint itself should be above 15°C/59°F, preferably above 20°C/68°F for proper application. Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. Relative humidity max. 90%. In confined spaces provide adequate ventilation during application and drying.
PRECEDING COAT:	None, but BAJAPOX 15590 can be used as a "blast primer"
SUBSEQUENT COAT:	42525, or as per specification, depending on area of use.
REMARKS:	
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.
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 150-200 micron/6-8 mils. It is recommended to use heavy airless spray equipment with a pump transmission rate of 60:1 (approximately), and a theoretical output of min. 12 liters per minute.
Recoating :	At 20°C/68°F surface temperature and good ventilation the following recoating intervals apply: (200 micron/8 mils dry film thickness of BAJAPOX MULTI-STRENGTH 42525)
BAJAPOX:	Minimum Maximum
BAJATHANE:	6 hours 30 days 6 hours 1 day*
	*Optimal adhesion is obtained when BAJAPOX MULTI-STRENGTH 42525 is recoated while still tacky. The long maximum recoating interval for BAJAPOX will be reduced if the coating is more than just scarcely exposed to direct sunshine before recoating. If the interval is exceeded, roughening of surface is necessary to ensure intercoat adhesion. Do not store at temperatures above 45°C/113°F. Normally not to be diluted, but exceptionally 1-2% BAJAK'S THINNER 08450 may be used.
Note:	Note: BAJAPOX MULTI-STRENGTH 42525 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 environment. Apply only in well ventilated areas.
Issued:	March 2009



Product Data

BAJAPOX 45080 BAJAPOX 45083

High temperatures: CURING AGENT 95010
Low to medium temperatures: CURING AGENT 97480

Description: BAJAPOX 45080/45083 is a high-build, modified, two-component epoxy paint, which cures to a coating with good resistance to water, splashes of mineral oils, aliphatic hydrocarbons, and to abrasion and impact. Limited resistance to aromatic and stronger solvents, and to acids and oxidizing materials.

Recommended use: As an intermediate coat with no maximum recoating interval in BAJAPOX/BAJATHANE systems.
CURING AGENT 95010, polyamide, is typically for use above 5°C/41°F, CURING AGENT 97480, polyamide adduct, facilitates curing down to -10°C/14°F.

Service temperatures: Maximum, dry: 120°C/248°F (see REMARKS overleaf).

PHYSICAL CONSTANTS:

	45080	45083
Version; mixed product:	Off-white	Off-white
Colours :	Flat	Flat
Finish:	48 ± 1	45 ± 1
Volume solids, %:	6.4 m ² /litre - 75 micron	6.0 m ² /litre - 75 micron
Theoretical spreading rate:	257 sq.ft./US gallon - 3 mils	241 sq.ft./US gallon - 3 mils
Flash point:	30°C/86°F	30°C/86°F
Specific gravity:	1.4 kg/litre - 11.7 lbs/US gallon	1.4 kg/litre - 11.7 lbs/US gallon
Surface dry:	1½ (app) hours at 20°C/68°F (ISO 1517)	3 (app) hours at 10°C/50°F (ISO 1517)
Dry to touch:	4 (app) hours at 20°C/68°F	6 (app) hours at 10°C/50°F
Fully cured:	7 days at 20°C/68°F	14 days at 10°C/50°F
V.O.C.:	495 g/litre - 4.1 lbs/US gallon	515 g/litre - 4.3 lbs/US gallon

*Other shades according to assortment list.

APPLICATION DETAILS:

	45080	45083
Mixing ratio:	Base 45080 : Curing agent 95010 8.4 : 1.6 by volume	Base 45083 : Curing agent 97480 8.4 : 1.6 by volume
Application method:	Airless spray Brush	Airless spray Brush
Thinner (max.vol.):	08450(5%) 08450 (5%)	08450 (5%) 08450 (5%)
Pot life:	6 hours (20°C/68°F) 8 hours (20°C/68°F)	4 hours (20°C/68°F) (Airless) 8 hours (20°C/68°F) (Brush)
Nozzle orifice:	.015"-.021"	
Nozzle pressure:	150 bar/2100 psi (Airless spray data are indicative and subject to adjustment)	
Cleaning of tools:	BAJAK'S TOOL CLEANER 99610 or THINNER 08450	
Indicated film thickness, dry:	75 micron/3 mils (See REMARKS overleaf)	
Indicated film thickness, wet:	150 micron/6 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. 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.

BAJAPOX 45080 / 45083

APPLICATION CONDITIONS: Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation.
 Use only where application and curing can proceed at temperatures above 5°C/41°F when using CURING AGENT 95010, and above -10°C/14°F when using CURING AGENT 97480. The temperature of the paint itself should be minimum 15°C/59°F.
 In confined spaces provide adequate ventilation during application and drying.

PRECEDING COAT: BAJAPOX primers/intermediate coats or according to specification.

SUBSEQUENT COAT: BAJATHANE topcoats according to specification.

REMARKS:
 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.
 Film thicknesses: 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 50-125 micron/2-5 mils.
 Recoating: **Before recoating, clean the surface thoroughly of all contamination. Especially at long intervals before recoating very careful cleaning is required.**
 To check adequate quality of the preparatory cleaning a test patch is recommended before actual recoating.
 Recoating intervals related to later conditions of exposure:
 (75 micron/3 mils dry film thickness of BAJAPOX 45080 / 45083)

	Curing agent 95010				Curing agent 29748			
	Minimum		Maximum		Minimum		Maximum	
Surface temperature	20°C/68°F				10°C/50°F			
Recoated with	Atmospheric				Atmospheric			
	Medium	Severe	Medium	Severe	Medium	Severe	Medium	Severe
BAJATHANE topcoats	4 hours	8 hours	None*	None*	6 hours	12 hours	None*	None*

Note: *If there is any doubt about the adequacy of the surface preparation, a thin, fresh coat of BAJAPOX 45080 / 45083 is applied to secure adhesion of the following coat.
BAJAPOX 45080 / 45083 is for professional use only.

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.



Product Data

BAJAPOX 45182

CURING AGENT 98180

Description:	BAJAPOX 45182 is a two-component, low-temperature curing, modified polyamide adduct cured epoxy.
Recommended use:	For marine and protective use as a "bridge coat" between epoxy and physically drying coatings.
Service temperatures:	Maximum, dry: 80°C/176°F

PHYSICAL CONSTANTS:

Colours :	Yellowish grey
Finish:	Flat
Volume solids, %:	46 ± 1
Theoretical spreading rate:	4.6 m ² /litre - 100 micron 184 sq.ft./US gallon - 4 mils
Flash point:	23°C/73°F
Specific gravity:	1.3 kg/litre - 10.8 lbs/US gallon
Dry to touch:	6 (approx.) hours at 20°C/68°F
Fully cured:	7 days at 20°C/68°F
V.O.C.:	490 g/litre - 4.1 lbs/US gallon

APPLICATION DETAILS:

Mixing ratio:	Base 45182 : Curing agent 98180 4 : 1 by volume
Application method:	Airless spray Brush (touch up)
Thinner (max.vol.):	08450 (5%) 08450 (5%)
Pot life:	3 hours (20°C/68°F)
Nozzle orifice:	.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 film thickness, dry:	100 micron/4 mils (see REMARKS overleaf)
Indicated film thickness, wet:	225 micron/9 mils
Recoat interval, min:	6 hours (20°C/68°F)
Recoat interval, max:	Antifoulings: 3 days (20°C/68°F) Other topcoats, for areas above water: according to separate painting specification

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.
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BAJAPOX 45182

SURFACE PREPARATION:	<p>New steel: Abrasive blasting to Sa 2½. For temporary protection if required use suitable shopprimer. Any damage of shopprimer and contamination from storage and fabrication should be thoroughly cleaned prior to final painting. For priming purposes, specified BAJAPOX paint.</p> <p>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 powertool cleaning. Feather edges to sound and intact areas. Dust off residues. Touch up to full film thickness with specified BAJAPOX paint (see REMARKS below).</p>
APPLICATION CONDITIONS:	<p>Use only where application and curing can proceed at temperatures higher than -10°C/14°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 such as sea chest or stagnant air under large flat bottoms provide adequate ventilation during application and drying.</p>
PRECEDING COAT:	BAJAPOX systems according to specification.
SUBSEQUENT COAT:	Antifouling or according to specification.
REMARKS:	
Film thicknesses:	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 75-125 micron/3-5 mils. May be specified in 50 micron/2 mils dry film thickness, however (more) thinning may be required to facilitate proper film formation.
Film thicknesses, subsequent coats:	BAJAPOX 45182 is designed for recoating with antifouling in any normal specified total film thicknesses. BAJAPOX 45182 is not designed for recoating with heavy duty epoxy systems. Later maintenance of paint systems with BAJAPOX 45182 as a part of the system is accordingly most conveniently carried out by touch-up with eg BAJAPOX 45150 including proper overlap of intact surrounding paint system.
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 etting may be relevant to remove any degraded surface layer and may also replace the above-mentioned cleaning methods when properly executed. To check whether the quality of the surface cleaning is adequate, a test patch may be relevant. A thin extra coat of BAJAPOX 45182 may advantageously be applied if there is any doubt about suitability of cleaning process.
Note:	BAJAPOX 45182 is for professional use only.

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



Product Data

BAJAPOX HI-BUILD 45230

CURING AGENT 95040

Description:

BAJAPOX HI-BUILD 45230 is a two-component, high build, polyamide cured epoxy Point. It forms a hard and tough coating resistant to abrasion, Impact, seawater, splashes of mineral oils, aliphatic hydrocarbons, and some vegetable and animal oils such as fish oil. Limited resistance to aromatic hydrocarbons and stronger solvents. Not resistant to alkalis, acids, and oxidizing materials.

Recommended use:

In moderate to severely corrosive environments as an intermediate or finishing coat directly on cured zinc silicate (ZINCSIL products) or similar surfaces to minimize popping.

Not recommended for the Interior of tanks.

For shop application or for use below 10°C/50°F. CURING AGENT 95420 can substitute CURING AGENT 95040 - please see overleaf.

Maximum, dry: 140°C/284°F.

Service temperatures:

PHYSICAL CONSTANTS:

Colours:	Light grey
Finish:	Semi-flat
Volume solids:	61%
Theoretical spreading rate:	6.1 m ² /litre-100 micron 245 sq.ft./US gallon- 4 mils
Flash point:	25°C/77°F
Specific gravity:	1.4 kg/litre-11.7 lbs/US gallon
Surface dry:	3 (approx.) hours at 20°C/68°F (ISO 1517)
Dry to touch:	8-10 hours at 20°C/68°F
Fully cured:	1 week at 20°C/68°F
V.O.C.:	367 g/litre-3.1 lbs/US gallon

APPLICATION DETAILS:

Mixing ratio:	Base 45230: Curing agent 95040 3: 1 by volume	
Application method:	Airless spray	Brush (touch up)
Thinner (max. vol.):	08700 (5%)	08700 (5%)
Pot life:	2 hours (20°C/68°F)	6 hours (20°C/68°F)
Nozzle orifice:	.018"-.021"	
Nozzle pressure:	200 bar/2900 psi (Airless spray data are indicative and subject to adjustment)	
Cleaning of tools:	BAJAK'S TOOL CLEANER 99610	
Indicated film thickness, dry:	100 micron/4 mils	
Indicated film thickness, wet:	175 micron/7 mils	
Recoat Interval, min:	See REMARKS overleaf	
Recoat interval, max:	See REMARKS overleaf	

SURFACE PREPARATION:

Zinc silicate coated surfaces: Remove oil and grease etc. with suitable detergent.
Remove salt and other contaminants by (high pressure) freshwater cleaning. After exposure to high humidity, zinc salts ("white rust") will have to be carefully removed by high pressure fresh water cleaning if necessary combined with scrubbing with stiff nylon brushes. Consult the APPLICATION INSTRUCTIONS for the relevant ZINCSIL product.

BAJAPOX HI-BUILD 45230

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.
Note: For curing at temperatures below 10°C/50°F and down to -10°C/14°F, CURING AGENT 95040 can be used. Mixing ratio 45230:95040 = 3.0:1.0 parts by volume. Can also substitute for shop application where fast drying and shorter recoating intervals are required. Please contact BAJAK for further advice.

PRECEDING COAT:

BAJAK'S ZINCSIL qualities, or according to specification.

SUBSEQUENT COAT:

None, or as listed below under recoating intervals, according to specification. For other qualities, consult nearest BAJAK office.

REMARKS:
 Film thicknesses:

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 50-100 micron/2.4 mils. However, to obtain optimum anti-popping properties on top of zinc silicates (ZINCSIL) apply BAJAPOX HI-BUILD 45230 in a dry film thickness of at least 75 micron/3 mils. It is recommended to apply a mist coat of the non-diluted BAJAPOX HIILD 45230, let the air escape, and then a few minutes' later apply the full coat of BAJAPOX Hi BUILD 45230.
 At temperatures below approximately 25°C/77°F this procedure is especially recommended.

Recoating:

Recoating Intervals related to later conditions of exposure:

(100 micron/4 mils dry film thickness of BAJAPOX HI-BUILD 45230)

	Minimum			Maximum		
	20°C/68°F			20°C/68°F		
Recoated with (quality numbers only)	Atmospheric			Atmospheric		
	Medium	Severe	Water Immersion	Medium	Severe	Water Immersion
56360	6 hours	6 hours	Not relevant	16 hours	16 hours	Not relevant
46410	6 hours	6 hours	Not relevant	36 hours	36 hours	Not relevant
55210	16 hours	16 hours	Not relevant	None	3 days*	Not relevant
45200 45230	16 hours	16 hours	Not relevant	None	30 days*	Not relevant

*If the coating has been subjected to direct sunlight for a short period only, the maximum recoating interval may be prolonged.

Before recoating after exposure in contaminated environment clean the surface thorough by pressure fresh water hosing and allow to dry. If the maximum recoating interval is exceed roughening of the surface Is necessary to ensure intercoat adhesion.

Note:

BAJAPOX HI-BUILD 45230 is for professional use only.

SAFETY:

Packings are provided with applicable safety labels which should be observed. In addition, Material Safety Data Sheet(s) should be consulted and national or local safety regulations should be followed.
 As a general rule, inhalation of possible solvent vapours or paint mist, and contact of liquid paint with skin and eyes, should be avoided. Forced ventilation should be provided when applying paint in confined spaces or stagnant air. Even when ventilation is provided, respiratory, skin, and eye protection are always recommended when spraying paint. Necessary precautions against the risk of fire or explosions must be taken.

BAJAPOX MULTI-STRENGTH 45750A

CURING AGENT 97650A

Description: BAJAPOX MULTI-STRENGTH 45750A is a self-priming, two-component, high-build, polyamide/amine cured epoxy paint which cures to an abrasion resistant coating with good resistance to seawater. Applicable by standard heavy duty airless spray equipment. Minimum curing temperature 10°C/50°F.

Recommended use: As a heavy duty coating for areas exposed to abrasion such as ramps, ship hulls and holds of bulk carriers.
As a ballast tank coating for special purposes such as chemical carriers carrying hot cargoes.
As a finishing coat where a cosmetic appearance is of less importance.

Service temperatures: Dry: Maximum 140°C/284°F (See REMARKS overleaf)
Ballast water service: Resists normal ambient temperatures at sea*
Other water service: 50°C/140°F (no temperature gradient)
Other liquids: Contact BAJAK
*Avoid long-term exposure to negative temperature gradients.

PHYSICAL CONSTANTS:

Colours/Shade nos:	Grey/Red
Finish:	Semi-gloss
Volume Solids, %:	74 ± 1
Theoretical spreading rate:	3.7 m ² /litre – 200 micron 146 sq.ft./US gallon - 8 mils
Flash point:	27°C/81°F
Specific gravity:	1.55 kg/litre – 13 lbs/US gallon
Dry to touch:	7-8 hours at 20°C/68°F
Fully cured:	7 days at 20°C/68°F
V.O.C.:	205 g/litre - 1.7 lbs/US gallon

APPLICATION DETAILS:

Mixing ratio for 45750A:	Base 45750A : Curing agent 97650A 5 : 1 by weight
Application method:	Airless spray Brush (touch-up)
Thinner (max.vol.):	08450 (2%) 08450 (2%)
Pot life:	1 hour (20°C/68°F)
Nozzle orifice:	.023"-.027"
Nozzle pressure:	250 bar/3600 psi (Airless spray data are indicative and subject to adjustment)
Cleaning of tools:	BAJAK'S TOOL CLEANER 99610
Indicated film thickness, dry:	200 micron/8 mils
Indicated film thickness, wet:	250 micron/10 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. 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.

Issued: Feb.2007

2- BAJAPOX MULTI-STRENGTH 45750A

SURFACE PREPARATION:	<p>New steel, "heavy duty use": Abrasive blasting to min. Sa 2½. Grit-blasted surfaces: recommended profile is Rz minimum 100 micron – maximum 150 micron, corresponding to ISO Comparator Coarse (G). Oil and grease must be removed with suitable detergent, salts and other contaminants by (high pressure) fresh water hosing prior to blasting. After blasting, clean the surface carefully from abrasive and dust.</p> <p>New steel, ballast tanks and similar areas: Abrasive blasting to Sa 2½. For temporary protection, if required, use a suitable shopprimer. Damage of shopprimer and contamination from storage and fabrication should be thoroughly cleaned prior to final painting. The best performance will be obtained by abrasive spot-blasting of welds, rusty spots, etc. and by abrasive sweep blasting of the intact shopprimer. For repair and touch-up use BAJAPOX MULTI-STRENGTH 45750A. Stainless steel: (Ballast tanks in chemical carriers) to be abrasive blasted to a uniform, sharp, dense profile, ISO Comparator Medium (G), corresponding to Rz minimum 50 micron. Any salts, grease, oil, etc. to be removed before abrasive blasting is commenced.</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 abrasive blasting or power tool cleaning (minor areas only). Feather edges to sound intact areas.</p> <p>Dust off residues. Touch-up to full film thickness.</p> <p>On old ship bottoms and similar pit corroded surfaces, excessive amounts of salt residues may call for dry abrasive blasting, high pressure fresh water hosing, drying, and finally, dry abrasive blasting again. Alternatively, water jetting may be used provided the steel surface has already the surface profile as described above: New steel, "heavy duty use".</p>									
APPLICATION CONDITIONS:	<p>Use only where application and curing can proceed at temperatures above 10 °C/50 °F. The temperature of the paint itself should be above 15 °C/59 °F, preferably above 20 °C/68 °F for proper application. Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. Relative humidity max. 90%. In confined spaces provide adequate ventilation during application and drying.</p>									
PRECEDING COAT:	<p>None, but BAJAPOX 15590 can be used as a "blast primer"</p>									
SUBSEQUENT COAT:	<p>None, or as per specification, depending on area of use.</p>									
REMARKS:										
Weathering/SERVICE TEMPERATURES:	<p>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.</p>									
FILM THICKNESS:	<p>May be specified in another film thickness than indicated depending on purpose and area of use.</p> <p>This will alter spreading rate and may influence drying time and recoating interval. Normal range dry is 150-200 micron/6-8 mils.</p> <p>It is recommended to use heavy airless spray equipment with a pump transmission rate of 60:1 (approximately), and a theoretical output of min. 12 litres per minute.</p>									
Recoating :	<p>At 20 °C/68 °F surface temperature and good ventilation the following recoating intervals apply: (200 micron/8 mils dry film thickness of BAJAPOX MULTI-STRENGTH 45750A)</p> <table><thead><tr><th></th><th>Minimum</th><th>Maximum</th></tr></thead><tbody><tr><td>BAJAPOX:</td><td>6 hours</td><td>30 days</td></tr><tr><td>BAJATHANE:</td><td>6 hours</td><td>1 day*</td></tr></tbody></table>		Minimum	Maximum	BAJAPOX:	6 hours	30 days	BAJATHANE:	6 hours	1 day*
	Minimum	Maximum								
BAJAPOX:	6 hours	30 days								
BAJATHANE:	6 hours	1 day*								
	<p>*Optimal adhesion is obtained when BAJAPOX MULTI-STRENGTH 45750A is recoated while still tacky.</p> <p>The long maximum recoating interval for BAJAPOX will be reduced if the coating is more than just scarcely exposed to direct sunshine before recoating. If the interval is exceeded, roughening of surface is necessary to ensure intercoat adhesion. Do not store at temperatures above 45 °C/113 °F.</p> <p>Normally not to be diluted, but exceptionally 1-2% BAJAK'S THINNER 10845 may be used.</p>									
Note:	<p>BAJAPOX MULTI-STRENGTH 45750A is for professional use only.</p>									
Issued:	<p>Feb.2007</p>									



Product Data

BAJAPOX MULTI STRENGTH 45750

CURING AGENT 97650

- Description:** BAJAPOX MULTI STRENGTH 45750 is a self-priming, two-component, high-build, polyamide/amine cured epoxy paint which cures to an abrasion resistant coating with good resistance to seawater. Applicable by standard heavy duty airless spray equipment. Minimum curing temperature 10°C/50°F.
- Recommended use:** As a heavy duty coating for areas exposed to abrasion such as ramps, ship hulls and holds of bulk carriers.
As a ballast tank coating for special purposes such as chemical carriers carrying hot cargoes.
As a finishing coat where a cosmetic appearance is of less importance.
- Service temperatures:** Dry: Maximum 140°C/284°F (See REMARKS overleaf)
Ballast water service: Resists normal ambient temperatures at sea
Other water service: 50°C/140°F (no temperature gradient)
Other liquids: Contact BAJAK
*Avoid long-term exposure to negative temperature gradients.

PHYSICAL CONSTANTS:

- Colours:** Grey - Red
Finish: Semi-gloss
Volume Solids, %: 81 ± 1
Theoretical spreading rate: 4.1 m²/litre - 200 micron
162 sq.ft./US gallon - 8 mils
Flash point: 27°C/81°F
Specific gravity: 1.6 kg/litre - 13.4 lbs/US gallon
Dry to touch: 7-8 hours at 20°C/68°F
Fully cured: 7 days at 20°C/68°F
V.O.C.: 205 g/litre - 1.7 lbs/US gallon

APPLICATION DETAILS:

- Mixing ratio:** Base 45750 : Curing agent 97650
4 : 1 by volume
- Application method:** Airless spray
Brush (touch-up)
- Thinner (max.vol.):** 08450 (2%)
08450 (2%)
- Pot life:** 1 hour (20°C/68°F)
- Nozzle orifice:** .023"-.027"
- Nozzle pressure:** 250 bar/3600 psi
(Airless spray data are indicative and subject to adjustment)
- Cleaning of tools:** BAJAK'S TOOL CLEANER 99610
- Indicated film thickness, dry:** 200 micron/8 mils
- Indicated film thickness, wet:** 250 micron/10 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. 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.

- Issued:** Feb.2007

2- BAJAPOX MULTI-STRENGTH 45750

SURFACE PREPARATION: New steel, "heavy duty use": Abrasive blasting to min. Sa 2½. Grit-blasted surfaces: recommended profile is Rz minimum 100 micron maximum 150 micron, corresponding to ISO Comparator Coarse (G). Oil and grease must be removed with suitable detergent, salts and other contaminants by (high pressure) fresh water hosing prior to blasting. After blasting, clean the surface carefully from abrasive and dust. New steel, ballast tanks and similar areas: Abrasive blasting to Sa 2½. For temporary protection, if required, use a suitable shopprimer. Damage of shopprimer and contamination from storage and fabrication should be thoroughly cleaned prior to final painting. The best performance will be obtained by abrasive spot-blasting of welds, rusty spots, etc. and by abrasive sweep blasting of the intact shopprimer. For repair and touch-up use BAJAPOX MULTI-STRENGTH 45750. Stainless steel: (Ballast tanks in chemical carriers) to be abrasive blasted to a uniform, sharp, dense profile, ISO Comparator Medium (G), corresponding to Rz minimum 50 micron. Any salts, grease, oil, etc. to be removed before abrasive blasting is commenced. 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 (minor areas only). Feather edges to sound intact areas. Dust off residues. Touch-up to full film thickness. On old ship bottoms and similar pit corroded surfaces, excessive amounts of salt residues may call for dry abrasive blasting, high pressure fresh water hosing, drying, and finally, dry abrasive blasting again. Alternatively, water etting may be used provided the steel surface has already the surface profile as described above: New steel, "heavy duty use".

APPLICATION CONDITIONS: Use only where application and curing can proceed at temperatures above 10 °C/50 °F. The temperature of the paint itself should be above 15 °C/59 °F, preferably above 20 °C/68 °F for proper application. Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. Relative humidity max. 90%. In confined spaces provide adequate ventilation during application and drying.

PRECEDING COAT: None, but BAJAPOX 15590 can be used as a "blast primer"

SUBSEQUENT COAT: None, or as per specification, depending on area of use.

REMARKS:
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.

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 150-200 micron/6-8 mils.
It is recommended to use heavy airless spray equipment with a pump transmission rate of 60:1 (approximately), and a theoretical output of min. 12 litres per minute.

Recoating : At 20 °C/68 °F surface temperature and good ventilation the following recoating intervals apply:
(200 micron/8 mils dry film thickness of BAJAPOX MULTI-STRENGTH 45750)

	Minimum	Maximum
BAJAPOX:	6 hours	30 days
BAJATHANE:	6 hours	1 day

*Optimal adhesion is obtained when BAJAPOX MULTI-STRENGTH 45750 is recoated while still tacky.

The long maximum recoating interval for BAJAPOX will be reduced if the coating is more than just scarcely exposed to direct sunshine before recoating. If the interval is exceeded, roughening of surface is necessary to ensure intercoat adhesion. Do not store at temperatures above 45 °C/113 °F.

Normally not to be diluted, but exceptionally 1-2% BAJAK'S THINNER 08450 may be used.

Note: BAJAPOX MULTI-STRENGTH 45750 is for professional use only.

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Product Data

BAJAPOX HIGH-STRENGTH 45751/45753

Medium to high temperatures: BASE 45751 with CURING AGENT 97652
Low to medium temperatures: BASE 45753 with CURING AGENT 98750

Description:	BAJAPOX HIGH-STRENGTH 45751/45753 is a self-priming, two-component, high-build, epoxy-polyamide/amine paint which cures to an abrasion and corrosion resistant coating. Applicable by standard heavy duty airless spray equipment.	
Recommended use:	As a heavy duty coating for areas exposed to abrasion and aggressive corrosive climate such as ramps, ship hulls and holds of bulk carriers. As a ballast tank coating for special purposes such as chemical carriers carrying hot cargoes and other purposes where "pure epoxy coating" is requested. As a finishing coat where a cosmetic appearance is of less importance. BAJAPOX HIGH -STRENGTH 45751 is intended for use in warm climates. BAJAPOX HIGH-STRENGTH 45753 is intended for use in cold climates - see APPLICATION CONDITIONS overleaf.	
Service temperatures:	Dry:	Maximum 140°C/284°F (See REMARKS overleaf)
	Ballast water service:	Resists normal ambient temperatures at sea*
	Other water service:	50°C/140°F (no temperature gradient)
	Other liquids:	Contact BAJAK
	*Avoid long-term exposure to negative temperature gradients.	
PHYSICAL CONSTANTS:		
mixed product:	45751	45753
Colours:	Grey- Red	Grey- Red
Finish:	Semi-gloss	Semi-gloss
Volume solids, %:	79 ± 1	76 ± 1
Theoretical spreading rate:	4.0 m ² /litre-200 micron 158 sq.ft./US gallon - 8 mils	3.8 m ² /litre - 200 micron 152 sq.ft./US gallon - 8 mils
Flash point:	27°C/81°F	27°C/81°F
Specific gravity:	1.6 kg/litre-13.4 lbs/US gallon	1.6 kg/litre-13.4 lbs/US gallon
Dry to touch:	7-8 hours at 20°C/68°F	8-10 hours at 10°C/50°F
Fully cured:	7 days at 20°C/68°F	14 days at 10°C/50°F
V.O.C.:	255 g/litre-2.1 lbs/US gallon	240 g/litre-2.0 lbs/US gallon
APPLICATION DETAILS:		
Mixing ratio:	45751 Base 45751 : Curing agent 97652 3 : 1 by volume	45753 Base 45753 : Curing agent 98750 3 : 1 by volume
Application method:	Airless spray	
Thinner (max.vol.):	08450 (5%) (See PRECEDING COAT overleaf and separate APPLICATION INSTRUCTIONS)	
Pot life:	1 hour (20°C/68°F)	1 hour (20°C/68°F)
Nozzle orifice:	.021"- .023"	.021"- .023"
Nozzle pressure:	250 bar/3600 psi (Airless spray data are indicative and subject to adjustment)	250 bar/3600 psi
Cleaning of tools:	BAJAK'S TOOL CLEANER 99610	
Indicated film thickness, dry:	200 micron/8 mils	200 micron/8 mils
Indicated film thickness, wet:	250 micron/10 mils	275 micron/11 mils
Recoat interval, min:	6 hours (20°C/68°F)	12 hours (10°C/50°F)
Recoat interval, max:	See REMARKS overleaf	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. 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.	

BAJAPOX HIGH-STRENGTH 45751/45753

SURFACE PREPARATION:

New steel:

"Heavy duty use": Abrasive blasting to min. Sa 2½. Grit-blasted surfaces: recommended profile is Rz minimum 100 micron - maximum 150 micron, corresponding to ISO Comparator Coarse (G). Oil and grease must be removed with suitable detergent, salts and other contaminants by (high pressure) fresh water hosing prior to blasting. After blasting, clean the surface carefully from abrasive and dust.

Ballast tanks and similar areas: Abrasive blasting to Sa 2½. For temporary protection, if required, use a suitable shopprimer. Damage of shopprimer and contamination from storage and fabrication should be thoroughly cleaned prior to final painting. The best performance will be obtained by abrasive spot-blasting of welds, rusty spots, etc. and by abrasive sweep blasting of the intact shopprimer. For repair and touch-up use BAJAPOX HIGH-STRENGTH 45751/45753.

Stainless steel: (Ballast tanks in chemical carriers) to be abrasive blasted to a uniform, sharp, dense profile, ISO Comparator Medium (G), corresponding to Rz minimum 50 micron. Any salts, grease, oil, etc. to be removed before abrasive blasting is commenced.

Repair and maintenance:

The actual purpose and conditions may make other types and degrees of surface preparation than the above described relevant. Reference is made to separate application instructions.

APPLICATION CONDITIONS:

Use only where application and curing can proceed at temperatures above -10°C/14°F for BAJAPOX HIGH -STRENGTH 45753 and above 10°C/50°F for BAJAPOX HIGH-STRENGTH 45751. The temperature of the paint itself should be above 15°C/59°F, preferably above 20°C/68°F for BAJAPOX HIGH -STRENGTH 45751, for proper application. Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. Relative humidity max. 90%. In confined spaces provide adequate ventilation during application and drying.

PRECEDING COAT:

None, but BAJAPOX 15590 can be used as a "blast primer" for BAJAPOX HIGH -STRENGTH 45751. BAJAPOX HIGH -STRENGTH 45753 can be used as a "blast primer" for BAJAPOX HIGH-STRENGTH 45753 when diluted 15-25% with BAJAK'S THINNER 08450.

SUBSEQUENT COAT: REMARKS:
Colour of Curing Agent:

None, or BAJAPOX-paint as per specification, depending on area of use.

The curing agent 98750 has a tendency to become darker at storage. This has no influence on performance, but may influence the shade of the mixed product. Some certificates have been issued under the former quality numbers 45750 or 4575. BAJAPOX HIGH -STRENGTH 45751 is identical with the former 45750 except that mixing ratio and thixotropy properties have been adjusted to specific demands of application, for instance dual feed two component spray equipment and supply in 1000 litres paint containers.

Weathering/ service temperatures: Film thicknesses:

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.
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 150-250 micron/6-10 mils.
It is recommended to use heavy airless spray equipment with a pump transmission rate of 60:1 (approximately), and a theoretical output of min. 12 litres per minute.

Recoating:

Recoating intervals related to later conditions of exposure:
(200 micron/8 mils dry film thickness of BAJAPOX HIGH -STRENGTH 45751/457531

Curing agent 97652

Curing agent 98750

	Curing agent 97652						Curing agent 98750					
	Minimum			Maximum			Minimum			Maximum		
Surface temp	20°C/68°F						10°C/50°F					
Recoated with	Atmospheric		Immer- sion	Atmospheric		Immer- sion	Atmospheric		Immer- sion	Atmospheric		Immer- sion
	Medium	Severe		Medium	Severe		Medium	Severe		Medium	Severe	
BAJAPOX	4 hours	5 hours	6 hours	None	None	30 days	8 hours	10 hours	12hours	None	None	60 days
BAJATHANE Topcoat	4 hours	5 hours	N/R	10 days	3 days	N/R	8 hours	10 hours	N/R	20 days	6 days	N/R

Recoating:

The long maximum recoating interval for BAJAPOX will be reduced if the coating is more than just scarcely exposed to direct sunshine before recoating.
If the interval is exceeded, roughening of surface is necessary to ensure intercoat adhesion.
Thinning: Normally not to be diluted.

Note:

BAJAPOX HIGH -STRENGTH 45751/45753 is for professional use only.



Product Data

BAJAPOX MASTIC 45880 BAJAPOX MASTIC 45881

High temperatures: 45881 with CURING AGENT 95881
Low to medium temperatures: 45880 with CURING AGENT 95880

- Description:** BAJAPOX MASTIC 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:	Grey	Grey
Colours :	Semi-gloss	Semi-gloss
Finish:	80 ± 1	80 ± 1
Volume solids, %:	5.3 m ² /litre - 150 micron	5.3 m ² /litre - 150 micron
Theoretical spreading rate:	214 sq.ft./US gallon - 6 mils	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)	Depending on purpose usually less than 5% THINNER 08450 (See REMARKS overleaf)
Pot life:	1 hour (20°C/68°F)(Airless spray) 2 hours (20°C/68°F)(Brush)	1½ hour (30°C/86°F)(Airless spray) 2 hours (30°C/86°F)(Brush)
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.

BAJAPOX MASTIC 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 MASTIC 45880/45881. As an alternative to dry cleaning, water etting 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 etting, 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 MASTIC 45880 and above approx 25°C/77°F for BAJAPOX MASTIC 45881. The temperature of the paint itself should be 15°C/59°F or 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 MASTIC 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 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.
Film thicknesses / thinning:	<p>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.</p>
Application onto zinc silicate or spray-metallized surfaces: (thinning):	It is recommended to apply BAJAPOX MASTIC 45880 by using a "mist-coat" procedure provided the paint temperature is approximately above 20°C/68°F: A thin, undiluted coat is applied (the mist coat) and after a few minutes, a second coat is applied in the full specified film thickness. If the paint temperature is below 20°C/68°F, thinning (max 15%) may be required.
Note:	BAJAPOX MASTIC 45880/45881 is for professional use only.



APPLICATION INSTRUCTIONS

For product description refer to the product data sheet

BAJAPOX MASTIC 45880 BAJAPOX MASTIC 45881

High temperatures: 45881 with CURING AGENT 95881
Low to medium temperatures: 45880 with CURING AGENT 95880

Scope:

These Application Instructions cover surface preparation, application equipment and application details for BAJAPOX MASTIC 45880/45881.

Surface preparation:

General: In order to obtain best performance, abrasive blast cleaning is recommended. However, BAJAPOX MASTIC 45880/45881 has "surface tolerant" properties and offers higher performance than many other coatings when applied to surfaces mechanically cleaned only (salts, oil, grease etc. Shall always be removed) where only mechanical cleaning and dust removal can be carried out (beside the removal of salts and of oily contaminants).

Remove oil and grease with suitable detergent, salt and other contaminants by (high pressure) fresh water cleaning.

NEW STEEL:

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

When applied to ZINC SILS:

BAJAPOX MASTIC 45880/45881 can be applied when the ZINC SIL is cured. Consult APPLICATION INSTRUCTIONS for the relevant ZINC SIL. Remove oil and grease etc. with suitable detergent. Remove salt and other contaminants by high pressure fresh water cleaning. After exposure to high humidity, zinc salts, "white rust", must be removed carefully by high pressure fresh water cleaning, if necessary combined with scrubbing with stiff nylon brushes.

REPAIR AND MAINTENANCE :**Spot-repairs:**

Clean damaged areas thoroughly by power tool cleaning to minimum St 2 (spot-repairs) or by abrasive blasting to minimum Sa 2, preferably Sa 2½. Improved surface preparation will improve the performance of BAJAPOX MASTIC 45880/45881. As an alternative to dry cleaning, water jetting to minimum WJ-2 (NACE No. 5/SSPC-SP12), may be used.

Feather edges to sound and intact areas. Brush off loose material.
Touch up to full film thickness.

Compatibility: BAJAPOX MASTIC 45880/45881 may be used in connection with other generic paint systems than epoxy and polyurethanes.

It is recommended to make a test patch. In any case it is a must that the old paint system is tightly adhering and is properly prepared before the touch-up is performed.

BAJAPOX MASTIC 45880/45881

Full coating:

Compatibility with old system: In general full compatibility can be expected with old epoxy systems. A test patch should always be performed before fullcoating is decided. If the old epoxy is not weathered/chalked or if it is topcoated with polyurethane, it is recommended to roughen the surface before recoating. Furthermore, very thorough cleaning is a must. Any dirt, chalked surface material, oil and grease should be removed with suitable detergent followed by high pressure fresh water hosing of the entire surface.

Removal of old system: Full coating after complete mechanical removal of an old paint system is possible too. Yet, it must be considered that mechanical cleaning by disc grinding or by rotating wire brushing may produce a very smooth surface giving reason to reduced adhesive forces.

Note: Another risk is left over of a hard black rustscale being cleaned to an apparent brightness without showing any adhesive defects. Yet, the exposure to open air during cleaning may have started a continuous oxidation of the hard black rust making it mechanically weak and of poor adhesion to the underlying steel surface. Later, during service, the scale plus overlaying paintmaterial may flake off.

Note: On old steel surfaces having been exposed to salt water, excessive amounts of salt residues in pittings may call for high pressure water etting, wet abrasive blasting, alternatively dry abrasive blasting, high pressure fresh water hosing, drying, and finally, dry abrasive blasting again.

Application equipment:

BAJAPOX MASTIC 45880/45881 being a high solids and a relatively high viscosity material, may require special measures to be taken at application.

Recommended airless spray equipment:

Pump ratio:	min. 45:1
Pump output:	12 litres/minute (theoretical)
Input pressure:	min. 6 bar/90 psi
Spray hoses:	max. 100 metres/300 feet, 1/2" internal diameter max. 30 metres/100 feet, 3/8" internal diameter max. 6 metres/20 feet, 1/4" internal diameter

Regular surfaces:	
Nozzle size:	.021" through .023"
Fan angle:	60°.

Complicated surfaces (and touch up):	
Nozzle size:	.017" through .021"
Fan angle:	40°.

After finishing the application, clean the equipment immediately with THINNER 08450 or BAJAK'S TOOL CLEANER 99610.

Note: Increasing hose diameter may increase paint flow, thereby improving the spray fan. If longer hoses are necessary it may be necessary to raise the pump ratio to 60:1, maintaining the high output capacity of the pump.

Alternatively up to approx. 5% THINNER 08450 may be added, but thinning must be done with care as the anti-sagging properties are drastically reduced by overthinning.

Airless spray data are indicative and subject to adjustment.

Induction time:

In case of a paint temperature at 15°C/59°F or below, it is an advantage to allow the two components to pre-react before application. This is especially relevant in the case of substrate temperatures below 15°C/59°F.

Product Data



BAJAPOX MASTIC 45880/45881

In case of a paint temperature at 15°C/59°F, an induction time of 15 minutes is recommended. In case of a paint temperature at 10°C/50°F, an induction time of 25 minutes is recommended. In order to obtain proper application properties, the paint temperature should preferably never be below 10°C/50°F.

Application:

Film-build/continuity: With this paint material applied in one/few coat(s) it is of special importance that a continuous, pinhole-free paint film is obtained at application of each coat. An application technique which will ensure good film formation on **all** surfaces must be adopted. It is very important to use nozzles of the correct size, not too big, and to have a proper, uniform distance of the spray gun to the surface, 30-50 cm should be aimed at. Furthermore, great care must be taken to cover edges, openings, rear sides of stiffeners etc. Thus, on these areas application of a **stripecoat** will therefore be good painting practice. To obtain good and steady atomizing, the viscosity of the paint must be suitable and the spray equipment must be sufficient in output pressure and capacity. At high working temperatures, use of extra thinner may be necessary to avoid dust-spray.

The paint layer must be applied homogeneously and as close to the specification as possible. Avoid exaggerated film thickness due to the risk of sagging, cracks and solvent retention. The paint consumption must be controlled.

The finished coating must appear as a homogeneous film with a smooth surface and irregularities such as dust, dry spray, abrasives, should be remedied.

On **poorly prepared surfaces** it is always recommended to apply the first coat by brush. Extra thinning will facilitate the penetration of the paint material, but will also require an extra layer to be applied.

Wet/dry film thickness:

Please note that the thixotropic nature of BAJAPOX MASTIC 45880/45881 may give a rather "wavy" surface of the paint just after application. This smoothens at drying, but can make it necessary to let the wet film readings be of a higher value than indicated. In many cases the wet film thickness, reading should be 25-50 micron/1-2 mils higher than calculated. As the wavy surface becomes more smooth during drying these extra wet film thickness readings will not cause a higher paint consumption than otherwise stipulated.

Film thickness/thinning:

BAJAPOX MASTIC 45880/45881 is normally specified in 125-200 micron/5-8 mils. Depending on ambient conditions, usually maximum 5% thinning with THINNER 08450 is relevant, however, increasing at high temperatures. May be specified down to 75 micron/3 mils. To obtain optimum film formation in film thicknesses lower than 125 micron/5 mils dry film thickness additional thinning with 5-10% THINNER 08450 is recommended.

Pot life:

When measured under standard conditions the pot life is 1 hour at 20°C/68°F for BAJAPOX MASTIC 45880 respectively 1½ hours at 30°C/86°F for BAJAPOX MASTIC 45881. However, for a 20 litres/5 US gallons mix, and used under warm climate conditions, the heat developed by the chemical reaction between BASE and CURING AGENT may make the corresponding practical pot life shorter. Therefore: At high temperatures, use the paint immediately after mixing irrespective of equipment.

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.

Attached:

Tables of "physical data versus temperature"

BAJAPOX MASTIC 45880/45881

**Physical data
versus temperature:**

Drying time and recoating interval vary with film thickness, temperature and later exposure conditions:

BAJAPOX MASTIC 45880 in a dry film thickness of **100-150 micron/4-6 mil s**:

Surface temperature:	-10°C/14°F	-5°C/23°F	0°C/32°F	10°C/50°F	20°C/68°F	30°C/86°F
Drying time (approx)	6 days	3 days	24 hours	10 hours	4 hours	3 hours
Curing time (approx)	5 months	2½ months	1 month	14 days	7 days	5 days
MINIMUM recoating interval related to later conditions of exposure:						
Interval for recoating with BAJAPOX and BAJATHANE qualities						
Atmospheric, medium	8 days	4 days	30 hours	12 hours	5 hours	4 hours
Atmospheric, severe	12 days	6 days	42 hours	18 hours	7 hours	5 hours
Interval for recoating with BAJATEX qualities						
Atmospheric, Medium or severe	8 days	4 days	30 hours	12 hours	5 hours	4 hours
Interval for recoating with BAJAPOX topcoats						
Surface temperature:	10°C/50°F	15°C/59°F	20°C/68°F	30°C/86°F		
Atmospheric, medium	12 hours	8 hours	5 hours	4 hours		
Atmospheric, severe	18 hours	12 hours	7 hours	5 hours		

Notes:

- Avoid sudden drops in (substrate) temperatures during drying/initial curing. It is especially important that the substrate temperature does not drop significantly before application of the acrylic or polyurethane finish and that proper ventilation is maintained.
- If faster handling or recoating at lower temperatures is required, BAJAPOX 45143 may be used.
- In case of low temperatures, it is recommended that BAJAPOX MASTIC 45880 has been given a proper induction time before application. Consider paint temperature equal to substrate temperature and follow the rules given on page 2.

BAJAPOX MASTIC 45880 in a dry film thickness of **200 micron/8 mil s**:

Surface temperature:	-10°C/14°F	-5°C/23°F	0°C/32°F	10°C/50°F	20°C/68°F	30°C/86°F
Drying time (approx)	12 days	6 days	36 hours	15 hours	6 hours	4½ hours
Curing time (approx)	5 months	2½ months	1 month	14 days	7 days	5 days
MINIMUM recoating interval related to later conditions of exposure:						
Interval for recoating with BAJAPOX and BAJATHANE qualities						
Atmospheric, medium	10 days	5 days	42 hours	18 hours	7 hours	5 hours
Atmospheric, severe	14 days	7 days	60 hours	25 hours	10 hours	8 hours
Interval for recoating with BAJATEX qualities						
Atmospheric, Medium or severe	10 days	5 days	42 hours	18 hours	7 hours	5 hours
MINIMUM Interval for recoating with BAJAPOX topcoats						
Surface temperature:	10°C/50°F	15°C/59°F	20°C/68°F	30°C/86°F		
Atmospheric, medium	18 hours	12 hours	7 hours	5 hours		
Atmospheric, severe	25 hours	17 hours	10 hours	8 hours		

Notes:

- Avoid sudden drops in (substrate) temperatures during drying/initial curing. It is especially important that the substrate temperature does not drop significantly before application of the acrylic or polyurethane finish and that proper ventilation is maintained.
- If faster handling or recoating at lower temperatures is required, BAJAPOX 45143 may be used.
- In case of low temperatures, it is recommended that BAJAPOX MASTIC 45880 has been given a proper induction time before application. Consider paint temperature equal to substrate temperature and follow the rules given on page 2.



Product Data

BAJAPOX MASTIC 45880/45881

MAXIMUM recoating intervals of BAJAPOX MASTIC 45880 (independent on dry film thickness):

Surface temperature:	-10°C/14°F	-5°C/23°F	0°C/32°F	10°C/50°F	20°C/68°F	30°C/86°F
MAXIMUM recoating interval related to later conditions of exposure						
Interval for recoating with BAJAPOX qualities						
Atmospheric, medium	None	None	None	None	None	None
Atmospheric, severe						
Interval for recoating with BAJATHANE topcoats						
Atmospheric, medium	4 months	3 months	2 months	4 weeks	21 days	14 days
Atmospheric, severe	4 weeks	21 days	14 days	6 days	3 days	2 days
Interval for recoating with BAJATEX qualities						
Atmospheric, Medium or severe	20 days	10 days	72 hours	30 hours	12 hours	9 hours
MINIMUM interval for recoating with BAJAPOX topcoats						
Surface temperature:	10°C/50°F	15°C/59°F	20°C/68°F	30°C/86°F		
Atmospheric, medium	6 days	4 days	3 days	2 days		
Atmospheric, severe	3 days	2 days	1½ day	1 day		

BAJAPOX MASTIC 45881 in a dry film thickness of 100-150 micron/4-6 mils:

Surface temperature:	20°C/68°F	30°C/86°F	40°C/104°F
Drying time (approx)	4 hours	3 hours	2 hours
Curing time (approx)	7 days	5 days	3 days
MINIMUM recoating interval related to later conditions of exposure:			
Interval for recoating with BAJAPOX, BAJATHANE and BAJATEX qualities			
Atmospheric, medium	5 hours	4 hours	3 hours
Atmospheric, severe	7 hours	5 hours	4 hours

- 1) Avoid sudden drops in (substrate) temperatures during drying/initial curing.
- 2) If faster handling is required at lower temperatures, BAJAPOX 45143 may be used.

BAJAPOX MASTIC 45881 in a dry film thickness of 200 micron/8 mils:

Surface temperature:	20°C/68°F	30°C/86°F	40°C/104°F
Drying time (approx)	6 hours	5 hours	4 hours
Curing time (approx)	7 days	5 days	3 days
MINIMUM recoating interval related to later conditions of exposure:			
Interval for recoating with BAJAPOX, BAJATHANE and BAJATEX qualities			
Atmospheric, medium	7 hours	5 hours	4 hours
Atmospheric, severe	10 hours	8 hours	6 hours

MAXIMUM recoating intervals of BAJAPOX MASTIC 45881 (independent on dry film thickness):

Surface temperature:	20°C/68°F	30°C/86°F	40°C/104°F
MAXIMUM recoating interval related to later conditions of exposure			
Interval for recoating with BAJAPOX qualities			
Atmospheric, medium	None	None	None
Atmospheric, severe	None	None	None
Interval for recoating with BAJATHANE topcoats			
Atmospheric, medium	21 days	14 days	7 days
Atmospheric, severe	3 days	2 days	1 day
Interval for recoating with BAJATEX qualities			
Atmospheric	12 hours	9 hours	6 hours

BAJAPOX MASTIC 45880/45881

Specific Notes for overcoating with BAJATHANE Topcoats:

- i) Depending on actual local conditions, extended maximum recoating intervals may apply. Please contact BAJAK for further advice.
- ii) The MIO version, colour no. 12430, may provide extended recoating properties if BAJAPOX MASTIC 45880/45881 in shade 12430 is applied **In a film thickness that allows a MIO structure to develop**. This is typically achieved in a dry film thickness range of 50-100 micron/2-4 mils for which reason further thinning is relevant. Reference is made to page 3.

Prior to application of BAJATHANEs it is mandatory to clean the surface thoroughly to ensure that any contamination in the rough MIO surface structure is removed.

To determine whether the quality of the surface cleaning is adequate, a test patch may be relevant. However, such a test is not the final proof of long-term durability, but if the result is doubtful, repeated cleaning will be relevant. A more safe solution could be to refresh the surface with a new thin (diluted) coat of BAJAPOX MASTIC 45880/45881.

The MIO concept is typically for use as a "travel coat" within industrial objects.

The dark shade of the MIO pigment should be taken into account when selecting subsequent shades.

For typical marine coatings, prolonged overcoating intervals can be obtained by using BAJAPOX 45080/45083 as a preceding coat.

General notes on prolonged recoating intervals:

Besides the notes stated under the tables for minimum recoating intervals, the following applies:

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 determine whether the quality of the surface cleaning is adequate, a test patch may be relevant, however, this test patch should not be a final proof of the durability of the coating.



Product Data

BAJATEX HI-BUILD 46410

Description:

BAJATEX HI-BUILD 46410 is a physically drying high build paint with good colour retention as a semi-flat finish. Based on acrylic resin, alkyd and non-chlorinated plasticizer. Contains zinc phosphate. Resistant to salt water, splashes of aliphatic hydrocarbons, animal and vegetable oils.

Recommended use:

1. As a primer, intermediate or finishing coat in BAJATEX-systems in moderately corrosive environment.
2. As a selfprimed repair and touch-up coating for containers as well as other cases where a fast and economic repair job is desired.
3. As a finishing coat for containers.

Service temperatures:

Maximum, dry: 80°C/176°F (See REMARKS overleaf).

PHYSICAL CONSTANTS:

Colours :	Grey - Red
Finish:	Semi-flat
Volume solids, %:	42 ± 1
Theoretical spreading rate:	4.2 m ² /litre - 100 micron 168 sq.ft./US gallon - 4 mils
Flash point:	24°C/75°F
Specific gravity:	1.2 kg/litre - 10.0 lbs/US gallon
Surface dry:	1 (approx.) hrs at 20°C/68°F (ISO 1517)
Dry to touch:	4 (approx.) hours at 20°C/68°F
V.O.C.:	515 g/litre - 4.3 lbs/US gallon

APPLICATION DETAILS:

Application method:	Airless spray	Air spray	Brush/Roller
Thinner (max. vol.):	08080 (5%)	08080 (15%)	08080 (5%)
Nozzle orifice:	.017"-.021"		
Nozzle pressure:	175 bar/2500 psi (Airless spray data are indicative and subject to adjustment)		
Cleaning of tools:	THINNER 08080		
Indicated film thickness, dry:	100 micron/4 mils (See REMARKS overleaf)		
Indicated film thickness, wet:	225 micron/9 mils		
Recoat interval, min:	When dry (See REMARKS overleaf)		
Recoat interval, max:	None (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.

BAJATEX HI-BUILD 46410

SURFACE PREPARATION:	<p>New steel: Remove oil and grease etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. 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 BAJATEX HI-BUILD 46410.</p> <p>Repair and maintenance: Remove oil and grease etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. Remove all rust and loose material by abrasive blasting or power tool cleaning. Dust off residues. Touch up bare spots with BAJATEX HI-BUILD 46410 to full film thickness.</p>
APPLICATION CONDITIONS:	<p>As dictated by normal good painting practice.</p> <p>In confined spaces provide adequate ventilation during application and drying.</p>
PRECEDING COAT:	None, or according to specification.
SUBSEQUENT COAT:	None, or as per specification.
REMARKS:	
Colours:	Certain lead-free red and yellow colours may discolour when exposed to sulphide and chlorine-containing atmosphere.
Service temperatures:	As BAJATEX HI-BUILD 46410 is a thermoplastic product, prolonged, mechanical exposure at temperatures above approx. 40°C/104°F may cause film indentation. When temperature drops below, mechanical strength is recovered.
Film thicknesses:	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 is 75-125 micron/3-5 mils. To obtain an even dry film thickness (of 125 micron), application in two passes (wet-in-wet) is recommended. If applied by roller, e.g. as deckcoating, usual dry film thickness is approx. 50 microns per coat. A series of maintenance jobs may result in build up of a too high total film thickness which may cause blister formation due to "entrapped" solvents. As each coat may also retain solvents, it is generally recommended not to apply BAJATEX HI-BUILD 46410 in excessive film thickness.
Deck coating:	If a skid-proof surface is desired, sprinkle BAJAK'S ANTI-SKID 67500 evenly on the first coat of BAJATEX HI-BUILD 46410 while still wet (consumption approx. 2.5 kg/5.5 lbs to 25 m ² /270 sq.ft.). When the paint is dry, sweep up surplus grit and apply a second coat of BAJATEX HI-BUILD 46410. Antiskid properties can also be obtained by mixing 1.0 kg of BAJAK'S ANTISKID BEADS 67420 into 20 litre of BAJATEX HI-BUILD 46410.
Recoating:	For multicoat application minimum recoating interval is influenced by the actual film thickness and number of coats applied. Reference is made to the corresponding painting specification. No maximum recoating interval, but before recoating after exposure in contaminated environment, clean the surface thoroughly by high pressure fresh water hosing and allow to dry.
Note:	BAJATEX HI-BUILD 46410 is for professional use only.

**BAJAK'S SILTEX SMOOTH 46600**

Special product Data Sheet

Description:	BAJAK'S SILTEX SMOOTH 46600 is a physically drying paint based on modified acrylic resin with optimum color retention. It is a water-repellant, anti-carbonation coating with a carbon dioxide diffusion resistance of 6000 Gpa.s.m ² /kg . when applied in the SILTEX Coating System in two coats as described under REMARKS (see overleaf) . The SILTEX System also provides protection against chloride intrusion.
Recommended use:	<ol style="list-style-type: none"> 1. As an exterior finishing coat in SILTEX Coating Systems for protection of reinforced concrete structures, plaster, brick work and similar substrates. 2. As an exterior intermediate coating in Siltex textured coating systems for protection of reinforced concrete structures, plaster, brick work and similar substrates.
Service temperatures:	Dry :
periodical , maximum :	60 ° C / 140 ° F
Peak, maximum :	80 ° C / 176 ° F

PHYSICAL CONSTANTS:

Colours:	White (other shades according to assortment list)
Finish:	Flat
Volume Solids, %:	36%
Theoretical spreading rate:	7.2 m ² /litre – 50 micron 289 sq.ft/US gallon – 2 mils
Flash point:	23°C/73°F
Specific gravity:	1.3 kg/litre 10.8 lbs/US gallon
	Surface dry : ½ (approx.) hour at 20°C/68°F (ISO 1517)
Dry to touch:	2 (approx.) hour at 20°C/68°F
V.O.C. :	566 g/litre – 4.7 lbs / US gallon

APPLICATION DETAILS:

Application method:	Airless spray	Air spray	Brush / Roller
Thinner (max.vol.):	08080 (5%)	08080 (15%)	08080 (5%)
Nozzle orifice:	.025"- .027"		
Nozzle pressure:	100 bar/1450 psi (Airless spray data are indicative and subject to adjustment)		
Cleaning of tools:	THINNER 08080		
Indicated film thickness, dry:	50 micron/2 mils (see REMARKS overleaf)		
Indicated film thickness, wet:	125 micron/5 mils		
Recoat interval, min:	2 hours (20°C/68°F)		
Recoat interval, max:	None (See REMARKS overleaf)		

2- BAJAK'S SILTEX SMOOTH 46600

SURFACE PREPARATION: **Repair and maintenance** : Remove damaged and loose paint by mechanical cleaning and dust off. Seal bare substrates with BAJAK'S SILTEX SEALER 26600 and touch up to full film thickness with BAJAK'S SILTEX SMOOTH 46600 .

APPLICATION CONDITIONS: As dictated by normal good painting s practice. Surface temperatures over the dew point, preferably more than 3°C/5°F .
In confined spaces, provide adequate ventilation during application and drying. Relative humidity (RH) below 85% .

PRECEDING COAT: BAJAK'S SILTEX SEALER 26600 .
SUBSEQUENT COAT: BAJAK'S SILTEX SMOOTH 46600, BAJAK'S SILTEX FINE 5661 or BAJAK'S SILTEX MEDIUM 5662 according to specification.

REMARKS:
Carbon dioxide and water resistance : In a total dry film thickness of minimum 100 micron / 4 mils, 2 coats, BAJAK'S SILTEX SMOOTH 46600 has a carbon dioxide diffusion resistance, ZCO₂, of 6000 Gpa x s x m²/kg, a water vapour diffusion resistance, ZH₂O, of 11 Gpa x s x m²/kg, and a water repellency of more than 97% .

Film thickness : May be specified in another film thickness than indicated depending on purpose and area of use. Minimum total dry film thickness is 100 micron/4 mils. Application in higher film thicknesses than indicated will alter spreading rate and may influence drying time and recoat interval. Furthermore, another film thickness than indicated will influence ZCO₂, ZH₂O and water repellancy. For multi-coat application, the actual film thickness and the number of coats applied influence the minimum recoat interval. Reference is made to the corresponding painting specification.

Recoating : No maximum recoat interval, but before over coating after exposure in contaminated environment, clean the surface thoroughly by high pressure fresh water hosing and allow to dry.

Coating system :	BAJAK'S SILTEX SEALER 26600	BAJAK'S SILTEX SMOOTH 46600	BAJAK'S SILTEX SMOOTH 46600
	Sealing	min. 50 micron	min. 50 micron

Note: **BAJAK'S SILTEX SMOOTH 46600 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.

BAJALIN® ENAMEL 51510

- Description:** BAJALIN ENAMEL51510 is a flat alkyd enamel which forms a weather resistant coating. It is flexible and resistant to salt water and spillage of mineral oil and other aliphatic hydrocarbons.
- Recommended use:** As a general purpose finishing coat in alkyd systems on exterior and interior steel and woodwork in mildly to moderately corrosive environment.
As a finishing coat in engine rooms including tank tops, main engines and auxiliary machinery.
- Service temperatures:** Maximum, dry: 100°C (these temperatures may cause yellowing/discoloration).
- Availability:** Part of Group Assortment. Local availability subject to confirmation.

PHYSICAL CONSTANTS:

Colours/Shade nos:	White/9034	Black /7035*
Finish:	Flat	Flat
Volume solids,%	55 ± 1	55 ± 1
Theoretical spreading rate:	10 m ² /litre - 55 micron	10 m ² /litre - 55 micron
Flash point:	38°C	38°C
Specific gravity:	1.6 kg/litre	1.45 kg/litre
Surface dry:	2½ (approx) hrs at 20°C (ISO 1517)	2½ (approx) hrs at 20°C (ISO 1517)
Dry to touch:	6-8 hours at 20°C	6-8 hours at 20°C
V.O.C.:	420 g/litre	412 g/litre

APPLICATION DETAILS:

Application method:	Airless spray	Air spray	Brush/Roller
Thinner (max.vol.):	S8013 (5%)	S8013 (15%)	S8013 (5%) (See REMARKS overleaf)
Nozzle orifice:	.018"		
Nozzle pressure:	150 bar/2200 psi		
	<i>(Airless spray data are indicative and subject to adjustment)</i>		
Cleaning of tools:	THINNER 08230		
Indicated film thickness, dry:	55 micron/2.2 mils		
Indicated film thickness, wet:	100 micron/4 mils		
Recoat interval, min:	8 hours (20°C/68°F)		
Recoat interval, max:	See REMARKS overleaf		

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BAJALIN ENAMEL 51510

APPLICATION CONDITIONS: As dictated by normal good painting practice.
In confined spaces provide adequate ventilation during application and drying.

PRECEDING COAT: BAJALIN PRIMER 11210 for steel and BJAPOX SEALER 23020 for concrete or according to specification.

SUBSEQUENT COAT: None,
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.

Film thicknesses: May be specified in other film thicknesses than indicated depending on purpose and area of use. This will alter spreading rate and may influence drying time and recoat interval. Normal range 30-40 micron/1.2-1.6 mils.

Thinning: THINNER S8013 may be used for spray application, however, with a certain risk of wrinkling of the preceding fresh coat of BAJALIN.

Recoating: Recoat intervals related to later conditions of exposure:
(55 micron/2.2 mils dry film thickness of BAJALIN ENAMEL 51510)

	Minimum		Maximum	
SURFACE TEMPERATURE	20°C		20°C	
	Atmospheric		Atmospheric	
Recoated with (quality numbers only)	Mild	Medium	Mild	Medium
53510	8hour	8 hours	None	7 days

If the maximum recoat interval is exceeded, roughening of the surface is recommended to ensure intercoat adhesion.
Before recoating after exposure in contaminated environment, clean the surface thoroughly by (high pressure) fresh water hosing and allow drying.

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.

Note: **BAJALIN ENAMEL 51510 is for professional use only.**

This Product Data Sheet supersedes those previously issued. For definition and scope, see explanatory notes to applicable Product Data Sheets. Data, specifications, directions and recommendations given in this data sheet represent only test results or experience obtained under controlled or specially defined circumstances. Their accuracy, completeness or appropriateness under the actual conditions of any intended use of the Products herein must be determined exclusively by the Buyer and/or User. The Products are supplied and all technical assistance is given subject to BAJAK's GENERAL CONDITIONS OF SALES, DELIVERY AND SERVICE, unless otherwise expressly agreed in writing. The Manufacturer and Seller disclaim, and Buyer and/or User waive all claims involving, any liability, including but not limited to negligence, except as expressed in said GENERAL CONDITIONS for all results, injury or direct or consequential losses or damages arising from the use of the Products as recommended above, on the overleaf or otherwise. Product data are subject to change without notice and become void five years from the date of issue.

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BAJATHANE * TOPCOAT 51551

CURING AGENT 61050

Description: BAJATHANE TOPCOAT 51551 is a two-component, flat aliphatic acrylic polyurethane coating with good color retention and abrasion resistance.

Recommended use: As a finishing coat for protection of structural steel in severely corrosive environment, where light-fastness and gloss retention are required.
Minimum temperature for curing is -10 °C /14°F.

Service temperatures: Maximum, Dry: 120°C/248°F(see REMARKS overleaf).

Approvals:

Availability: Subject to confirmation.

PHYSICAL CONSTANTS:

Colours/Shade nos: white/10000*
Finish: Flat
Volume Solids, %: 52
Theoretical spreading rate: 10.4 m²/litre - 50 micron
417 sq.ft./US gallon- 2 mils
Flash point: 31°C/88°F
Specific gravity: 1.4 – 1.5 kg/litre (According To Shade)
Surface dry: 2.½(approx.) hrs at 20°C/68°F (ISO 1517)
Dry to touch: 8 (approx.) hours at 20°C/68°F
Fully cured: 7 days at 20°C/68°F
V.O.C.: 445 g/litre - 3.7 lbs/US gallon

* other shades according to assortment list .

APPLICATION DETAILS:

Mixing ratio for 51551: Base 51551 : Curing agent 61050
8 : 1 by weight

Application method:	Airless spray	Brush	Roller
Thinner (max.vol.):	See REMARKS overleaf	08080 (5%)	08080 (15%)
Pot life:	4 hours (20°C/68°F)		
Nozzle orifice:	.017"-.019"		
Nozzle pressure:	150 bar/2200 psi (Airless spray data are indicative and subject to adjustment)		
Cleaning of tools:	THINNER 08080 OR 08510		
Indicated film thickness, dry:	50 micron/2 mils		
Indicated film thickness, wet:	100 micron/4 mils		
Recoat interval, min:	See REMARKS overleaf		
Recoat interval, max:	See REMARKS overleaf		

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2. BAJATHANE TOPCOAT 51551

APPLICATION AND CURING CONDITIONS: The surface must be completely clean and dry at the time of application, and its temperature must be above the dew point to avoid condensation. Minimum temperature of curing is $-10^{\circ}\text{C}/14^{\circ}\text{F}$. at the freezing point and below, be aware of the risk of ice on the surface which will hinder the adhesion. High humidity and/or condensation during application and the following 16 hours ($20^{\circ}\text{C}/68^{\circ}\text{F}$) may adversely affect the film formation. In confined spaces provide adequate ventilation during application and drying.

PRECEDING COAT: BAJAPOX HI-BUILD 45200, BAJAPOX 45141, BAJAPOX 45230 or according to specification.

SUBSEQUENT COAT: None.

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

SERVICE TEMPERATUR: At service temperature above $100^{\circ}\text{C}/212^{\circ}\text{F}$), slight discoloration may be expected.

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 is 40-60 micron/1.6-2.4 mils.

Thinning: The type and amount of thinner depend on application conditions, application method, temperature, ventilation, and substrate. THINNER 08080 is recommended in general. THINNER 08510 may be used alternatively depending on local condition.
Airless spray: 5-15% thinning is recommended. Under extreme conditions up to more than 20% may be necessary to obtain satisfactory film formation. The best result is obtained by applying a mist coat of BAJATHANE ENAMEL 51551 at first, and then 2-15 minutes later apply to full film thickness giving a uniform film formation. Do not exaggerate the film thickness.

Recoating And drying/curing time:

Physical data versus temperatures:						
SURFACE TEMPERATURE		$-10^{\circ}\text{C}/14^{\circ}\text{F}$	$0^{\circ}\text{C}/32^{\circ}\text{F}$	$10^{\circ}\text{C}/50^{\circ}\text{F}$	$20^{\circ}\text{C}/68^{\circ}\text{F}$	$30^{\circ}\text{C}/86^{\circ}\text{F}$
Dry to touch, approx.		3 days	36 hours	16 hours	8 hours	6 hours
Resist condensing humidity/ light showers after*:		7 days	3 days	32 days	16 hours	12 hours
Fully cured, 70% RH		2 months	32 days	14 days	7 days	5 days
Recoating interval, Recoating 51551 with polyurethane	Min	6 days	3 days	32 hours	16 hours	12 hours
	Max	None	None	None	None	None

*Faster drying and curing may be obtained by using an "accelerator" – consult BAJAK for further advice.

A completely clean surface is mandatory to ensure intercoat adhesion, especially at long recoating intervals. Any dirt, oil, and grease has to be removed, e.g. with suitable detergent.

Salts to be removed by fresh water hosing. To check an adequate quality of the surface cleaning a test patch is recommended before actual recoating.

Note: CURING AGENT 61050 is sensitive to moisture. Store in dry place and keep the can tightly closed until use. Open curing agent cans with caution as overpressure might exist. Even small traces of water in the mixed paint will reduce the pot-life and result in film defects.
BAJATHANE TOPCOAT 51551 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.

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BAJAK'S POLYESTER HR 51585

Description:	BAJAK'S POLYESTER HR 51585 is a heat resistant polyester modified melamine paint. It is baking paint.
Recommended use:	For long-term protection of hot pipelines, exhaust pipes, smoke stacks and other hot surfaces up to 300 °C / 572 °F for aluminum color and 200°C/390°F for other colors , resist short time exposure up to 400°C/752°F for aluminum color and 300 °C / 572 °F for other colors. When heated to above 200°C/390°F for longer periods a certain discoloration may occur, which do not affect the protective properties of the product. In corrosive environment see PRECEDING COAT overleaf.
Service temperature:	Maximum, dry: 300°C/572°F for aluminum color and 200°C/390°F °F for other colors.

PHYSICAL CONSTANTS:

Mixed product:	51585
Colours/Shade no:	Black/7035
Finish:	Semi-flat (see REMARKS overleaf)
Volume Solids, %:	38 ± 1
Theoretical spreading rate:	11.9 m ² /litre – 25 micron
Flash point:	25°C/77°F
Specific gravity:	1.15 kg/liter
Curing Temp.:	160°C/320°F
Curing Time:	20 Min.
V.O.C.:	605 g/liter

APPLICATION DETAILS:

Application method:	Airless spray	Air spray	Brush
Thinner (max. vol.):	08080 (15%) (See REMARKS overleaf)	08080 (25%)	08080 (15%)
Nozzle orifice:	.017"		
Nozzle pressure:	125 bar (Airless spray data are indicative and subject to adjustment)		
Cleaning of tools:	THINNER 08080		
Indicative dft:	25 micron/1 mil (See REMARKS overleaf)		
Indicative wft:	65 micron/2.6 mils		
Recoat interval, min:	-		
Recoat interval, max:	-		

2. BAJAK'S POLYESTER HR 51585

SURFACE PREPARATION:	Remove oil and grease etc. thoroughly with suitable detergent. Remove salts and contaminants by high pressure fresh water cleaning.
APPLICATION CONDITIONS:	Clean and dry surface with a temperature above dew point to avoid condensation. In confined spaces provide adequate ventilation during application and drying.
PRECEDING COAT:	None.
SUBSEQUENT COAT:	None.
REMARKS:	
Gloss:	After exposure to heat the gloss is reduced.
Thermo plasticity:	The paint film is somewhat thermoplastic also after heating.
Film thicknesses:	It is recommended to avoid too high thicknesses of the paint as this will give a risk of blistering at later heating. THINNER 08080 must be added at application to secure the low dry film thickness.
High temperature Service:	For high temperature service, the total dry film thickness of the paint system should preferably be kept at 75 micron/3 mils as maximum.
Note:	BAJAK'S POLYESTER HR 51585 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.

BAJAK'S SILICONE HR 51615

Description: BAJAK'S SILICONE HR 51615 is a heat resistant color pigmented paint.

Recommended use: For long-term protection of hot pipelines, exhaust pipes, smoke stacks and other hot surfaces. In corrosive environment see PRECEDING COAT overleaf.

Service temperatures: Maximum, dry: 350°C

Availability: Several color shades are available.

PHYSICAL CONSTANTS:

Colours/Shade nos: Black/7233
Finish: Semi-flat (See REMARKS overleaf)
Volume Solids, %: 39 ± 1
Theoretical spreading rate: 15.6 m²/litre – 25 micron
Flash point: 25°C
Specific gravity: 1.15 kg/litre
Surface dry: 1 (approx.) hour at 20°C/68°F (ISO 1517)
Dry to touch: 2-4 hours at 20°C/68°F
V.O.C.: 490 g/litre

APPLICATION DETAILS:

Application method:	Airless spray	Air spray	Brush
Thinner (max.vol.):	08080 (5%)	08080 (5%)	08080 (5%) (See REMARKS overleaf)
Pot life:	-		
Nozzle orifice:	.017"		
Nozzle pressure:	125 bar		
	(Airless spray data are indicative and subject to adjustment)		
Cleaning of tools:	THINNER 08080		
Indicated film thickness, dry:	25 micron/1 mil (See REMARKS overleaf)		
Indicated film thickness, wet:	65 micron/2.6 mils		
Recoat interval, min:	24 hours (20°C/68°F) (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.

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2. BAJAK'S SILICONE HR 51615

SURFACE PREPARATION:	Remove oil and grease etc. thoroughly with suitable detergent. Remove salts and other contaminants by (high pressure) fresh water cleaning. Abrasive blasting to Sa 2½.
APPLICATION CONDITIONS:	Clean and dry surface with a temperature above dew point to avoid condensation. In confined spaces provide adequate ventilation during application and drying.
PRECEDING COAT:	Can be used directly on blast-cleaned steel. For maximum corrosion protection, a primer coat of the following paints is recommended (40 micron/1.6 mil dry film thicknesses): BAJAK'S SILICONE ZINC 16900 or BAJAK'S ZINCSIL 15700. This will lower the heat resistance, reference is made to the product data sheets for the mentioned primers.
SUBSEQUENT COAT:	None.
REMARKS:	
Gloss:	After exposure to heat the gloss is reduced.
Film thicknesses:	It is recommended to avoid too high thicknesses of the paint as this will give a risk of blistering at later heating. THINNER 08080 must be added at application to secure the low dry film thickness.
Curing:	To obtain full curing BAJAK'S SILICONE HR 51615 requires heating to minimum 200°C/392°F for at least 2 hrs as the coating will otherwise exhibit certain thermo plasticity.
High temperature Service:	For high temperature service, the total dry film thickness of the paint system should preferably be kept at 75 micron/3 mils as maximum.
First exposure:	Do not expose the paint system to heat before it is through dry (minimum 24 hours at 20°C/68°F).
Recoating:	May be recoated when through dry (24 hours at 20°C/68°F) or after being heated for one hour to approximately 200°C/392°F. Before recoating after exposure in contaminated environment, clean surface thoroughly by high pressure fresh water hosing and allow to dry.
Zinc silicate primer:	If BAJAK'S SILICONE HR 51615 is applied on zinc silicate coatings, such as BAJAK'S ZINCSIL 15700, popping may occur after application or after first heating up. The best way to avoid popping is to apply a mist coat in the first pass of BAJAK'S HR 51615. Let the air escape and apply the full coat of BAJAK'S HR 51615.
Note:	BAJAK'S SILICONE HR 51615 is for professional use only.

BAJALIN® ENAMEL 52140 M

- Description:** BAJALIN ENAMEL52140 M is semi flat alkyd enamel which forms a weather resistant coating. It is flexible and resistant to salt water and spillage of mineral oil and other aliphatic hydrocarbons.
- Recommended use:** As a general purpose finishing coat in alkyd systems on exterior and interior steel and woodwork in mildly to moderately corrosive environment.
As a finishing coat in engine rooms including tank tops, main engines and auxiliary machinery.
- Service temperatures:** Maximum, dry: 120°C/248°F (these temperatures may cause yellowing/discoloration).
- Availability:** Part of Group Assortment. Local availability subject to confirmation.

PHYSICAL CONSTANTS:

Colours/Shade nos:	White/10000	Black /19990*
Finish:	Semi-flat	Semi-flat
Volume solids,%	48 ± 1	48 ± 1
Theoretical spreading rate:	12 m ² /litre - 40 micron 480 sq.ft./US gallon - 1.6 mils	16 m ² /litre - 30 micron 643 sq.ft./US gallon - 1.2 mils
Flash point:	38°C/100°F	38°C/100°F
Specific gravity:	1.4 kg/litre – 11.7 lbs/US gallon)	1.12 kg/litre – 9.3 lbs/US gallon
Surface dry:	2½ (approx) hrs at 20°C/68°F (ISO 1517)	2½ (approx) hrs at 20°C/68°F (ISO 1517)
Dry to touch:	6-8 hours at 20°C/68°F	6-8 hours at 20°C/68°F
V.O.C.:	380 g/litre - 3.2 lbs/US gallon	412 g/litre - 3.4 lbs/US gallon

APPLICATION DETAILS:

Application method:	Airless spray	Air spray	Brush/Roller
Thinner (max.vol.):	08230 (5%)	08230 (15%)	08230 (5%) (See REMARKS overleaf)
Nozzle orifice:	.018"		
Nozzle pressure:	150 bar/2200 psi (Airless spray data are indicative and subject to adjustment)		
Cleaning of tools:	THINNER 08230		
Indicated film thickness, dry:	40 micron/1.6 mils		
Indicated film thickness, wet:	80 micron/3.2 mils		
Recoat interval, min:	8 hours (20°C/68°F)		
Recoat interval, max:	See REMARKS overleaf		

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BAJALIN ENAMEL 52140 M

- APPLICATION CONDITIONS:** As dictated by normal good painting practice.
In confined spaces provide adequate ventilation during application and drying.
- PRECEDING COAT:** BAJALIN PRIMER 12050, BAJALIN PRIMER HI-BUILD 13200, BAJALIN UNDERCOAT42460 or according to specification.
- SUBSEQUENT COAT:** None,
- 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.
- Film thicknesses:** May be specified in other film thicknesses than indicated depending on purpose and area of use. This will alter spreading rate and may influence drying time and recoat interval. Normal range 30-40 micron/1.2-1.6 mils.
- Thinning:** THINNER 08080 may be used for spray application, however, with a certain risk of wrinkling of the preceding fresh coat of BAJALIN.
- Recoating:** Recoat intervals related to later conditions of exposure:
(40 micron/1.6 mils dry film thickness of BAJALIN ENAMEL 52140 M)

	Minimum		Maximum	
SURFACE TEMPERATURE	20°C/68°F		20°C/68°F	
	Atmospheric		Atmospheric	
Recoated with (quality numbers only)	Mild	Medium	Mild	Medium
52140	8hour	8 hours	None	5 days

If the maximum recoat interval is exceeded, roughening of the surface is recommended to ensure intercoat adhesion.
Before recoating after exposure in contaminated environment, clean the surface thoroughly by (high pressure) fresh water hosing and allow drying.

- Potable water tanks:** Do not put tanks into service before the coating is properly cured. When cured but before taking tank into use for potable water, fill twice with water, each time for a period of not less than 24 hours, and finally flush with fresh water. Alternatively hose down with warm fresh water (max. 50°C/122°F). Such cleaning may be subject to local/individual specification or regulation.
- Safety:** Handle with care. Before and during use, observe all safety labels on packaging and paint containers, consult BAJAKEL 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.

Note: **BAJALIN ENAMEL 52140 M is for professional use only.**

This Product Data Sheet supersedes those previously issued. For definition and scope, see explanatory notes to applicable Product Data Sheets. Data, specifications, directions and recommendations given in this data sheet represent only test results or experience obtained under controlled or specially defined circumstances. Their accuracy, completeness or appropriateness under the actual conditions of any intended use of the Products herein must be determined exclusively by the Buyer and/or User. The Products are supplied and all technical assistance is given subject to BAJAK's GENERAL CONDITIONS OF SALES, DELIVERY AND SERVICE, unless otherwise expressly agreed in writing. The Manufacturer and Seller disclaim, and Buyer and/or User waive all claims involving, any liability, including but not limited to negligence, except as expressed in said GENERAL CONDITIONS for all results, injury or direct or consequential losses or damages arising from the use of the Products as recommended above, on the overleaf or otherwise. Product data are subject to change without notice and become void five years from the date of issue.

Issued March 2004



BAJALIN® ENAMEL 52140

- Description:** BAJALIN ENAMEL52140 is a glossy alkyd enamel which forms a weather resistant coating. It is flexible and resistant to salt water and spillage of mineral oil and other aliphatic hydrocarbons.
- Recommended use:** As a general purpose finishing coat in alkyd systems on exterior and interior steel and woodwork in mildly to moderately corrosive environment.
As a finishing coat in engine rooms including tanktops, main engines and auxiliary machinery.
- Service temperatures:** Maximum, dry:120°C/248°F(these temperatures may cause yellowing/discoloration).
- Availability:** Part of Group Assortment. Local availability subject to confirmation.

PHYSICAL CONSTANTS:

Colours/Shade nos:	White/10000	Black /19990*
Finish:	Glossy	Glossy
Volume solids,%	46 ± 1	43 ± 1
Theoretical spreading rate:	15.3 m ² /litre - 30 micron 615 sq.ft./US gallon - 1.2 mils	14.3 m ² /litre - 30 micron 575 sq.ft./US gallon - 1.2 mils
Flash point:	38°C/100°F	38°C/100°F
Specific gravity:	1.1 kg/litre - 9.2 lbs/US gallon)	0.9 kg/litre - 7.5 lbs/US gallon
Surface dry:	2½ (approx) hrs at 20°C/68°F (ISO 1517)	2½ (approx) hrs at 20°C/68°F (ISO 1517)
Dry to touch:	6-8 hours at 20°C/68°F	6-8 hours at 20°C/68°F
V.O.C.:	430 g/litre - 3.6 lbs/US gallon	455 g/litre - 3.8 lbs/US gallon

APPLICATION DETAILS:

Application method:	Airless spray	Air spray	Brush/Roller
Thinner (max.vol.):	08230 (5%)	08230 (15%)	08230 (5%) (See REMARKSoverleaf)
Nozzle orifice:	.018"		
Nozzle pressure:	150 bar/2200 psi (Airless spray data are indicative and subject to adjustment)		
Cleaning of tools:	THINNER 08230		
Indicated film thickness, dry:	30 micron/1.2 mils		
Indicated film thickness, wet:	75 micron/3 mils		
Recoat interval, min:	8 hours (20°C/68°F)		
Recoat interval, max:	See REMARKS overleaf		

Issued: March 2004

BAJALIN ENAMEL 52140

APPLICATION CONDITIONS:	As dictated by normal good painting practice. In confined spaces provide adequate ventilation during application and drying.
PRECEDING COAT:	BAJALIN PRIMER 12050, BAJALIN PRIMER HI-BUILD 13200, BAJALIN UNDERCOAT42460 or according to specification.
SUBSEQUENT COAT:	None,
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.
Film thicknesses:	May be specified in other filmthicknesses than indicated depending on purpose and area of use. This will alter spreading rate and may influence drying time and recoat interval. Normal range 30-40 micron/1.2-1.6 mils.
Thining:	THINNER 08080 may be used for spray application, however, with a certain risk of wrinkling of the preceding fresh coat of BAJALIN.
Recoating:	Recoat intervals related to later conditions of exposure: (30 micron/1.2 mils dry film thickness of BAJALIN ENAMEL 52140)

	Minimum		Maximum	
SURFACE TEMPERATURE	20°C/68°F		20°C/68°F	
	Atmospheric		Atmospheric	
Recoated with (quality numbers only)	Mild	Medium	Mild	Medium
52140	8hour	8 hours	None	5 days

If the maximum recoat interval is exceeded, roughening of the surface is recommended to ensure intercoat adhesion.

Before recoating after exposure in contaminated environment, clean the surface thoroughly by (high pressure) fresh water hosing and allow to dry.

Potable water tanks: Do not put tanks into service before the coating is properly cured. When cured but before taking tank into use for potable water, fill twice with water, each time for a period of not less than 24 hours, and finally flush with fresh water. Alternatively hose down with warm fresh water (max. 50°C/122°F). Such cleaning may be subject to local/individual specification or regulation.

Safety: Handle with care. Before and during use, observe all safety labels on packaging and paint containers, consult BAJAKEL 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.

Note: BAJALIN ENAMEL 52140 is for professional use only .

: This Product Data Sheet supersedes those previously issued. For definition and scope, see explanatory notes to applicable Product Data Sheets. Data, specifications, directions and recommendations given in this data sheet represent only test results or experience obtained under controlled or specially defined circumstances. Their accuracy, completeness or appropriateness under the actual conditions of any intended use of the Products herein must be determined exclusively by the Buyer and/or User. The Products are supplied and all technical assistance is given subject to BAJAK's GENERAL CONDITIONS OF SALES, DELIVERY AND SERVICE, unless otherwise expressly agreed in writing. The Manufacturer and Seller disclaim, and Buyer and/or User waive all claims involving, any liability, including but not limited to negligence, except as expressed in said GENERAL CONDITIONS for all results, injury or direct or consequential losses or damages arising from the use of the Products as recommended above, on the overleaf or otherwise. Product data are subject to change without notice and become void five years from the date of issue.

Issued March 2004



بازاک (سهامی خاص)

BAJATHANE * TOPCOAT 52552

CURING AGENT 62050

Description: BAJATHANE TOPCOAT 52552 is a two-component, polyurethane coating with good gloss and color retention.

Recommended use: As a finishing coat for protection of vehicles and steel structures against weathering, UV degradation, etc with superior hardness and scratch resistance.
Minimum temperature for curing is -10 °C /14°F.

Service temperatures: Maximum ,Dry: 120°C/248°F(see REMARKS overleaf).

Availability: Subject to confirmation.

PHYSICAL CONSTANTS:

Colours/Shade nos: Grey/7202
Finish: Semi Matt
Volume Solids, %: 50
Theoretical spreading rate: 12.5 m²/litre - 40 micron

Flash point: 31°C/88°F
Specific gravity: 1.4 kg/litre
Surface dry: 1½(approx.) hrs at 20°C/68°F (ISO 1517)
Dry to touch: 4 (approx.) hours at 20°C/68°F
Fully cured: 7 days at 20°C/68°F
V.O.C.: 420 g/litre

* other shades according to assortment list .

APPLICATION DETAILS:

Mixing ratio for 52552: Base 52552 : Curing agent 62050
8 : 1 by weight
Application method: Curtain Brush (touch-up)
Thinner (max.vol.): 08080 (5%) 08080 (20%)
Pot life: 3 hours (20°C/68°F)
Nozzle orifice:
Nozzle pressure:

Cleaning of tools: THINNER 08080
Indicated film thickness, dry: 40 micron/2 mils
Indicated film thickness, wet: 80 micron/4 mils
Recoat interval, min: See REMARKS overleaf
Recoat interval, max: See REMARKS overleaf

Issued: March 2018

2. BAJATHANE TOPCOAT 52552

APPLICATION AND CURING CONDITIONS: The surface must be completely clean and dry at the time of application, and its temperature must be above the dew point to avoid condensation. Minimum temperature of curing is -10 °C/14°F. at the freezing point and below, be aware of the risk of ice on the surface which will hinder the adhesion. High humidity and/or condensation during application and the following 16 hours (20°C/68°F) may adversely affect the film formation. In confined spaces provide adequate ventilation during application and drying.

PRECEDING COAT: BAJAPOX 42523 or according to specification.

SUBSEQUENT COAT: None.

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

SERVICE TEMPERATUR: At service temperature above 100 °C/212°F), slight discoloration may be expected.

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 is 40-50 micron/1.6-2 mils.

Thinning: The type and amount of thinner depend on application conditions, application method, temperature, ventilation, and substrate. THINNER 08080 is recommended in general.

Recoating And drying/curing time:

Physical data versus temperatures:						
SURFACE TEMPERATURE		-10°C/14°F	0°C/32°F	10°C/50°F	20°C/68°F	30°C/86°F
Dry to touch, approx.		3 days	36 hours	10 hours	4 hours	3 hours
Resist condensing humidity/light showers after*:		7 days	3 days	32 days	16 hours	12 hours
Fully cured, 70% RH		2 months	32 days	14 days	7 days	5 days
Recoating interval, Recoating 52552 with 52551	Min	6 days	3 days	32 hours	16 hours	12 hours
	Max	None	None	None	None	None

*Faster drying and curing may be obtained by using an "accelerator" – consult BAJAK for further advice.

A completely clean surface is mandatory to ensure intercoat adhesion, specially at long recoating intervals. Any dirt, oil, and grease has to be removed, e.g. with suitable detergent.

Salts to be removed by fresh water hosing. To check an adequate quality of the surface cleaning a test patch is recommended before actual recoating.

Note: CURING AGENT 62050 is sensitive to moisture. Store in dry place and keep the can tightly closed until use. Open curing agent cans with caution as overpressure might exist. Even small traces of water in the mixed paint will reduce the pot-life and result in film defects.

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



BAJAMIRROR 52586

Description: BAJAMIRROR 52586 mirror-back coatings represent the state-of-the-art in high-performance, protective coatings for mirror products. BAJAMIRROR52586 coatings deliver superior performance against the harshest accelerated environmental testing requirements in the mirror industry, including excellent salt spray and CASS corrosion results.

Recommended use : As a top coat for primed mirror sheets

APPLICATION DETAILS:

Applying viscosity 25-30 sec ,Ford cup No. #4
Thinner(20%,based on volume) xylene

CURING CONDITIONS :

Substrate primer painted mirror sheets
DFT 25microns
Baking temperature 150 °C
Baking time 6min @150 °C

PHYSICAL PROPERTIES :

Shade Grey
Specific gravity , ±0.02 (g/ml) 1.33,(ASTM 1475)
Volume solid (%) 52,(ASTM 2697)
Weight solid (%) 65.3,(ASTM D 2697-03)
Pot life 12 hr.
Shelf life 6 months
Preceding coat BAJAMIRROR 12148

FILM PROPERTIES:

Shade Grey
Pencil Hardness 2H (min.), (ASTM D3363)
Adhesion 5B, (ASTM D 3359 or 0, ISO 2409)
MEK resistance >100 (double rubbing)
Neutral salt spray Min. 500 hours, without blistering (ASTM B117)
CASS(Copper accelerated acetic acid salt spray) 5 day without any blistering on surface and any penetration in the X cut line, (ASTMB 368 - 97)

APPLICATION METHOD: Curtain coating or Pouring method

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.

BAJAK'S ALUMINIUM HR 52614

Description: BAJAK'S ALUMINIUM HR 52614 is a mid coat and top coat heat resistant aluminium pigmented physically drying paint. resistance to heat up to 200°C and heat stress.

Recommended use: For long-term protection of hot pipelines, exhaust pipes, smoke stacks and other hot Surfaces up to 200°C. resist short time exposure up to 250°C. when heated to above 200°C for longer periods a certain discoloration may occur, which do not affect the protective properties of the product..

Service temperatures: Maximum, dry: 200°C/392 °F.

Availability:

PHYSICAL CONSTANTS:

Colours/Shade nos: Aluminium
 Finish: Semi glass (See REMARKS overleaf)
 Volume Solids, %: 35 ± 1
 Theoretical spreading rate: 10 m²/litre – 35 micron
 Flash point: 28°C/82°F
 Specific gravity: 1 kg/litre - 7 lbs/US gallon
 Surface dry: 20 min. (app.) at 20°C/68°F (ISO 1517)
 Dry to touch: 2 hours at 20°C/68°F
 V.O.C.: 550 g/litre – 5.3 lbs/US gallon

APPLICATION DETAILS:

Application method:	Airless spray	Air spray	Brush
Thinner (max.vol.):	08230 (15%)	08230 (25%)	08230 (15%)
Pot life:			
Nozzle orifice:	.017"-0.019"		
Nozzle pressure:	125 bar/1800 psi (Airless spray data are indicative and subject to adjustment)		
Cleaning of tools:	THINNER 08230		
Indicated film thickness, dry:	35 micron/1.4 mil (See REMARKS overleaf)		
Indicated film thickness, wet:	100 micron/4 mils		
Recoat interval, min:	4 hours (20°C/68°F) (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.

BAJAK'S ALUMINIUM HR 52614

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 BAJAK'SALUMINIUM HR 52614.
APPLICATION CONDITION:	The surface must be completely clean and dry at the time of application, and its temperature must be 3°C above the dew point to avoid condensation. Minimum temperature for curing is -10°C. At the freezing point and below, be aware of the risk of ice on the surface, which will hinder the adhesion. High humidity and /or condensation during application and the following 16 hours (20°C) may adversely affect the film formation.
PRECEDING COAT:	BAJAK ALUMINIUM ZINC HR 12612 or according to specification.
SUBSEQUENT COAT:	BAJAK'S ALUMINIUM HR 52614 or according to specification.
REMARKS:	
Gloss:	After exposure to heat the gloss is reduced.
Film thicknesses:	A series of maintenance jobs may result in build up of a too high total film thickness, which may cause blister formation due to “entrapped” solvents. As each coat may also retain solvents, it is generally recommended not to apply BAJAK ALUMINUM HR 52614 in excessive film thickness.
Recoating:	Before recoating after exposure in contaminated environment, clean the surface thoroughly by high pressure fresh water hosing and allow drying.
Issued:	Feb. 2010



بازاک (سهامی خاص)

BAJAK MMA 2K ROAD MARKER 52941

Description:	BAJAK 52941 is a two-component, chemically curing ROAD MARKING paint based on methyl meth acrylic resin for optimum abrasion resistance. It has excellent physical and chemical properties such as: U.V resistance, resistance against heat and water, flexible and applicable at low temperatures.
Recommended use:	As an exterior finishing coat in ROAD MARKING system on asphalt and concrete surfaces in moderately to severely abrasion environment.
Service temperature:	Maximum Wet: 50 °C/ 122°F dry: 80 °C/ 176°F

PHYSICAL CONSTANTS:

Colors/Shade No:	White/9016
Finish:	Flat Other colours available on request
Volume Solid:	100% (Curable material)
Theoretical spreading rate:	0.50 m ² /Liter – 2mm 0.33 m ² /lit – 3mm
Flash point	35°C
Specific gravity:	1.55±0.05 kg/liter
Dry to touch:	45 minute at 20 °C/68°F. (ISO 1517)
Fully cured:	2 hrs at 20 °C

APPLICATION DETAILS:

Mixing ratio:	Base: 52941 Curing agent: 62041 100:09 (by weight)
Application method:	See <u>Remarks</u> overleaf
Pot life:	20 minutes at 20°C
Cleaning of tools:	99610

2.BAJAK MMA2K ROAD MARKER

SURFACE PREPARATION:	Asphalt and concrete: cleaning by detergent for removing oil and dirt and drying before applying traffic paint. Repair and maintenance: Remove oil and grease, etc with suitable detergent. Clean damaged areas thoroughly.
APPLICATION AND CURING CONDITION:	The surface must be completely clean and dry at the time of application, and its temperature must be 3°C 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. High humidity and /or condensation during application and the following 6 hours (20°C) may adversely affect the film formation.
APPLICATION METHOD:	Manual application: For drawing pointing signs, pedestrain crossings and vertical traffic signs, using cut-in screens or tape for limiting the design and pouring the paint in the design and flattening it by trowel. Application by lining-box: Lining-box is a metal frame with two edges at the sides one of which is shorter than the other. It is filled with the ready-mixed paint and is drawn towards the desire direction which forms a harmonious film on the surface. Automatic application: In this method paint base is applied by a machine while moving with a thickness of 1mm to 3mm and hardener is sprayed on to it at the same time. Application of warning lines: To draw warning lines through above method, special rollers are used to make the surface uneven.
PRECEDING COAT:	None.
SUBSEQUENT COAT:	None.
REMARKS: Film thicknesses:	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 DFT is 2mm.
Note:	BAJAK BAJAK MMA2K ROAD MARKER is for professional use only.
SAFETY:	Handle with care. Before and during use, observe all safety labels on packaging and paint containers, our 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.
Issued:	MAY 2009



BAJAK'S BAKING ENAMEL 53517

Description: BAJAK'S BAKING ENAMEL 53517 is a one-component, baking finish coat based on Alkyd/Melamine resins for optimum adhesion and hardness resistance. It has excellent physical and chemical properties such as: mechanical properties, resistance against water and flexibility.

Recommended use: As finish coat for industrial tools

Certificate/Approvals:

PHYSICAL CONSTANTS:

Product: 53517
 Colours/Shade no: Black (Other shades according to assortment list) /7035
 Finish: glossy
 Volume Solids, %: 45 ± 1
 Theoretical spreading rate: 15 M2 / liter @ 30 Mic. dft
 Flash point: 24°C/75°F
 Specific gravity: 1.0 – 1.1 kg/liter
 Flash time: 10 minutes at 20°C/68°F
 Cure conditions: 20±5 min. at 150±10°C/285°F
 V.O.C.: 450 g/liter
 Viscosity cup4: 90-100 sec@25°C

Shelf life: 12 months (25°C/77°F) from date of production.
 Shelf life is dependent on storage temperature. Shelf life is reduced at storage temperatures above 25°C/77°F. Do not store above 40°C/104°F or below 5°C/40°F.
 Shelf life is exceeded if the liquid is gelled or viscosity increased.

APPLICATION DETAILS:

Application method:	Air spray	Brush (touch up)
Thinner (max.vol.):	08017 (30%)	08017 (15%)
Nozzle orifice:	1.8	
Air pressure:	4 -6 bar	
Cleaning of tools:	THINNER 08017	
Indicative dft:	30 micron	
Indicative wft:	65 micron	
Recoat interval, min:	After flash time	
Recoat interval, max:	Before baking	

2. BAJAK'S BAKING ENAMEL 53517

SURFACE PREPARATION:	Remove oil and grease with suitable detergent.
APPLICATION CONDITIONS:	The surface must be completely clean and dry with a temperature above the dew point to avoid condensation.
SUBSEQUENT COAT:	As per specification.
REMARKS: Film thicknesses and theoretical spreading rate:	On steel 30 micron/1.2 mil film thickness corresponds to approx. 65 micron/2.5 mil measured on a smooth test panel .Increase in DFT causes decrease in theoretical spreading rate and mechanical properties.
Thinning:	Selection of proper thinner is related to application conditions.
Curing:	Baking time is shorter at higher temperatures.
Shelf life:	1 Year at 25°C/77°F, in higher temperatures shelf life decreased.
Note:	BAJAK'S BAKING ENAMEL 53517 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.
Issued:	October 2012

2. BAJATHANE TOPCOAT 53550

APPLICATION AND CURING CONDITIONS: The surface must be completely clean and dry at the time of application, and its temperature must be above the dew point to avoid condensation. Minimum temperature of curing is $-10\text{ }^{\circ}\text{C}/14^{\circ}\text{F}$. at the freezing point and below, be aware of the risk of ice on the surface which will hinder the adhesion. High humidity and/or condensation during application and the following 16 hours ($20^{\circ}\text{C}/68^{\circ}\text{F}$) may adversely affect the film formation.
In confined spaces provide adequate ventilation during application and drying.

PRECEDING COAT: BAJAPOX INTER MEDIATE 42522 or according to specification.

SUBSEQUENT COAT: None or BAJATHANE TOPCOAT 53550.

REMARKS:
Colours: Certain lead-free red and yellow colours may discolour when exposed to sulphide and chlorine-containing atmosphere.
SERVICE TEMPERATUR: At service temperature above $100\text{ }^{\circ}\text{C}/212^{\circ}\text{F}$), slight discoloration may be expected.

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 is 40-60 micron/1.6-2.4 mils.

Thinning: The tipe and amount of thinner depend on application conditions, application method, temperature, ventilation, and substrate. THINNER 08050 is recommended in general.
Airless spray: 5-15% thinning is recommended. Under extreme conditions up to more than 20% may be necessary to obtain satisfactory film formation.
The best result is obtained by applying a mist coat of BAJATHANE 53550 at first, and then 2-15 minutes later apply to full film thickness giving a uniform film formation. Do not exaggerate the film thickness.

Recoating And drying/curing time:

Physical data versus temperatures:						
SURFACE TEMPERATURE		$-10^{\circ}\text{C}/14^{\circ}\text{F}$	$0^{\circ}\text{C}/32^{\circ}\text{F}$	$10^{\circ}\text{C}/50^{\circ}\text{F}$	$20^{\circ}\text{C}/68^{\circ}\text{F}$	$30^{\circ}\text{C}/86^{\circ}\text{F}$
Dry to touch, approx.		3 days	36 hours	16 hours	8 hours	6 hours
Resist condensing humidity/ light showers after*:		7 days	3 days	32 days	16 hours	12 hours
Fully cured, 70% RH		2 months	32 days	14 days	7 days	5 days
Recoating interval, Recoating 53550 with 53550	Min	6 days	3 days	24 hours	14 hours	8 hours
	Max			15 Days	7 Days	5 Days

*Faster drying and curing may be obtained by using an "accelerator" – consult BAJAK for further advice.

A completely clean surface is mandatory to ensure intercoat adhesion, especially at long recoating intervals. Any dirt, oil, and grease has to be removed, e.g. with suitable detergent.

Salts to be removed by fresh water hosing. To check an adequate quality of the surface cleaning a test patch is recommended before actual recoating.

Note: CURING AGENT 63050 is sensitive to moisture. Store in dry place and keep the can tightly closed until use. Open curing agent cans with caution as overpressure might exist. Even small traces of water in the mixed paint will reduce the pot-life and result in film defects.
BAJATHANE TOPCOAT 53550 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

2.POLYURETHANE FLOORING 53555

APPLICATION AND CURING CONDITIONS:	<p>The surface must be completely clean and dry at the time of application. And its temperature must be above the dew point to avoid condensation. Minimum temperature for curing is 5°C/41°F.</p> <p>At the freezing point and below, beware of the risk of ice on the surface which will hinder the adhesion. High humidity and/or condensation during application and the following 16 hours (20°C/68°F) may adversely affect the film formation. Maximum concrete moisture content should be 4%.</p> <p>In confined spaces provide adequate ventilation during application and drying.</p>
PRECEDING COAT:	BAJAK'S EPOXY SEALER 15026
SUBSEQUENT COAT:	None.
REMARKS: Film thicknesses:	<p>May be specified in another film thickness than indicated depending on purpose and area of use.</p> <p>This will alter spreading rate and may influence drying time and recoating interval. Normal range is 1000 microns/40 mils.</p>
Thinning: Physical property:	Not recommend.

Type of Physical property:	Result	Unit	Standard
Pressure strength	600	Kgf/cm ²	ASTM D695M
Elongation strength	250	Kgf/cm ²	ASTM D638M
Hardness persos	250	Sec	ASTM D4366
Abrasion Resistance	20 mg	1000 cycle	ASTM D4060
Adhesion pull off	500	Psi	ASTM D4541

A completely clean surface is mandatory to ensure intercoat adhesion, especially at long recoating intervals. Any dirt,oil,and grease have to be removed, e.g. with suitable detergent.

Salts to be removed by fresh water hosing. To check an adequate quality of the surface cleaning a test patch is recommended before actual recoating.

SAFETY:	<p>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 and national safety regulations. Harmful or fatal if swallowed; immediately seek medical assistance swallowed. Avoid inhalations of possible solvent vapors or paint mist, as well as paint contact with skin and eyes. Apply only on well-ventilated areas and ensure that adequate forced ventilation exists when applying paint in confined spaces or when the air is stagnant. Always take precautions against the risks of fire and explosions.</p>
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Issued: June 2002



BAJACOIL 53585

Description: BAJACOIL 53585 is high performance modified Polyester-Melamine coil coating topcoat with ultimate weathering resistance. The product has very high flexibility and hardness.

Recommended use: As a topcoat for primed Galvanized steel and Aluminum coils., to be used for sandwich panel, corrugate sheet

CURING CONDITIONS

Substrate	Galvanized steel
Primer	BAJACOIL 12585
DFT of primer	5-7 microns
Primer curing condition	31 sec. @ 350°C
Primer PMT	232-242 °C
Top coat DFT	15-17 microns
Topcoat curing condition	29 sec. @ 350°C
Topcoat PMT	232-241°C

PHYSICAL CONSTANTS OF THE PRODUCT

Shade (RAL)	3005	1015	1028
Density , ±0.02 (gr/ml)	1.06	1.35	1.36
Volume solid (%)	54	45	45
Weight solid (%)	55	65	66
Viscosity	100-110 sec , ASTM Cup#4		
Shelf life	One year		

FILM PROPERTIES

Shade (code)	Red (RAL 3005)
Gloss (%)	30-40
Pencil Hardness	2H (min.)
Flexibility (T-bend)	0T , only crack without delamination 1.5T, without crack
Cupping resistance	7mm, without crack
MEK resistance	>100 (double rubbing)
Salt spray test (galvanized substrate)	Min. 500 hours, without blistering
Chemical resistance (250hrs immersion test)	HCl (15% sol.), H ₂ SO ₄ (15% sol.) , NaOH (15% sol.) , HNO ₃ (5% sol.)

APPLICATION METHOD: Automatic Roller

SURFACE PREPARATION Chromating process

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.

BAJALIN® ENAMEL 54510

Description:	BAJALIN ENAMEL54510 is a glossy alkyd enamel which forms a weather resistant coating. It is flexible and resistant to salt water and spillage of mineral oil and other aliphatic hydrocarbons.
Recommended use:	As a general purpose finishing coat in alkyd systems on exterior and interior steel and woodwork in mildly to moderately corrosive environment. As a finishing coat in engine rooms including tanktops, main engines and auxiliary machinery.
Service temperatures:	Maximum, dry:120°C/248°F (these temperatures may cause yellowing/discoloration).
Availability:	Part of Group Assortment. Local availability subject to confirmation.

PHYSICAL CONSTANTS:

Colours/Shade nos:	White/10000	Black /19990*
Finish:	Glossy	Glossy
Volume solids,%	46 ± 1	43 ± 1
Theoretical spreading rate:	15.3 m ² /litre - 30 micron 615 sq.ft./US gallon - 1.2 mils	14.3 m ² /litre - 30 micron 575 sq.ft./US gallon - 1.2 mils
Flash point:	38°C/100°F	38°C/100°F
Specific gravity:	1.1 kg/litre - 9.2 lbs/US gallon	0.9 kg/litre - 7.5 lbs/US gallon
Surface dry:	2½ (approx) hrs at 20°C/68°F (ISO 1517)	2½ (approx) hrs at 20°C/68°F (ISO 1517)
Dry to touch:	6-8 hours at 20°C/68°F	6-8 hours at 20°C/68°F
V.O.C.:	430 g/litre - 3.6 lbs/US gallon	455 g/litre - 3.8 lbs/US gallon

APPLICATION DETAILS:

Application method:	Airless spray	Air spray	Brush/Roller
Thinner (max.vol.):	08230 (5%)	08230 (15%)	08230 (5%) (See REMARKS overleaf)
Nozzle orifice:	.018"		
Nozzle pressure:	150 bar/2200 psi (Airless spray data are indicative and subject to adjustment)		
Cleaning of tools:	THINNER 08230		
Indicated film thickness, dry:	30 micron/1.2 mils		
Indicated film thickness, wet:	75 micron/3 mils		
Recoat interval, min:	8 hours (20°C/68°F)		
Recoat interval, max:	See REMARKS overleaf		

BAJALIN ENAMEL 54510

APPLICATION CONDITIONS:	As dictated by normal good painting practice. In confined spaces provide adequate ventilation during application and drying.
PRECEDING COAT:	BAJALIN PRIMER 12050, BAJALIN PRIMER HI-BUILD 13200, BAJALIN UNDERCOAT42460 or according to specification.
SUBSEQUENT COAT:	None,
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.
Film thicknesses:	May be specified in other filmthicknesses than indicated depending on purpose and area of use. This will alter spreading rate and may influence drying time and recoat interval. Normal range 30-40 micron/1.2-1.6 mils.
Thining:	THINNER 08080 may be used for spray application, however, with a certain risk of wrinkling of the preceding fresh coat of BAJALIN.
Recoating:	Recoat intervals related to later conditions of exposure: (30 micron/1.2 mils dry film thickness of BAJALIN ENAMEL 54510)

	Minimum		Maximum	
SURFACE TEMPERATURE	20°C/68°F		20°C/68°F	
	Atmospheric		Atmospheric	
Recoated with (quality numbers only)	Mild	Medium	Mild	Medium
54510	8hour	8 hours	None	5 days

If the maximum recoat interval is exceeded, roughening of the surface is recommended to ensure intercoat adhesion.
Before recoating after exposure in contaminated environment, clean the surface thoroughly by (high pressure) fresh water hosing and allow to dry.

Potable water tanks: Do not put tanks into service before the coating is properly cured. When cured but before taking tank into use for potable water, fill twice with water, each time for a period of not less than 24 hours, and finally flush with fresh water. Alternatively hose down with warm fresh water (max. 50°C/122°F). Such cleaning may be subject to local/individual specification or regulation.

Safety: Handle with care. Before and during use, observe all safety labels on packaging and paint containers, consult BAJAKEL 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.

Note: **BAJALIN ENAMEL 54510 is for professional use only .**

: This Product Data Sheet supersedes those previously issued. For definition and scope, see explanatory notes to applicable Product Data Sheets. Data, specifications, directions and recommendations given in this data sheet represent only test results or experience obtained under controlled or specially defined circumstances. Their accuracy, completeness or appropriateness under the actual conditions of any intended use of the Products herein must be determined exclusively by the Buyer and/or User. The Products are supplied and all technical assistance is given subject to BAJAK's GENERAL CONDITIONS OF SALES, DELIVERY AND SERVICE, unless otherwise expressly agreed in writing. The Manufacturer and Seller disclaim, and Buyer and/or User waive all claims involving, any liability, including but not limited to negligence, except as expressed in said GENERAL CONDITIONS for all results, injury or direct or consequential losses or damages arising from the use of the Products as recommended above, on the overleaf or otherwise. Product data are subject to change without notice and become void five years from the date of issue.

Issued March 2004



BAJAK'S BAKING ENAMEL 54517

Description: BAJAK'S BAKING ENAMEL 54517 is a one-component, baking finish coat based on Alkyd/Melamine resins for optimum adhesion and hardness resistance. It has excellent physical and chemical properties such as: mechanical properties, resistance against water and flexibility.

Recommended use: As finish coat for industrial tools

Certificate/Approvals:

PHYSICAL CONSTANTS:

Product: 54517
 Colours/Shade no: Black (Other shades according to assortment list) /7035
 Finish: glossy
 Volume Solids, %: 44 ± 1
 Theoretical spreading rate: 15 M2 / liter @ 30 Mic. dft
 Flash point: 24°C/75°F
 Specific gravity: 1.0 – 1.04 kg/liter
 Flash time: 10 minutes at 20°C/68°F
 Cure conditions: 14 min. at 140 °C/285°F
 V.O.C.: 450 g/liter

Shelf life: 12 months (25°C/77°F) from date of production.
 Shelf life is dependent on storage temperature. Shelf life is reduced at storage temperatures above 25°C/77°F. Do not store above 40°C/104°F or below 5°C/40°F.
 Shelf life is exceeded if the liquid is gelled or viscosity increased.

APPLICATION DETAILS:

Application method:	Air spray	Brush (touch up)
Thinner (max.vol.):	08017 (30%)	08017 (15%)
Nozzle orifice:	1.8	
Air pressure:	4 -6 bar	
Cleaning of tools:	THINNER 08017	
Indicative dft:	20 micron	
Indicative wft:	45 micron	
Recoat interval, min:	After flash time	
Recoat interval, max:	Before baking	

2. BAJAK'S BAKING ENAMEL 54517

SURFACE PREPARATION:	Remove oil and grease with suitable detergent.
APPLICATION CONDITIONS:	The surface must be completely clean and dry with a temperature above the dew point to avoid condensation.
SUBSEQUENT COAT:	As per specification.
REMARKS: Film thicknesses and theoretical spreading rate:	On steel 30 micron/1.2 mil film thickness corresponds to approx. 65 micron/2.5 mil measured on a smooth test panel .Increase in DFT causes decrease in theoretical spreading rate and mechanical properties.
Thinning:	Selection of proper thinner is related to application conditions.
Curing:	Baking time is shorter at higher temperatures.
Shelf life:	1 Year at 25°C/77°F, in higher temperatures shelf life decreased.
Note:	BAJAK'S BAKING ENAMEL 54517 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.
Issued:	October 2012



BAJAPOX TOPCOAT 54521

Description: BAJAPOX 54521 is a two-component epoxy polyamide finish coat with good wetting properties and low water permeability, which cures to a hard wearing and good resistance against abrasion and impact and with excellent decontamination properties. to seawater, mineral oils, aliphatic hydrocarbons and splashes from petrol.

Recommended use:

1. As a topcoat on primed steel.
2. For repair and maintenance work.
3. As a finishing coat for interior use.

Service temperatures:

	Dry:	Wet:
Maximum:	140°C	40°C

TECHNICAL DATAS:

Binders: Epoxy resin and polyamide.
 Pigments: Metallic, extender and colored pigment.
 Solvents: Ketons, Alcohols and aromatic hydrocarbons.
 Hardener: 63020

PHYSICAL CONSTANTS:

Mixed product: 54521
 Colours/Shade no: Grey /7119
 Finish: Glossy, when expose to weather return to semi-gloss
 Volume Solids, %: App. 54 -58
 Theoretical spreading rate: 10 m²/litre – 50 micron DFT
 Flash point: 26°C
 Specific gravity: App. 1.2 kg/litre
 Surface dry: Max. 2 hrs-20°C (ISO 1517)
 Dry to touch: Max. 7 hrs-20°C
 Fully cured: Max. 7 days-20°C
 V.O.C.: App. 385 g/litre

APPLICATION DETAILS:

Mixing ratio: Base 54521 : Curing agent 63020
 3.2 : 1 by weight

Application method:	Airless spray	Air spray	Brush
Thinner (max.vol.):	8450 (5%)	8450 (15%)	8450 (5%)
Pot life:	8 hours (20°C) (airless)		
Nozzle orifice:	.019" - .023"		
Nozzle pressure:	200 bar/3000 psi		
Cleaning of tools:	S8450		
Indicative dft:	50 micron		
Indicative wft:	100 micron		
Recoat interval, min:	8 hrs-20°C		
Recoat interval, max:	7 days-20°C		

2. BAJAPOX TOPCOAT 54521

SURFACE PREPARATION:	On primed surface : The surface must be completely clean and dry at the time of application.
APPLICATION CONDITIONS:	Use only where application and curing can proceed at temperature of the surface and that of the paint itself must be above 10°C. The temperature of the surface and that of the paint itself must be above this limit. Optimum results are obtained at 17°C. Apply only on a dry and clean surface with a 17°C. Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. Relative humidity max. 80%, preferably 40-60%.
PRECEDING COAT:	BAJAPOX PRIMER 11320 , or as per specification.
SUBSEQUENT COAT:	None, or as per specification.
REMARKS: Recoating:	If the maximum recoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion.
Note:	BAJAPOX TOPCOAT 54521 is for professional use only.
Safety:	Handle with care. Before and during use, observe all safety labels on packaging and paint containers. Avoid inhalation of possible solvent vapours or paint mist, as well as paint contact with skin and eyes. Apply only in well ventilated areas.
Issued:	Feb. 2013



بازاكت (سهامى خاص)

BAJATHANE * TOPCOAT 54551

CURING AGENT 64051

Description:	BAJATHANE TOPCOAT 54551 is a two-component, polyurethane coating with good gloss and color retention.
Recommended use:	As a finishing coat for protection of vehicles and steel structures against weathering, UV degradation, etc with superior hardness and scratch resistance. Minimum temperature for curing is -10 °C /14°F.
Service temperatures:	Maximum ,Dry: 120°C/248°F(see REMARKS overleaf).
Approvals:	Approved as a low flame spread material by Germany authorities.
Availability:	Subject to confirmation.

PHYSICAL CONSTANTS:

Colours/Shade nos:	white/10000*
Finish:	Full Gloss
Volume Solids, %:	50
Theoretical spreading rate:	10 m ² /litre - 50 micron 417 sq.ft./US gallon- 2 mils
Flash point:	31°C/88°F
Specific gravity:	1.3 kg/litre - 10.0 lbs/US gallon
Surface dry:	2½(approx.) hrs at 20°C/68°F (ISO 1517)
Dry to touch:	8 (approx.) hours at 20°C/68°F
Fully cured:	7 days at 20°C/68°F
V.O.C.:	445 g/litre - 3.7 lbs/US gallon

* other shades according to assortment list .

APPLICATION DETAILS:

Mixing ratio for 54551:	Base 54551 : Curing agent 64051 4.8 : 1 by weight	
Application method:	Airless spray	Air spray
Thinner (max.vol.):	8051 (5%)	8051 (20%)
Pot life:	2 hours (20°C/68°F)	
Nozzle orifice:	.017"-.019"	
Nozzle pressure:	150 bar/2200 psi (Airless spray data are indicative and subject to adjustment)	
Cleaning of tools:	THINNER 8051	
Indicated film thickness, dry:	50 micron/2 mils	
Indicated film thickness, wet:	100 micron/4 mils	
Recoat interval, min:	See REMARKS overleaf	
Recoat interval, max:	See REMARKS overleaf	

Issued: March 2004

2. BAJATHANE TOPCOAT 54551

APPLICATION AND CURING CONDITIONS: The surface must be completely clean and dry at the time of application, and its temperature must be above the dew point to avoid condensation. Minimum temperature of curing is -10 °C/14°F. at the freezing point and below, be aware of the risk of ice on the surface which will hinder the adhesion. High humidity and/or condensation during application and the following 16 hours (20°C/68°F) may adversely affect the film formation.
In confined spaces provide adequate ventilation during application and drying.

PRECEDING COAT: BAJAPOX HI-BUILD 45200,BAJAPOX 45141,BAJAPOX 4530 or according to specification.

SUBSEQUENT COAT: None.

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

SERVICE TEMPERATURE: At service temperature above 100 °C(212°F), slight discoloration may be expected.

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 is 40-60 micron/1.6-2.4 mils.

Thinning: The type and amount of thinner depend on application conditions, application method, temperature, ventilation, and substrate. THINNER 8051 is recommended in general.
Airless spray: 5-15% thinning is recommended. Under extreme conditions up to more than 20% may be necessary to obtain satisfactory film formation.
The best result is obtained by applying a mist coat of BAJATHANE 54551 at first, and then 2-15 minutes later apply to full film thickness giving a uniform film formation. Do not exaggerate the film thickness.

Recoating And drying/curing time:

Physical data versus temperatures:						
SURFACE TEMPERATURE		-10°C/14°F	0°C/32°F	10°C/50°F	20°C/68°F	-30°C/86°F
Dry to touch,approx.		3 days	36 hours	16 hours	8 hours	6 hours
Resist condensing humidity/light showers after*:		7 days	3 days	32 days	16 hours	12 hours
Fully cured, 70% RH		2 months	32 days	14 days	7 days	5 days
Recoating interval, Recoating 54551 with 54551	Min	6 days	3 days	32 hours	16 hours	12 hours
	Max	None	None	None	None	None

*Faster drying and curing may be obtained by using an "accelerator" – consult BAJAK for further advice.

A completely clean surface is mandatory to ensure intercoat adhesion, especially at long recoating intervals. Any dirt, oil, and grease has to be removed, e.g. with suitable detergent.

Salts to be removed by fresh water hosing. To check an adequate quality of the surface cleaning a test patch is recommended before actual recoating.

Note: CURING AGENT 64051 is sensitive to moisture. Store in dry place and keep the can tightly closed until use. Open curing agent cans with caution as overpressure might exist. Even small traces of water in the mixed paint will reduce the pot-life and result in film defects.

BAJATHANE TOPCOAT 54551 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



BAJAK'S BAKING ENAMEL 54580

Description: BAJAK'S BAKING ENAMEL 54580 is a one-component, baking finish coat based on polyester/Melamine resins for optimum adhesion and hardness resistance. It has excellent physical and chemical properties such as: mechanical properties, resistance against water and flexibility.

Recommended use: As finish coat for industrial tools

Certificate/Approvals:

PHYSICAL CONSTANTS:

Product: 54580
 Colours/Shade no: Black (Other shades according to assortment list) /7035
 Finish: glossy
 Volume Solids, %: 50 ± 2
 Theoretical spreading rate: 12 M2 / liter @ 40 Mic. dft
 Flash point: 24°C/75°F
 Specific gravity: 1.2 – 1.3 kg/liter
 Flash time: 10 minutes at 20°C/68°F
 Cure conditions: 25 min. at 140 °C/285°F
 V.O.C.: 500 g/liter

Shelf life: 12 months (25°C/77°F) from date of production.
 Shelf life is dependent on storage temperature. Shelf life is reduced at storage temperatures above 25°C/77°F. Do not store above 40°C/104°F or below 5°C/40°F.
 Shelf life is exceeded if the liquid is gelled or viscosity increased.

APPLICATION DETAILS:

Application method:	Air spray	Brush (touch up)
Thinner (max.vol.):	08017 (30%)	08017 (15%)
Nozzle orifice:	1.8	
Air pressure:	4 -6 bar	
Cleaning of tools:	THINNER 08017	
Indicative dft:	40 micron	
Indicative wft:	80 micron	
Recoat interval, min:	After flash time	
Recoat interval, max:	Before baking	

2. BAJAK'S BAKING ENAMEL 54580

SURFACE PREPARATION:	Remove oil and grease with suitable detergent.
APPLICATION CONDITIONS:	The surface must be completely clean and dry with a temperature above the dew point to avoid condensation.
SUBSEQUENT COAT:	As per specification.
REMARKS: Film thicknesses and theoretical spreading rate:	On steel 40 micron/1.6 mil film thickness corresponds to approx. 80 micron/3.2 mil measured on a smooth test panel .Increase in DFT causes decrease in theoretical spreading rate and mechanical properties.
Thinning:	Selection of proper thinner is related to application conditions.
Curing:	Baking time is shorter at higher temperatures.
Shelf life:	1 Year at 25°C/77°F, in higher temperatures shelf life decreased.
Note:	BAJAK'S BAKING ENAMEL 54580 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.
Issued:	October 2012



BAJACOIL 54586

Description: BAJACOIL 54586 is high performance coil coating topcoat based on polyester with ultimate weathering resistance. The product has very high flexibility and hardness.

Recommended use: As a topcoat for primed Galvanized steel and Aluminum coils., to be used for sandwich panel, corrugate sheet and composite panel

CURING CONDITIONS

Substrate	Galvanized steel and Aluminum (with chromating or phosphating process)
Primer	BAJACOIL 12585
DFT of primer	7-8 microns
Primer curing condition	For Galvanized steel 30 sec. @ 315-325°C - for aluminum 40 sec. @ 230-240 °C
Primer PMT	216-220°C
Top coat DFT	15-18 microns
Topcoat curing condition	For Galvanized steel 30 sec. @ 315-325°C – for aluminum 70 sec. @ 230-240 °C
Topcoat PMT	225-235 °C

PHYSICAL CONSTANTS OF THE PRODUCT

Shade	Based on order
Density , ±0.02 (gr/ml)	1.25
Volume solid (%)	52
Weight solid (%)	64
Viscosity	80-90 sec , ASTM Cup#4
Shelf life	One year

FILM PROPERTIES

Shade	Based on order
Gloss (%)	85-90 @ 60°
Pencil Hardness	2H (min.)
Adhesion	5B
Flexibility (T-bend)	0T , only crack without delamination 1.5T, without crack
Cupping resistance	7mm, without crack
MEK resistance	>100 (double rubbing)
Salt spray test (galvanized substrate)	Min. 500 hours, without blistering

APPLICATION METHOD: Automatic Roller or bar coater

SURFACE PREPARATION Chromating process

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.



Product Data

BAJAPOX ANTISTATIC TOPCOAT 54726

CURING AGENT 61726

Description: BAJAPOX ANTISTATIC TOPCOAT 54726 is high performance Epoxy polyamine conductive topcoat on primed concrete structures.

Recommended use: 1. As a high performance antistatic topcoat with excellent adhesion to a wide range of existing coatings on primed concrete.

Service temperatures: Dry:
Maximum: 120°C/248°F

PHYSICAL CONSTANTS:

Colours: Light Gray
Finish: Gloss
Solids Content, %: 90
Theoretical spreading rate: 0.9 m²/litre - 1000 micron
36 sq.ft./US gallon - 40 mils
Flash point: 38°C/90°F
Specific gravity: 1.36 kg/litre
Surface dry: 3 (approx.) hrs at 20°C/68°F (ISO 1517)
Dry to touch: 5 (approx.) hours at 20°C/68°F
Fully cured: 5 days at 20°C/68°F
V.O.C.: 135 g/litre

APPLICATION DETAILS:

Mixing ratio for 54726 : Base 54726: Curing agent 61726
4 : 1 by weight

Application method: roller knife
(Consult the separate APPLICATION INSTRUCTIONS)

Thinner (max.vol.): Do not dilute

Pot life: 0.5 hour (20°C/68°F)

Nozzle orifice: -

Nozzle pressure: -

Cleaning of tools: BAJAK'S THINNER 8020

Indicated film thickness, dry: 3000

Indicated film thickness, wet: 3300

Recoat interval, min: 8 hour (20°C/68°F)

Recoat interval, max: 3 Days (20°C/68°F)

2. BAJAPOX ANTISTATIC TOPCOAT 54726

SURFACE PREPARATION: Primed Concrete surface should be clean from dust and grease with thinner or suitable detergent and dry.

APPLICATION CONDITIONS: Use only where application and curing can proceed at temperatures above 0°C/50°F. The temperature of the paint itself must be above 15°C/59°F for proper application. In-can temperature of the paint should preferably be below 25°C/77°F. Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. Relative humidity max 60%.

PRECEDING COAT: BAJAPOX ANTISTATIC PRIMER 11726

SUBSEQUENT COAT: None, or BAJAPOX ANTISTATIC 54726

REMARKS The natural tendency of epoxy coatings to chalk in outdoor exposure and to become more Weathering/service sensitive to mechanical damage and chemical exposure at elevated temperatures is also reflected temperatures in this product.

Dry 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 of dry film thickness is 1000-3000 mic.

Recoating:

Physical data versus temperatures:				
	Minimum		Maximum	
SURFACE TEMPERATURE	20°C/68°F		20°C/68°F	
	Atmospheric mild	Atmospheric Medium	Atmospheric mild	Atmospheric Medium
Recoated with BAJAPOX 54726	8 hours	8 hours	5 days	3 days

Note: **BAJAPOX ANTISTATIC PRIMER 11726** 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.



BAJATHANE ENAMEL 55100

CURING AGENT 95370

- Description:** BAJATHANE ENAMEL 55100 is a two-component, high-gloss acrylic polyurethane enamel with good gloss and colour retention.
- Recommended use:** As a glossy decorative finishing coat on a variety of substrates such as steel, aluminium, glassfibre, reinforced polyester, plywood, hardwood etc. in severely corrosive atmospheric environment.
Minimum temperature for curing is $-10^{\circ}\text{C}/14^{\circ}\text{F}$.
- Service temperatures:** Maximum, dry: $120^{\circ}\text{C}/248^{\circ}\text{F}$ (see REMARKS overleaf).

PHYSICAL CONSTANTS:

Colours :	White
Finish:	High-gloss
Volume solids, %:	52 ± 1
Theoretical spreading rate:	14.9 m ² /litre - 35 micron 596 sq.ft./US gallon - 1.4 mil
Flash point:	$31^{\circ}\text{C}/88^{\circ}\text{F}$
Specific Gravity:	1.3 kg/litre - 10.8 lbs/US gallon
Surface dry:	2½ (approx.) hrs at $20^{\circ}\text{C}/68^{\circ}\text{F}$ (ISO 1517)
Dry to touch:	4-5 hours at $20^{\circ}\text{C}/68^{\circ}\text{F}$
Fully cured:	7 days at $20^{\circ}\text{C}/68^{\circ}\text{F}$
V.O.C.:	440 g/litre - 3.7 lbs/US gallon

*Other shades according to assortment list.

APPLICATION DETAILS:

Mixing ratio for 55100:	Base 55100 : Curing agent 95370 7 : 1 by volume		
Application method:	Airless spray	Air spray	Brush
Thinner (max.vol.):	See REMARKS overleaf	See REMARKS overleaf	08080 (5%)
Pot life:	2 hours ($20^{\circ}\text{C}/68^{\circ}\text{F}$)		
Nozzle orifice:	.017"-.019"		
Nozzle pressure	75-100 bar /1100 -1450 psi (Airless spray data are indicative and subject to adjustment)		
Cleaning of tools:	THINNER 08080 or 08510		
Indicated film thickness, dry:	35 micron/1.4 mil		
Indicated film thickness, wet:	75 micron/3 mils		
Recoat interval, min:	8 hours ($20^{\circ}\text{C}/68^{\circ}\text{F}$)		
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.

BAJATHANE ENAMEL 55100

APPLICATION AND CURING CONDITIONS:

The surface must be completely clean and dry at the time of application, and its temperature must be above the dew point to avoid condensation. Minimum temperature for curing is $-10^{\circ}\text{C}/14^{\circ}\text{F}$. At the freezing point and below, be aware of the risk of ice on the surface which will hinder the adhesion. Light rain, high humidity and/or condensation during application and the following 16 hours ($20^{\circ}\text{C}/68^{\circ}\text{F}$) may adversely affect the film formation. The humidity of plywood/hardwood should not exceed 16% w/w. In confined spaces provide adequate ventilation during application and drying.

PRECEDING COAT:

BAJAPOX HI-BUILD 45200/45201, BAJAPOX 45304, BAJAPOX MASTIC 45880 or according to specification.

SUBSEQUENT COAT:

None.

REMARKS:

Colours:

Certain lead-free red and yellow colours may discolour when exposed to chlorine-containing atmosphere.

Service temperatures:

Leaded colours may become discoloured when exposed to sulphide-containing atmosphere. At service temperatures above $100^{\circ}\text{C}/212^{\circ}\text{F}$, slight discoloration may be expected.

Film thicknesses:

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 is 20-40 micron/0.8 -1.6 mils.

Thinning:

The type and amount of thinner depend on application conditions, application method, temperature, ventilation, and substrate. THINNER 08080 is recommended in general. THINNER 08510 may be used alternatively depending on local conditions.

Airless spray: 15-20% thinning is recommended. Under extreme conditions more than 25% may be necessary to obtain satisfactory film formation.

Conventional air spray: Dilute to a viscosity of 17-20 s/DIN 4 (approx 35% by volume). Use lowest possible air pressure and a small nozzle.

For both kinds of spray application the best result is obtained by applying a mist coat of BAJATHANE ENAMEL 55100 at first, and then 2-15 minutes later apply to full film thickness giving a uniform film formation. Do not exaggerate the film thickness.

Recoating and drying/curing time:

Physical data versus temperatures (35 micron/1.4 mil dry film thickness - sufficient ventilation):						
Surface temperature		$-10^{\circ}\text{C}/14^{\circ}\text{F}$	$0^{\circ}\text{C}/32^{\circ}\text{F}$	$10^{\circ}\text{C}/50^{\circ}\text{F}$	$20^{\circ}\text{C}/68^{\circ}\text{F}$	$30^{\circ}\text{C}/86^{\circ}\text{F}$
Dry to touch, approx.		45 hours	20 hours	9 hours	5 hours	3 hours
Resist condensing humidity/light showers after:		(7 days)	3 days	32 hours	16 hours	12 hours
Fully cured, 70% RH		(2 months)	32 days	14 days	7 days	5 days
Recoating interval, recoating 55100 with 55100	Min	3 days	1½ day	16 hours	8 hours	6 hours
	Max	(6 months)	(6 months)	(6 months)	3 months	2 months

* The maximum recoating intervals apply to surfaces exposed to very severe conditions of periodical immersion, heavy condensation, great variations in temperatures, chemical attack and/or abrasion during service life of the coating system. Under other conditions no maximum recoating interval. **A completely clean surface is anyhow mandatory to ensure intercoat adhesion especially at long recoating intervals. Any dirt oil and grease has to be removed, e.g. with suitable detergent. Salts to be removed by fresh water hosing. To check an adequate quality of the surface cleaning a test patch is recommended before actual recoating.**

If the maximum recoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion. In the case of recoating with other paint materials maximum will be 1-3 days ($20^{\circ}\text{C}/68^{\circ}\text{F}$) depending on type.

CURING AGENT 95370 is sensitive to moisture. Store in a dry place and keep the can tightly closed until use. Open curing agent cans with caution as overpressure might exist. Even small traces of water in the mixed paint will reduce the pot-life and result in film defects.

BAJATHANE ENAMEL 55100 is for professional use only.

Notes:



BAJATHANE * TOPCOAT 55210

CURING AGENT 95370

Description: BAJATHANE TOPCOAT 55210 is a two-component, semi-gloss aliphatic acrylic polyurethane coating with good gloss and color retention.

Recommended use: As a finishing coat for protection of structural steel in severely corrosive environment, where light-fastness and gloss retention are required.
Minimum temperature for curing is $-10^{\circ}\text{C} / 14^{\circ}\text{F}$.

Service temperatures: Maximum, Dry: $120^{\circ}\text{C} / 248^{\circ}\text{F}$ (see REMARKS overleaf).

Approvals: Approved as a low flame spread material by Germany authorities.

Availability: Subject to confirmation.

PHYSICAL CONSTANTS:

Colours/Shade nos:	white/10000*	Blue/30840*
Finish:	Semi-gloss	Semi-gloss
Volume Solids, %:	51 \pm 1	49 \pm 1
Theoretical spreading rate:	10.4 m ² /litre - 50 micron 417 sq.ft./US gallon- 2 mils	9.8 m ² /litre - 50 micron 393 sq.ft./US gallon- 2 mils
Flash point:	31 $^{\circ}\text{C} / 88^{\circ}\text{F}$	31 $^{\circ}\text{C} / 88^{\circ}\text{F}$
Specific gravity:	1.2 kg/litre - 10.0 lbs/US gallon	1.1 kg/litre - 9.2 lbs/US gallon
Surface dry:	2½ (approx.) hrs at 20 $^{\circ}\text{C} / 68^{\circ}\text{F}$ (ISO 1517)	2½ (approx.) hrs at 20 $^{\circ}\text{C} / 68^{\circ}\text{F}$ (ISO 1517)
Dry to touch:	8 (approx.) hours at 20 $^{\circ}\text{C} / 68^{\circ}\text{F}$	8 (approx.) hours at 20 $^{\circ}\text{C} / 68^{\circ}\text{F}$
Fully cured:	7 days at 20 $^{\circ}\text{C} / 68^{\circ}\text{F}$	7 days at 20 $^{\circ}\text{C} / 68^{\circ}\text{F}$
V.O.C.:	445 g/litre - 3.7 lbs/US gallon	465 g/litre - 3.9 lbs/US gallon
Shelf life:	1 year (25 $^{\circ}\text{C}$) from time of production. Depending on storage conditions, mechanical stirring may be necessary before usage.	

* other shades according to assortment list .

APPLICATION DETAILS:

Mixing ratio for 55210:	Base 55210 : Curing agent 95370 7 : 1 by volume	
Application method:	Airless spray	Brush
Thinner (max.vol.):	See REMARKS overleaf	08080 (5%)
Pot life:	2 hours (20 $^{\circ}\text{C} / 68^{\circ}\text{F}$)	
Nozzle orifice:	.017"-.019"	
Nozzle pressure:	150 bar/2200 psi (Airless spray data are indicative and subject to adjustment)	
Cleaning of tools:	THINNER 08080 OR 08510	
Indicated film thickness, dry:	50 micron/2 mils	
Indicated film thickness, wet:	100 micron/4 mils	
Recoat interval, min:	See REMARKS overleaf	
Recoat interval, max:	See REMARKS overleaf	

Issued: Mar. 2014

2. BAJATHANE TOPCOAT 55210

APPLICATION AND CURING CONDITIONS: The surface must be completely clean and dry at the time of application, and its temperature must be above the dew point to avoid condensation. Minimum temperature of curing is $-10\text{ }^{\circ}\text{C}/14^{\circ}\text{F}$. at the freezing point and below, be aware of the risk of ice on the surface which will hinder the adhesion. High humidity and/or condensation during application and the following 16 hours ($20^{\circ}\text{C}/68^{\circ}\text{F}$) may adversely affect the film formation.
In confined spaces provide adequate ventilation during application and drying.

PRECEDING COAT: BAJAPOX HI-BUILD 45200, BAJAPOX 45141, BAJAPOX 45230 or according to specification.

SUBSEQUENT COAT: None.

REMARKS:

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

SERVICE TEMPERATUR: At service temperature above $100\text{ }^{\circ}\text{C}/212^{\circ}\text{F}$), slight discoloration may be expected.

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 is 40-60 micron/1.6-2.4 mils.

Thinning: The type and amount of thinner depend on application conditions, application method, temperature, ventilation, and substrate. THINNER 08080 is recommended in general. THINNER 08510 may be used alternatively depending on local condition.
Airless spray: 5-15% thinning is recommended. Under extreme conditions up to more than 20% may be necessary to obtain satisfactory film formation.
The best result is obtained by applying a mist coat of BAJATHANE ENAMEL 55210 at first, and then 2-15 minutes later apply to full film thickness giving a uniform film formation. Do not exaggerate the film thickness.

Recoating And drying/curing time:

Physical data versus temperatures:						
SURFACE TEMPERATURE		$-10^{\circ}\text{C}/14^{\circ}\text{F}$	$0^{\circ}\text{C}/32^{\circ}\text{F}$	$10^{\circ}\text{C}/50^{\circ}\text{F}$	$20^{\circ}\text{C}/68^{\circ}\text{F}$	$30^{\circ}\text{C}/86^{\circ}\text{F}$
Dry to touch, approx.		3 days	36 hours	16 hours	8 hours	6 hours
Resist condensing humidity/light showers after*:		7 days	3 days	32 days	16 hours	12 hours
Fully cured, 70% RH		2 months	32 days	14 days	7 days	5 days
Recoating interval, Recoating 55210 with 55210	Min	6 days	3 days	32 hours	16 hours	12 hours
	Max	None	None	None	None	None

*Faster drying and curing may be obtained by using an "accelerator" – consult BAJAK for further advice.

A completely clean surface is mandatory to ensure intercoat adhesion, especially at long recoating intervals. Any dirt, oil, and grease has to be removed, e.g. with suitable detergent. Salts to be removed by fresh water hosing. To check an adequate quality of the surface cleaning a test patch is recommended before actual recoating.

Note: CURING AGENT 95370 is sensitive to moisture. Store in dry place and keep the can tightly closed until use. Open curing agent cans with caution as overpressure might exist. Even small traces of water in the mixed paint will reduce the pot-life and result in film defects.
BAJATHANE TOPCOAT 55210 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.

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BAJATHANE * TOPCOAT 55210M

CURING AGENT 95370M

Description: BAJATHANE TOPCOAT 55210M is a two-component, semi-flat aliphatic acrylic polyurethane coating with good gloss and color retention and abrasion resistance.

Recommended use: As a finishing coat for protection of structural steel in severely corrosive environment, where light-fastness and gloss retention are required.
Minimum temperature for curing is -10°C / 14°F .

Service temperatures: Maximum, Dry: 120°C / 248°F (see REMARKS overleaf).

Approvals:

Availability: Subject to confirmation.

PHYSICAL CONSTANTS:

Colours/Shade nos: white/10000*
Finish: Semi-flat
Volume Solids, %: 50 ± 1
Theoretical spreading rate: $10.4\text{ m}^2/\text{litre}$ - 50 micron
 $417\text{ sq.ft./US gallon}$ - 2 mils
Flash point: $31^{\circ}\text{C}/88^{\circ}\text{F}$
Specific gravity: 1.4 – 1.5 kg/litre (According To Shade)
Surface dry: $2.1/2$ (approx.) hrs at $20^{\circ}\text{C}/68^{\circ}\text{F}$ (ISO
Dry to touch: 1517)
Fully cured: 8 (approx.) hours at $20^{\circ}\text{C}/68^{\circ}\text{F}$
V.O.C.: 7 days at $20^{\circ}\text{C}/68^{\circ}\text{F}$
 445 g/litre - 3.7 lbs/US gallon
* other shades according to assortment list .

APPLICATION DETAILS:

Mixing ratio for 55210M: Base 55210M : Curing agent 95370M
8 : 1 by weight

Application method:	Airless spray	Brush	Roller
Thinner (max.vol.):	See REMARKS overleaf	08080 (5%)	08080 (15%)
Pot life:	4 hours ($20^{\circ}\text{C}/68^{\circ}\text{F}$)		
Nozzle orifice:	.017"-.019"		
Nozzle pressure:	150 bar/2200 psi (Airless spray data are indicative and subject to adjustment)		
Cleaning of tools:	THINNER 08080 OR 08510		
Indicated film thickness, dry:	50 micron/2 mils		
Indicated film thickness, wet:	100 micron/4 mils		
Recoat interval, min:	See REMARKS overleaf		
Recoat interval, max:	See REMARKS overleaf		

Issued: Mar. 2007

2. BAJATHANE TOPCOAT 55210M

APPLICATION AND CURING CONDITIONS: The surface must be completely clean and dry at the time of application, and its temperature must be above the dew point to avoid condensation. Minimum temperature of curing is $-10^{\circ}\text{C}/14^{\circ}\text{F}$. at the freezing point and below, be aware of the risk of ice on the surface which will hinder the adhesion. High humidity and/or condensation during application and the following 16 hours ($20^{\circ}\text{C}/68^{\circ}\text{F}$) may adversely affect the film formation. In confined spaces provide adequate ventilation during application and drying.

PRECEDING COAT: BAJAPOX HI-BUILD 45200, BAJAPOX 45141, BAJAPOX 45230 or according to specification.

SUBSEQUENT COAT: None.

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

SERVICE TEMPERATUR: At service temperature above $100^{\circ}\text{C}/212^{\circ}\text{F}$), slight discoloration may be expected.

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 is 40-60 micron/1.6-2.4 mils.

Thinning: The type and amount of thinner depend on application conditions, application method, temperature, ventilation, and substrate. THINNER 08080 is recommended in general. THINNER 08510 may be used alternatively depending on local condition.
Airless spray: 5-15% thinning is recommended. Under extreme conditions up to more than 20% may be necessary to obtain satisfactory film formation.
The best result is obtained by applying a mist coat of BAJATHANE ENAMEL 55210M at first, and then 2-15 minutes later apply to full film thickness giving a uniform film formation. Do not exaggerate the film thickness.

Recoating And drying/curing time:

Physical data versus temperatures:						
SURFACE TEMPERATURE		$-10^{\circ}\text{C}/14^{\circ}\text{F}$	$0^{\circ}\text{C}/32^{\circ}\text{F}$	$10^{\circ}\text{C}/50^{\circ}\text{F}$	$20^{\circ}\text{C}/68^{\circ}\text{F}$	$30^{\circ}\text{C}/86^{\circ}\text{F}$
Dry to touch, approx.		3 days	36 hours	16 hours	8 hours	6 hours
Resist condensing humidity/ light showers after*:		7 days	3 days	32 days	16 hours	12 hours
Fully cured, 70% RH		2 months	32 days	14 days	7 days	5 days
Recoating interval, Recoating 55210M with polyurethane	Min	6 days	3 days	32 hours	16 hours	12 hours
	Max	None	None	None	None	None

*Faster drying and curing may be obtained by using an "accelerator" – consult BAJAK for further advice.

A completely clean surface is mandatory to ensure intercoat adhesion, especially at long recoating intervals. Any dirt, oil, and grease has to be removed, e.g. with suitable detergent.

Salts to be removed by fresh water hosing. To check an adequate quality of the surface cleaning a test patch is recommended before actual recoating.

Note: CURING AGENT 95370M is sensitive to moisture. Store in dry place and keep the can tightly closed until use. Open curing agent cans with caution as overpressure might exist. Even small traces of water in the mixed paint will reduce the pot-life and result in film defects.
BAJATHANE TOPCOAT 55210M 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.

Issued: Mar. 2007



Product Data

BAJATHAN E TOPCOAT 55910

CURING AGENT 97050

- Description:** BAJATHANE TOPCOAT 55910 is a very flexible, two-component polyurethane topcoat.
- Recommended use:** As a VOC-compliant, high-build finishing coat for protection of structural steel in corrosive environment, especially for maintenance purposes.
- Service temperatures:** Maximum, dry: 120°C/248°F (see REMARKS overleaf)

PHYSICAL CONSTANTS:

Colours :	White
Finish:	Glossy
Volume solids, %:	66 ± 1
Theoretical spreading rate:	6.6 m ² /litre - 100 micron 265 sq.ft./US gallon - 4 mils
Flash point:	31°C/88°F
Specific gravity:	1.5 kg/litre - 12.5 lbs/US gallon
Surface dry:	3 (approx.) hours at 20°C/68°F (ISO 1517)
Dry to touch:	5 (approx.) hours at 20°C/68°F
Fully cured:	7 days at 20°C/68°F
V.O.C.:	330 g/litre - 2.7 lbs/US gallon

APPLICATION DETAILS:

Mixing ratio for 55910:	Base 55910 : Curing agent 97050 7 : 1 by volume	
Application method:	Airless spray (see REMARKS overleaf)	Brush (see REMARKS overleaf)
Thinner (max.vol.):	08080 (5%)	08080 (5%)
Pot life:	2 hours (20°C/68°F)	
Nozzle orifice:	.017"-.021"	
Nozzle pressure:	175 bar/2540 psi (Airless spray data are indicative and subject to adjustment)	
Cleaning of tools:	THINNER 08080/08880	
Indicated film thickness, dry:	100 micron/4 mils (see REMARKS overleaf)	
Indicated film thickness, wet:	150 micron/6 mils	
Recoat interval, min:	11 hours (20°C/68°F)	
Recoat interval, max:	None (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. 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.

BAJATHANE TOPCOAT 55910

APPLICATION CONDITIONS: The surface must be completely clean and dry at the time of application, and its temperature must be above the dew point to avoid condensation. Minimum temperature for curing is $-10^{\circ}\text{C}/14^{\circ}\text{F}$. At the freezing point and below, be aware of the risk of ice on the surface which will hinder the adhesion. High humidity and/or condensation during application and the following 24 hours ($20^{\circ}\text{C}/68^{\circ}\text{F}$) may adversely affect the film formation. In confined spaces provide adequate ventilation during application and drying.

PRECEDING COAT: According to specification.

SUBSEQUENT COAT: None.

REMARKS:

Service temperatures: Service temperatures above $90^{\circ}\text{C}/176^{\circ}\text{F}$, BAJATHANE TOPCOAT 55910 will become more soft. Furthermore, discoloration may occur.

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

Film thicknesses: May be specified in another film thickness than indicated depending on purpose and area of use. Normal range dry is minimum 75 micron/3 mils (undiluted), maximum 125 micron/5 mils. This will alter spreading rate and may influence drying time and recoat interval.

Recoat interval: **Minimum recoating interval** related to later conditions of exposure:

Surface temperature	$-10^{\circ}\text{C}/14^{\circ}\text{F}$	$0^{\circ}\text{C}/32^{\circ}\text{F}$	$10^{\circ}\text{C}/50^{\circ}\text{F}$	$20^{\circ}\text{C}/68^{\circ}\text{F}$	$30^{\circ}\text{C}/86^{\circ}\text{F}$
Normal	3 days	36 hours	16 hours	11 hours	6 hours
Severe	3 days	36 hours	16 hours	11 hours	6 hours

Maximum recoating interval: A completely clean surface is mandatory to ensure intercoat adhesion, especially at long recoat intervals. Any dirt, oil, and grease has to be removed. e.g. with suitable detergent followed by (high pressure) fresh water cleaning. Salts to be removed by fresh water hosing.

To check an adequate quality of the surface cleaning a test patch is recommended before actual recoating.

In case of recoating with other paint materials maximum will be 1-3 days ($20^{\circ}\text{C}/68^{\circ}\text{F}$) depending on type.

Notes: CURING AGENT 97050 is sensitive to moisture. Store in a dry place and keep the can tightly closed until use. Open curing agent cans with caution as overpressure might exist. Even small traces of water in the mixed paint will reduce the pot life and result in film defects.

BAJATHANE TOPCOAT 55910 is for professional use only.



Product Data

BAJATEX ENAMEL 56360

Description:	BAJATEX ENAMEL 56360 is a finishing coat based on acrylic resin and non-chlorinated plasticizer for optimum gloss and colour retention. Physically drying. Resistant to salt water, splashes of aliphatic hydrocarbons and animal and vegetable oils.
Recommended use:	As an interior and exterior finishing coat in BAJATEX systems in moderately to severely corrosive environment.
Service temperatures:	Maximum, dry: 80°C/176°F (see REMARKS overleaf).

PHYSICAL CONSTANTS:

Colours :	Black/19990	Orange/50040
Finish:	Semi-gloss	Semi-gloss
Volume solids, %:	31 ± 1	33 ± 1
Theoretical spreading rate:	8.9 m ² /litre - 35 micron 355 sq.ft./US gallon - 1.4 mils	9.4 m ² /litre - 35 micron 378 sq.ft./US gallon - 1.4 mils
Flash point:	25°C/77°F	25°C/77°F
Specific gravity:	1.0 kg/litre - 8.3 lbs/US gallon	1.0 kg/litre - 8.3 lbs/US gallon
Surface dry:	1 (approx.) hr at 20°C/68°F (ISO 1517)	1 (approx.) hr at 20°C/68°F (ISO 1517)
Dry to touch:	3-4 hours at 20°C/68°F	3-4 hours at 20°C/68°F
V.O.C.:	610 g/litre - 5.1 lbs/US gallon	595 g/litre - 4.9 lbs/US gallon

*Other shades according to assortment list.

APPLICATION DETAILS:

Application method:	Airless spray	Air spray	Brush/Roller
Thinner (max. vol.):	08080 (5%)	08080 (15%)	08080 (5%)
Nozzle orifice:	.017"		
Nozzle pressure:	150 bar/2200 psi (Airless spray data are indicative and subject to adjustment)		
Cleaning of tools:	THINNER 08080		
Indicated film thickness, dry:	35 micron/1.4 mils		
Indicated film thickness, wet:	100 micron/4 mils		
Recoat interval, min:	4 hours (20°C/68°F)		
Recoat interval, max:	None (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. 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.

BAJATEX ENAMEL 56360

APPLICATION CONDITIONS:	As dictated by normal good painting practice. Dry and clean surface at a temperature above the dew point. In confined spaces provide adequate ventilation during application and drying.
PRECEDING COAT:	BAJATEX HI-BUILD qualities, or according to specification.
SUBSEQUENT COAT:	None.
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. To obtain full opacity, an extra coat may be necessary, especially for certain lead-free colours in eg red, orange, yellow and green.
Service temperatures:	As BAJ ATEX ENAMEL 56360 is a thermoplastic product, prolonged direct contact at temperatures above approx. 40°C/104°F may cause film indentation. When the temperature drops below, the mechanical strength is recovered.
Film thicknesses:	A series of maintenance jobs may result in build up of a too high total film thickness which may cause blister formation due to "entrapped" solvents. As each coat may also retain solvents, it is generally recommended not to apply BAJATEX ENAMEL 56360 in excessive film thickness.
Recoating:	Before recoating after exposure in contaminated environment, clean the surface thoroughly by high pressure fresh water hosing and allow to dry. Overlapping with certain other paints may cause cracking. Refer to Remarks of relevant Painting Specification.
Skid-proof surfaces:	If a skid-proof surface is desired, sprinkle BAJAK'S ANTI-SKID 67500 evenly on the first coat of BAJATEX ENAMEL 56360 while still wet (consumption approx. 2.5 kg/5.5 lbs to 25 m ² /270 sq.ft.). When the paint is dry, sweep up surplus grit and apply a second coat of BAJ ATEX ENAMEL 56360. Antiskid properties can also be obtained by mixing 1.0 kg of BAJAK'S ANTI-SKID BEADS 67420 into 20 litres of BAJ ATEX ENAMEL 56360.
Note:	BAJATEX ENAMEL 56360 is for professional use only.



BAJATEX ENAMEL 56360N

Description:	BAJATEX ENAMEL 56360N is a finishing coat based on acrylic resin and non-chlorinated plasticizer for optimum gloss and colour retention. Physically drying. Resistant to salt water, splashes of aliphatic hydrocarbons and animal and vegetable oils. Contains nano-silver to provide anti-bacterial properties.
Recommended use:	As an interior and exterior finishing coat in BAJATEX systems in moderately to severely corrosive environment and masonry surfaces in which anti-bacterial properties are required.
Service temperatures:	Maximum ,Dry: 80°C/176°F(see REMARKS overleaf).
Availability:	Subject to confirmation.

PHYSICAL CONSTANTS:

Colours/Shade nos:	white/10000
Finish:	Semi-matt
Volume Solids, %:	38
Theoretical spreading rate:	10.8 m ² /litre - 35 micron 430 sq.ft./US gallon- 1.4 mils
Flash point:	25°C/77°F
Specific gravity:	1.2 kg/litre
Surface dry:	1(approx.) hrs at 20°C/68°F (ISO
Dry to touch:	1517)
V.O.C.:	3-4 hours at 20°C/68°F 610 g/litre – 5.1 lbs/US gallon
	* other shades according to assortment list .

APPLICATION DETAILS:

Application method:	Airless spray	Air spray	Brush/Roller
Thinner (max.vol.):	08080 (5%)	08080 (15%)	08080 (5%)
Nozzle orifice:	.017"		
Nozzle pressure:	150 bar/2200 psi (Airless spray data are indicative and subject to adjustment)		
Cleaning of tools:	THINNER 0808		
Indicated film thickness, dry:	35 micron/1.4 mils		
Indicated film thickness, wet:	100 micron/4 mils		
Recoat interval, min:	4 hours (20°C/68°F)		
Recoat interval, max:	None (See REMARKS overleaf)		

Issued: March 2008

2. BAJATEX ENAMEL 56360N

APPLICATION CONDITIONS:	As dictated by normal good painting practice. Dry and clean surface at a temperature above the dew point. In confined spaces provide adequate ventilation during application and drying.
PRECEDING COAT:	BAJATEX HI-BUILD qualities, or according to specification.
SUBSEQUENT COAT:	None.
Colours:	Certain lead-free red and yellow colours may discolour when chlorine-containing atmosphere. Leaded colours may become discoloured when exposed to sulphide-containing atmosphere. To obtain full opacity, an extra coat may be necessary, especially for certain lead-free colours in eg red, orange, yellow and green.
SERVICE TEMPERATUR:	At BAJATEX ENAMEL 56360N is a thermoplastic product, prolonged direct contact at temperatures. Above approx. 40°C/104°F may cause film indentation. When the temperature drops below, the mechanicals strength is recovered.
FILM THICKNESS:	A series of maintenance jobs may result in build up of a two high total film thickness which may cause blister formation due to "entrapped" solvents. As each coat may also retain solvents, it is generally recommended not two apply BAJATEX ENAMEL 56360N in excessive film thickness.
Recoating:	Before recoating after exposure in contaminated environment , clean the surface thoroughly by high pressure fresh water hosing and allow to dry. Overlapping with certain other paints may cause cracking. Refer to Remarks of relevant painting specification.
Skid-proof Surfaces:	If a skid-proof surface I desired, Sprinkle BAJAK'S ANTI-SKID 67500 evenly on the first coat of BAJATEX ENAMEL 56360N while still wet (consumption approx. 2.5kg/5.5 lbs to 25m ² /270 sq.ft.). When the paints id dry, sweep up surplus grit and apply a second coat of BAJATEX ENAMEL 56360. Antiskid properties can also be obtained by mixing 1.0 kg of BAJAK'S ANTI-SKID BEADS 67420 into 20 liters of BAJATEX ENAMLE 56360.
Note:	BAJATEX ENAMEL 56360N 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.
Issued:	March 2008



Product Data

BAJAK'S VISIBLE 56540

Description: BAJAK'S VISIBLE 56540 is a non-hiding, but strongly day-light reflecting acrylic paint with fluorescent pigments which give intense colour impression and high visibility VISIBLE. It has no effect in darkness, and it needs BAJAK'S VISIBLE LACQUER 06520 on top in order to improve the light fastness.

Recommended use: For life-saving equipment and for warning purposes such as protruding or moving objects, etc.

Service temperatures: Maximum, dry: 80°C/176°F (see REMARKS overleaf).

PHYSICAL CONSTANTS:

Colours : Orange
 Finish: Semi-gloss
 Volume solids, %: 44 ± 1
 Theoretical spreading rate: 11.0 m²/litre - 40 micron
 441 sq.ft./US gallon - 1.6 mils
 Flash point: 38°C/100°F
 Specific gravity: 1.0 kg/litre - 8.3 lbs/US gallon
 Dry to touch: 1-2 hours at 20°C/68°F
 V.O.C.: 450 g/litre - 3.7 lbs/US gallon

APPLICATION DETAILS:

Application method:	Airless spray	Air spray	Brush
Thinner (max. vol.):	08230 (5%)	08230 (15%)	08230 (5%)
Nozzle orifice:	.015"-.018"		
Nozzle pressure:	150 bar/2200 psi (Airless spray data are indicative and subject to adjustment)		
Cleaning of tools:	THINNER 08230		
Indicated film thickness, dry:	40 micron/1.6 mils		
Indicated film thickness, wet:	100 micron/4 mils		
Recoat interval, min:	2 hours (20°C/68°F)		
Recoat interval, max:	None		

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.

BAJAK'S VISIBLE 56540

APPLICATION CONDITIONS: As dictated by normal good painting practice.
In confined spaces provide adequate ventilation during application and drying.

PRECEDING COAT: White, preferably flat BAJATEX paint or according to specification. BAJAK'S VISIBLE 56540 is applied on a white surface in order to obtain optimum light reflection.

SUBSEQUENT COAT: BAJAK'S VISIBLE LACQUER 06520, which contains ultra-violet radiation absorbing filter.

REMARKS: As BAJAK'S VISIBLE 56540 is a thermoplastic product, prolonged mechanical exposure at temperatures above approx. 40°C/104°F may cause film indentation. When temperature drops below, the mechanical strength is recovered.
Do not expose liquid paint to temperatures above 40°C/104°F neither during storage nor in connection with application.

Note: **BAJAK'S VISIBLE 56540 is for professional use only.**



باجاك (سهامى خاص)

BAJAK'S SILICONE ALUMINIUM 56910

- Description:** BAJAK'S SILICONE ALUMINIUM 56910 is a heat resistant aluminium pigmented paint.
- Recommended use:** For long-term protection of hot pipelines, exhaust pipes, smoke stacks and other hot surfaces. In corrosive environment see PRECEDING COAT overleaf.
- Service temperatures:** Maximum, dry: 600°C/1112°F.
- Availability:** Part of Group Assortment. Local availability subject to confirmation.

PHYSICAL CONSTANTS:

- Colours/Shade nos: Aluminium/19000
Finish: Semi-flat (See REMARKS overleaf)
Volume Solids, %: 31 ± 1
Theoretical spreading rate: rate: 12.4 m²/litre – 25 micron
497 sq.ft./US gallon - 1.0 mil
- Flash point: 25°C/77°F
Specific gravity: 1.1 kg/litre - 9.2 lbs/US gallon
Surface dry: 1 (approx.) hour at 20°C/68°F (ISO 1517)
Dry to touch: 2-4 hours at 20°C/68°F
V.O.C.: 590 g/litre - 4.9 lbs/US gallon
Shelf life: 1 year (25°C) from time of production. Depending on storage conditions, mechanical stirring may be necessary before usage.

APPLICATION DETAILS:

- Application method: Airless spray Air spray Brush Brush
Thinner (max.vol.): 08080 (5%) 08080 (5%) 08080 (5%) (See REMARKS overleaf)
Pot life: 2 hours (20°C/68°F)
Nozzle orifice: .017"
Nozzle pressure: 125 bar/1800 psi
(Airless spray data are indicative and subject to adjustment)
- Cleaning of tools: THINNER 08080
Indicated film thickness, dry: 25 micron/1 mil (See REMARKS overleaf)
Indicated film thickness, wet: 75 micron/3 mils
Recoat interval, min: 24 hours (20°C/68°F) (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.

Issued: March 2004

2. BAJAK'S SILICONE ALUMINIUM 56910

SURFACE PREPARATION:	Remove oil and grease etc. thoroughly with suitable detergent. Remove salts and other contaminants by (high pressure) fresh water cleaning. Abrasive blasting to Sa 2½.
APPLICATION CONDITIONS:	Clean and dry surface with a temperature above dew point to avoid condensation. In confined spaces provide adequate ventilation during application and drying.
PRECEDING COAT:	Can be used directly on blast-cleaned steel. For maximum corrosion protection, a primer coat of the following paints is recommended (40 micron/1.6 mil dry film thicknesses): BAJAK'S SILICONE ZINC 16900 or BAJAK'S ZINCSIL 15700. This will lower the heat resistance, reference is made to the product data sheets for the mentioned primers.
SUBSEQUENT COAT:	None.
REMARKS:	
Gloss:	After exposure to heat the gloss is reduced.
Film thicknesses:	It is recommended to avoid too high thicknesses of the paint as this will give a risk of blistering at later heating. THINNER 08080 must be added at application to secure the low dry film thickness.
Curing:	To obtain full curing BAJAK'S SILICONE ALUMINIUM 56910 requires heating to minimum .300°C for at least 2 hrs as the coating will otherwise exhibit certain thermoplasticity
High temperature Service:	For high temperature service, the total dry film thickness of the paint system should preferably be kept at 75 micron/3 mils as maximum.
First exposure:	Do not expose the paint system to heat before it is through dry (minimum 24 hours at to heat: 20°C/68°F).
Recoating:	May be recoated when through dry (24 hours at 20°C/68°F) or after being heated for one hour to approximately 200°C/392°F. Before recoating after exposure in contaminated environment, clean surface thoroughly by high pressure fresh water hosing and allow to dry.
Zinc silicate primer:	If BAJAK'S SILICONE ALUMINIUM 56910 is applied on zinc silicate coatings, such as BAJAK'S ZINCSIL 15700, popping may occur after application or after first heating up. The best way to avoid popping is to apply a mist coat in the first pass of BAJAK'S SILICONE ALUMINIUM 56910. Let the air escape and apply the full coat of BAJAK'S SILICONE ALUMINIUM 56910.
Note:	BAJAK'S SILICONE ALUMINIUM 56910 is for professional use only.



BAJAK'S SILICONE ACRYLIC 56940

Description:	BAJAK'S SILICONE ACRYLIC 56940 is a heat resistant acrylic modified silicone paint. It is air drying at ambient temperature.
Recommended use:	For long-term protection of hot pipelines, exhaust pipes, smoke stacks and other hot surfaces up to 200°C for aluminum color and 150 °C for other colors , resist short time exposure up to 300°C for aluminum color and 200 °C / 390 °F for other colors. When heated to above 200°C for longer periods a certain discoloration may occur, which do not affect the protective properties of the product. In corrosive environment see PRECEDING COAT overleaf.
Service temperature:	Maximum, dry: 200°C for aluminum color and 150°C for other colors.

PHYSICAL CONSTANTS:

Mixed product:	56940
Colours/Shade no:	Aluminum/19000
Finish:	Semi-flat (see REMARKS overleaf)
Volume Solids, %:	37 ± 1
Theoretical spreading rate:	11.6 m ² /litre – 25 micron
Flash point:	25°C/77°F
Specific gravity:	1.1 kg/liter – 9.2 lbs/US gallon
Surface dry:	½ (approx.) hr at 20°C/68°F (ISO 1517)
Dry to touch:	1-2 hours at 20°C/68°F
V.O.C.:	605 g/liter - 5.0 lbs/US gallon

APPLICATION DETAILS:

Application method:	Airless spray	Air spray	Brush
Thinner (max. vol.):	08080 (15%) (See REMARKS overleaf)	08080 (25%)	08080 (15%)
Nozzle orifice:	.017"		
Nozzle pressure:	125 bar/1800 psi (Airless spray data are indicative and subject to adjustment)		
Cleaning of tools:	THINNER 08080		
Indicative dft:	25 micron/1 mil (See REMARKS overleaf)		
Indicative wft:	50-100 micron/2-4 mils (depending on colour)		
Recoat interval, min:	See REMARKS overleaf		
Recoat interval, max:	See REMARKS overleaf		

2. BAJAK'S SILICONE ACRYLIC 56940

SURFACE PREPARATION:	Remove oil and grease etc. thoroughly with suitable detergent. Remove salts and contaminants by high pressure fresh water cleaning. Abrasive blasting to Sa 2½, SSPC-SP-10. If shop primer is required, only zinc silicate type is recommended.
APPLICATION CONDITIONS:	Clean and dry surface with a temperature above dew point to avoid condensation. In confined spaces provide adequate ventilation during application and drying.
PRECEDING COAT:	Can be used directly on blast-cleaned steel. For maximum corrosion protection, a primer coat of one of the following paints is recommended (40 micron/1.6 mil dry film thicknesses): BAJAK'S SILICONE ZINC 16900 or BAJAK'S ZINCSIL 15700.
SUBSEQUENT COAT:	None.
REMARKS:	
Gloss:	After exposure to heat the gloss is reduced.
Thermo plasticity:	The paint film is somewhat thermoplastic also after heating.
Film thicknesses:	It is recommended to avoid too high thicknesses of the paint as this will give a risk of blistering at later heating. THINNER 08080 must be added at application to secure the low dry film thickness.
High temperature Service:	For high temperature service, the total dry film thickness of the paint system should preferably be kept at 75 micron/3 mils as maximum.
First exposure:	Do not expose the paint system to heat before it is through dry (minimum 24 hours at to heat: 20°C).
Recoating:	May be recoated when through dry (8 hours at 20°C) or after being heated for one hour to approximately 200°C. Before over coating after exposure in contaminated environment, clean surface thoroughly by high pressure fresh water hosing and allow to dry.
Zinc silicate primer:	If BAJAK'S SILICONE ACRYLIC 56940 is applied on zinc silicate coatings, such as BAJAK'S ZINCSIL 15700, popping may occur after application or after first heating up. The best way to avoid popping is to apply a mist coat in the first pass of BAJAK'S SILICONE ACRYLIC 56940. Allow the air to escape and apply the full coat of BAJAK'S SILICONE ACRYLIC 56940.
Note:	BAJAK'S SILICONE ACRYLIC 56940 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.

BAJAK'S ROOF COATING 58810B

Description: BAJAK ROOF COATING 58810B is a high-build acrylic coating. It forms a durable elastomeric membrane with excellent flexibility and water-proofing properties. The appearance is slightly textured.

Area of use: **Exterior:** Roofs and walls.

Substrates: Concrete, masonry, woodwork, tiles, steel, PU foam, etc.

PHYSICAL CONSTANTS:

Colour/Shade nos:	White/10000		
Finish:	Semi-flat		
Volume Solids, %:	37±2%		
Theoretical spreading rate:	2.5 m ² /litre at 150 micron*		
Flash point:	>66°C		
Specific gravity:	1.27 kg/litre		
Dry to touch:	6 hours (10°C)	3 hours (20°C)	1 hour (40°C)

***The theoretical spreading rate** has been calculated for the stated volume solids and dry film thickness.

A practical spreading rate will depend on the actual dry film thickness, the nature of the substrate, and the relevant consumption factor.

The physical constants are subject to normal manufacturing tolerances. Further reference is made to "Explanatory Notes".

APPLICATION DETAILS:

Application method:	Brush/roller	Conventional spray	Airless spray
Thinner (max. vol.):	None	None	None
Cleaning of tools:	Fresh water		
Indicated film thickness, dry:	150 micron		
Indicated film thickness, wet:	400 micron		
Recoat interval, min:	6-12 hours (10°C)	3-6 hours (20°C)	1-3 hours (40°C)
Recoat interval, max:	None	None	None

Surface condition: The surface should be stable, firm, dry and free of dust, sand, loose old paint, Sealer/primer, laitance, dirt, grease and oil. It is recommended to apply a primer/sealer prior to the specified filling procedure. Touch-up with primer/sealer on areas repaired with filler is recommended prior to application of topcoats.

Fillings: Mix 2-3 parts of sand to 1 part of BAJAK'S ROOF COATING 81540 to fill small cracks in the concrete. For large holes and cracks, BAJAK'S EPOXY GROUT 93026 is recommended.

Sealing:
On concrete: BAJAK'S ACRYLIC PRIMER/SEALER 26600.
On ferrous metal: BAJALIN PRIMER 12210.

Remarks: Use only where application and drying can proceed at temperatures above 5°C, preferably above 10°C. Drying data given is on the assumption that proper ventilation is provided.

Note: **BAJAK'S ROOF COATING 58810B 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. Harmful or fatal if swallowed; immediately seek medical assistance if swallowed. Avoid inhalation of possible solvent vapors or paint mist, as well as paint contact with skin and eyes. 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. Always take precautions against the risks of fire and explosions.

Issued: May 2016

BAJAFIRE 71880

SURFACE PREPARATION:	<p>Remove oil and grease, etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning.</p> <p>Abrasive blasting to Sa 2½ SSPC-SP-10, with a sharp-edged surface profile corresponding to Rugotest No. 3, BN9a, Keane-Tator Comparator, 2.0 G/S, 2 S, or ISO Comparator, Medium (G) corresponding to Segment 2.</p>
APPLICATION AND CURING CONDITIONS:	<p>The surface must be completely clean and dry at the time of application. And its temperature must be above the dew point to avoid condensation. Minimum temperature for curing is 5°C/41 °F.</p> <p>At the freezing point and below, be aware of the risk of ice on the surface which will hinder the adhesion. High humidity and/or condensation during application and the following 16 hours (20°C/68°F) may adversely affect the film formation.</p> <p>In confined spaces provide adequate ventilation during application and drying.</p>
PRECEDING COAT:	BAJAK zinc phosphate 15300
SUBSEQUENT COAT:	BAJAFIRE 71880, BAJATEX 56360
REMARKS:	
Film thicknesses:	<p>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 is 350 microns/14 mils. For more than 2 hours fire protection more coats should be applied.</p>
Thinning:	<p>The type and amount of thinner depends on application conditions, application method, temperature, ventilation, and substrate. Di-ionized water is recommended in general.</p> <p>A completely clean surface is mandatory to ensure inter coat adhesion, especially at long recoating intervals. Any dirt, oil, and grease have to be removed, e.g. with suitable detergent. Salts to be removed by fresh water hosing. To check an adequate quality of the surface cleaning a test patch is recommended before actual recoating.</p>
SAFETY:	<p>Handle with care. Before and during use, observe all safety labels on packing and paint containers, consult BAJAK material safety data sheets and follow all local and national safety regulations. Harmful or fatal if swallowed; immediately seek medical assistance swallowed.</p> <p>Avoid inhalations of possible solvent vapors or paint mist, as well as paint contact with skin and eyes. Apply only on well-ventilated areas and ensure that adequate forced ventilation exists when applying paint in confined spaces or when the air is stagnant. Always take precautions against the risks of fire and explosions.</p>
Issued:	July 2011



BAJAK'S TIN-FREE ANTIFOULING 71945

Description: BAJAK'S TIN-FREE ANTIFOULING 71945 is a tin-free, self-polishing antifouling, which has a high content of cuprous oxide and organic bioactive material.

Recommended use: As an antifouling to be used when paints containing tin are not suitable. As an antifouling to be applied bottom of vessels operating in global trade and with short idle periods.

Approved as TBT free anti-fouling paint by Germanischer Lloyd (GL).

PHYSICAL CONSTANTS:

Colours / Shade nos: Brown – Red
 Finish: Flat
 Volume solids: 57%
 Theoretical spreading rate: 5.7 m² / litre – 100 micron
 229 sq.ft. / US gallon – 4 mils
 Flash point: 23°C / 73° F
 Specific gravity : 1.8 kg/litre – 15.0 lbs / US gallon
 Dry to touch: 4 – 5 hours at 20 °C / 68 ° F
 V.O.C : 375 g/litre – 3.1 lbs / US gallon

The physical constants are subject to normal manufacturing tolerances.

APPLICATION DETAILS:

Application method:	Airless spray (see REMARKS overleaf)	Brush / Roller (see REMARKS overleaf)
Thinner (max.vo.):	08080 (5%)	08080 (5%)
Nozzle orifice:	.023" - .027"	
Nozzle pressure:	250 bar / 3600 psi (Airless spray data are indicative and subject to adjustment)	

Cleaning of tools: BAJAK'S THINNER 08080
 Indicated film thickness, dry: 100 micron / 4 mils (see REMARKS overleaf)
 Indicated film thickness, wet: 175 micron / 7 mils
 Recoat interval, min: 8 hours (20°C / 68°F)
 Recoat interval, max: See REMARKS overleaf

Issued : Feb 2007

2. BAJAK'S Tin-free Antifouling 71945

SURFACE PREPARATION : Existing old self polishing or ablative tin-free antifouling: Remove possible oil and grease etc. with suitable detergent, followed by high pressure fresh water cleaning. **It is imperative to remove possible weak structure of the old antifouling as well as the "leached" layer.** This must be done immediately after Indocking and before drying out of the surface. The high pressure hosing executed must be very thorough, pressure minimum 400 bar / 5800psi, keeping the same **short distance** to the surface (15-25 cm) all over. In severe cases, a water pressure up to 700 bar / 10.000 psi and nozzle-to-surface distance of only 10-15 cm may be necessary (minimum 10 cm to avoid damage to primers). This goes for vertical as well as flat bottom. Allow the surface to dry before coating.
Sealer: Whether or not to use a sealer coat depends on the type and condition of the existing antifouling.

APPLICATION CONDITIONS: The surface must be completely clean and dry at the time of application and its temperature must be above the dew point to avoid condensation.
In confined spaces such as sea chests and stagnant air under large flat bottoms provide adequate ventilation during application and drying.

PRECEDING COAT: BAJAPOX 45182 or according to specification.

SUBSEQUENT COAT: None.

REMARKS: This product contains heavy particles. Stir well before use.
By providing a constantly active surface during its life time, this antifouling is gradually sacrificed in the process. The colour of the system changes in accordance with the colours of the coats applied.
Indicated film thickness will vary according to specification. This will alter spreading rate and may influence drying time. In case of multi-coat application, drying time and minimum recoat interval will be influenced by the number of coats and by the thickness of each coat applied – reference is made to the corresponding painting specification.
Range and control of dry film thickness: 80 micron / 3.2 mils to 125 micron/5 mils. Keep thinning to a minimum to ensure that correct film thickness is obtained. The proper way of governing the film thickness is to sub-divide the areas to be painted and calculate the amount of paint to be applied on each sub-divide area. The exact amount of paint calculated must be applied evenly on the area. For further information, please consult the corresponding painting specification.
Recommended number of coats: As per specification depending on existing hull condition, trading pattern, and intended service life.
No maximum recoat interval, but after prolonged exposure to polluted atmosphere, remove accumulated contamination by high pressure fresh water cleaning and allow to dry before applying next coat.
If roller/brush application exceptionally is utilized (e.g. to line out) more coats are necessary to achieve the recommended film thickness.
Undocking: Minimum undocking time depends on number of coats, applied film thickness and the prevailing temperature. For further information, please consult the corresponding painting specification.
Maximum undocking time depends on the atmospheric conditions (UV-radiation, temperature, degree of air pollution, etc.) It is important to carry out a thorough high pressure fresh water cleaning after prolonged exposure. Exposure to the atmosphere up to 6 months normally presents no problem when such cleaning is carried out.

Note: **BAJAK'S TIN-FREE ANTIFOULING 71945 IS FOR PROFESSIONAL USE ONLY.**

SAFETY : Handle with care. Before and during use, observe all safety labels on packing and paint containers, consult BAJAK material safety data sheets and follow all local and national safety regulations. Harmful or fatal if swallowed; immediately seek medical assistance if swallowed. Avoid inhalation of possible solvent vapors or paint mist, as well as paint contact with skin and eyes. 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. Always take precautions against the risks of fire and explosions.

Issued: January 1999



بازاک (سهامی خاص)

BAJAK ACRYLIC ROAD MARKER 72541

Description: BAJAK 72541 is a one-component cold traffic paint based on thermoplastic acrylic resin. With excellent abrasion and weathering resistance.

Recommended use: As a road marker for asphalt and concrete surfaces.

Service temperature: Maximum Wet: 50 °C/ 122°F dry: 80 °C/ 176°F

PHYSICAL CONSTANTS:

Colors/Shade No: White/9031 Yellow/3020
Finish: Semi Flat
Volume Solid: 50%
Theoretical spreading rate: 2.5 M2 /Liter – 200 micron DFT.
Flash point: 33 °C/92° F
Specific gravity: 1.3 kg/liter
Surface dry: 15 minute at 20 °C/68 °F(ISO 1517)
Dry to touch: 30 minute at 20 °C/68°F. (ISO 1517)
Hard dry: 2 hrs. at 20 °C/68°F

The physical constants are subject to normal manufacturing tolerances.

APPLICATION DETAILS:

Application method: Airless and air spray
Thinner (Max by vol): 10%(8041) 20%(8041)
Cleaning of tools: THINNER 8041
Indicated film thickness, dry:200 microns / 8 mils

2.BAJAK COLD ACRYLIC ROAD MARKER 72541

SURFACE PREPARATION:	Asphalt and concrete: cleaning by detergent for removing oil and dirt and drying before applying traffic paint. Repair and maintenance: Remove oil and grease, etc with suitable detergent. Clean damaged areas thoroughly.
APPLICATION CONDITION:	Use only on a clean surface.
PRECEDING COAT:	None.
SUBSEQUENT COAT:	None.
REMARKS: Film thicknesses:	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 DFT is 200 microns/ 8 mils.
Note:	BAJAK ROAD MARKING ACRYLIC 72541 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 and national safety regulations. Harmful or fatal if swallowed; immediately seek medical assistance swallowed. Avoid inhalations of possible solvent vapors or paint mist, as well as paint contact with skin and eyes. Apply only on well-ventilated areas and ensure that adequate forced ventilation exists when applying paint in confined spaces or when the air is stagnant. Always take precautions against the risks of fire and explosions.
Issued:	June 2002



بازاک (سهامی خاص)

BAJAK HI-BUILD ACRYLIC ROAD MARKER 72542

Description: BAJAK 72542 is a one-component cold traffic paint based on thermoplastic acrylic resin. With excellent abrasion and weathering resistance.

Recommended use: As a road marker for asphalt and concrete surfaces.

Service temperature: Maximum Wet: 50 °C/ 122°F dry: 80 °C/ 176°F

PHYSICAL CONSTANTS:

Colors/Shade No: White/9031 Yellow/3020
Finish: Semi Flat
Volume Solid: 60%
Theoretical spreading rate: 3 M² /Liter – 200 micron DFT.
Flash point: 33 °C/92° F
Specific gravity: 1.5 kg/liter
Surface dry: 15 minute at 20 °C/68 °F(ISO 1517)
Dry to touch: 30 minute at 20 °C/68°F. (ISO 1517)
Hard dry: 2 hrs. at 20 °C/68°F

The physical constants are subject to normal manufacturing tolerances.

APPLICATION DETAILS:

Application method: Airless air spray
Thinner (Max by vol): 10%(8041) 20%(8041)
Cleaning of tools: THINNER 99610
Indicated film thickness, dry:200 microns / 8 mils

2.BAJAK COLD ACRYLIC ROAD MARKER 72542

SURFACE PREPARATION:	Asphalt and concrete: cleaning by detergent for removing oil and dirt and drying before applying traffic paint. Repair and maintenance: Remove oil and grease, etc with suitable detergent. Clean damaged areas thoroughly.
APPLICATION CONDITION:	Use only on a clean surface.
PRECEDING COAT:	None.
SUBSEQUENT COAT:	None.
REMARKS: Film thicknesses:	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 DFT is 200 microns/ 8 mils.
Note:	BAJAK ROAD MARKING ACRYLIC 72542 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 and national safety regulations. Harmful or fatal if swallowed; immediately seek medical assistance swallowed. Avoid inhalations of possible solvent vapors or paint mist, as well as paint contact with skin and eyes. Apply only on well-ventilated areas and ensure that adequate forced ventilation exists when applying paint in confined spaces or when the air is stagnant. Always take precautions against the risks of fire and explosions.
Issued:	Dec2014

BAJAPOX FLOW 73522

CURING AGENT 62021

DESCRIPTION:

BAJAPOX FLOW 73522 is a two component, high build, inhibitive pigmented polyamide cured epoxy paint with good wetting properties and low water permeability. It is self priming and forms a hard and tough coating which has good resistance against abrasion and impact as well as to natural gas and aliphatic hydrocarbons.

RECOMMENDED USE:

As an internal protection of steel pipes carrying natural gas and
As a flow coat.

PHYSICAL CONSTANTS:

Colours:	Red-Brown/1130	
Finish:	Semi-gloss.	
Volume by solid:	55%	
Theoretical Spreading rate:	7.3	m ² /litre-75 micron
	292	sq.ft/US gallon 3 mils
Flash point:	25°C/77°F	Abel-pensky.close cup
Specific gravity:	1.3	kg/litre
	10.9	lbs/US gallon
Dry to touch:	2 (approx.)	hours at 25 °C/77°F
Fully cured:	7	days at 25 °C/77°F

APPLICATION DETAILS:

Mixing Ratio:

BASE: BAJAPOX FLOW 73522 3.1 part by volume
CURING AGENT: 62021 1.0 part by volume

Application Method:

Airless Spray Brush (For Touch-up only)

Thinner (max.vol):

max. 5 % (S08450) max. 10%(S08450)

Pot-Life:

4 hour (25°C/77°F)

Nozzle Orifice:

0.017"-0.019" reversible nozzle

Nozzle Pressure:

200 bar/2900 psi

Cleaning of Tools:

BAJAK TOOL CLEANER 99610

Indicated film thickness, wet: 140 microns/5.5 mils (See REMARKS overleaf)

Indicated film thickness, dry: 75microns/3 mils (See REMARKS overleaf)

Recoat Interval, min: 8 hours (25°C/77°F)

Recoat interval, max: 4 days (25°C/77°F)

BAJAPOX FLOW 73522

Surface Preparation: **New Steel, Spot Repair & Maintenance:** Remove oil and grease etc., with suitable detergent or cleaner. Remove salt and other contaminants by high pressure Fresh water cleaning. Abrasive blasting to minimum Sa 2½, SSPC-SP 10. Surface profile 50 microns , after blasting, clean the Surface carefully from abrasives and dust.

Application Conditions: Apply only on a dry and clean surface with a temperature Min. 3°C above the dew point to avoid condensation and relative humidity of below 85%. Use only where application and curing can proceed at temperatures above approximately 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. In confined spaces provide adequate ventilation during application and drying.

Preceding Coat: None

Subsequent Coat: None, or according to specification.

Remarks:

Service Temperature: Dry service temperature: max: 120°C/248°F
Dry peak temperature: max. 140°C/284°F.

Film Thickness: May be specified in another film thickness than indicated depending on purpose and area of use. Normal range is 75 Mic. (3 mil.). This will alter spreading rate and may influence drying time and recoating interval.

Pot-life: The pot life is dependent upon packing size and temperature. For temperature at 35°C/95°F the pot life will be reduced to approximately 180 minutes.

Note: **BAJAPOX FLOW 73522 is for professional use only.**

Safety: Packing is provided with applicable safety labels, which should be observed. In addition, Material Safety Data Sheet(s) should be consulted and national or local regulations should be followed. As a general rule, inhalation of solvent vapors or paint mist, and contact of liquid paint with skin and eyes should be avoided. Forced ventilation should be provided when applying paint in confined spaces or stagnant air. Even when ventilation is provided, respiratory, skin, and eye protection are always recommended when spraying paint. Necessary precautions against the risk of fire or explosion must be taken.



BAJAPOX 73524

CURING AGENT 63027

Formerly 35560

Description:	BAJAPOX 73524 is a solvent-free, two-component, high-build, polyamine adduct cured epoxy paint, which cures to a coating with good resistance to fresh water.
Recommended use:	As a lining in potable water tanks and pipelines. As a self-primed, high build coating primarily for areas subject to abrasion and/or to a highly corrosive environment; E.g. splash zones, jetty and bridge pilings and decks.
Service temperatures:	Maximum, dry exposure only: 140°C In fresh water (directly on steel): 45°C. (no temperature gradient)
Availability:	Part of Group Assortment. Local availability subject to confirmation.
Certificate / Approvals:	Approved by WRAS as a coating for potable water according to BS 6920 standard

PHYSICAL CONSTANTS:

Colours/Shade nos:	50900 / Light red (see REMARKS overleaf)
Finish:	Glossy
Solids Content, %:	100
Theoretical spreading rate:	5 m ² /l - 200 micron
Flash point:	100°C
Specific gravity:	1.3 kg/liter
Surface dry:	10 approx. hour(s) 20°C
Dry to touch:	7 day(s) 20°C
Fully cured:	7 days at 20°C
V.O.C.:	0 g/l

APPLICATION DETAILS:

Mixing ratio for 35530:	Base 73524 : Curing agent 63027 6.8 : 2 by volume
Application method:	Airless spray , Brush (touch up)
Thinner (max.vol.):	Do not dilute
Pot life:	1.5 hour(s) 20°C 45 minutes 35°C
Nozzle orifice:	0.021 "
Nozzle pressure:	220 bar [3190 psi] minimum. (Airless spray data are indicative and subject to adjustment)
Cleaning of tools:	BAJAK'S TOOL CLEANER 8000
Indicated film thickness, dry:	200 micron(See REMARKS overleaf)
Indicated film thickness, wet:	200 micron
Recoat interval, min:	See REMARKS overleaf and separate APPLICATION INSTRUCTIONS
Recoat interval, max:	See REMARKS overleaf and separate APPLICATION INSTRUCTIONS

Issued: **Nov. 2016**

2. BAJAPOX 73524

SURFACE PREPARATION: **New steel:** Remove oil and grease etc. thoroughly with suitable detergent. Remove salts and other contaminants by high pressure fresh water cleaning. Abrasive blasting to near white metal Sa 2½ (ISO 8501-1:2007) with a surface profile corresponding to Rug test No. 3, BN10a, Keane-Tator Comparator 3.0 G/S, or ISO Comparator Rough Medium (G). Apply immediately after cleaning. All damage of shop primer and contamination from storage and fabrication should be thoroughly cleaned prior to over coating.
Repair and maintenance: Remove oil and grease etc. thoroughly with suitable detergent. Remove salts and other contaminants by high pressure fresh water cleaning. Old steel surfaces having been exposed to salt water, excessive amounts of salt residues in putting's may call for abrasive blasting, high pressure fresh water hosing, drying, and finally, dry abrasive blasting again.
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, as per relevant painting specification.

APPLICATION CONDITIONS: Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation.
 Use only where application and curing can proceed at temperatures above:10°C. The temperature of the paint itself should be above:15°C. In-can temperature of the paint should preferably be below 30°C. Curing requires a relative humidity of: maximum 85%. For low temperatures (10-15°C), then the maximum relative humidity is: 65%. In confined spaces provide adequate ventilation during application and drying.

PRECEDING COAT: None, or as per specification.
 If a blast primer/hold-coat is required use: BAJAPOX 13520 (According to separate APPLICATION INSTRUCTIONS)

SUBSEQUENT COAT: None.

REMARKS
 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.

Film thicknesses: May be specified in another film thickness than indicated depending on purpose and area of use. This will alter spreading rate. Normal range for tanks: 200-400 micron.
 May be specified in film thicknesses up to 600 µm for controlled applications, e.g. on pipelines.

Over coating: Over coating intervals related to later conditions of exposure: If the maximum over coating interval is exceeded, roughening of the surface is necessary to ensure inter coat adhesion. Before over coating after exposure in contaminated environment, clean the surface thoroughly with high pressure fresh water hosing and allow drying.
 A specification supersedes any guideline overcoat intervals indicated in the table.

Environment SURFACE TEMPERATURE	Immersion					
	10°C		20°C		30°C	
BAJAPOX	Min	Max	Min	Max	Min	Max
		40 h	75 d	16 h	30 d	8 h

Note: **BAJAPOX 73524 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.

This Product Data Sheet supersedes those previously issued. For definition and scope, see explanatory notes to applicable Product Data Sheets. Data, specifications, directions and recommendations given in this data sheet represent only test results or experience obtained under controlled or specially defined circumstances. Their accuracy, completeness or appropriateness under the actual conditions of any intended use of the Products herein must be determined exclusively by the Buyer and/or User. The Products are supplied and all technical assistance is given subject to BAJAK's GENERAL CONDITIONS OF SALES, DELIVERY AND SERVICE, unless otherwise expressly agreed in writing. The Manufacturer and Seller disclaim, and Buyer and/or User waive all claims involving, any liability, including but not limited to negligence, except as expressed in said GENERAL CONDITIONS for all results, injury or direct or consequential losses or damages arising from the use of the Products as recommended above, on the overleaf or otherwise. Product data are subject to change without notice and become void five years from the date of issue.

Issued: Nov. 2016



BAJAPOX®SF 73525

CURING AGENT 63525

DESCRIPTION: **BAJAPOX SF 73525** is a two component, solvent free, inert pigmented polyamine cured epoxy phenolic paint with good wetting properties and low water permeability. It is self priming and forms a hard and tough coating which has good resistance against abrasion and impact as well as to seawater, mineral oils and aliphatic hydrocarbons. Application in thick coats by standard heavy duty hot dual airless spray equipment up to 500 micron/20 mils in one working process is possible

RECOMMENDED USE:

1. As an internal coating for steel pipe exposed to potable water.
2. As a tank coating for steel exposed to abrasion and/or severe corrosive environment

APPROVALS: Approved by Sharif University as a coating for potable water according to AWWA C210 and BS6920 standards.

AVAILABILITY: Subject to confirmation

PHYSICAL CONSTANTS:

Finish:	Semi-gloss to glossy.	
Color:	Mix product : Grey, Base 73525 : White ,Curing Agent 63525 : Black	
Shade No:	7340	
Volume by solid:	100%	
Theoretical:	2.5	m ² /litre-400 micron
Spreading rate:	100	sq.ft/US gallon 16mils
Flash point:	100/212	°C/°F Abel- pensky. close cup
Specific gravity:	1.35±0.05	kg/litre
	11.2	lbs/US gallon
Surface dry:	1 (approx.)	hours at 40 °C/104°F (ISO 1517)
Dry to touch:	2 (approx.)	hours at 40 °C/104°F
Fully cured:	7	days at 20 °C/68°F

The physical constants are subject to normal manufacturing tolerances. Further reference is made to "Explanatory Notes" in the BAJAK Book.

APPLICATION DETAILS:

Mixing Ratio:	BASE: BAJAPOX SF 73525 :	2 part by volume
	CURING AGENT 63525 :	1 part by volume
Application Method:	hot airless Spray	Brush (touch up)
Thinner (max. vol.):	not recommend	
Pot-Life:	6 min. at (60°C/140°F)	15 min. at (35°C/95°F)
Nozzle Orifice:	0.027" - 0.035"	(See application instructions)
Nozzle Pressure:	250 bar/3650 psi	(Airless spray data are indicative and subject to adjustment)
Cleaning of Tools:	BAJAK'S TOOL CLEANER 08027	(See REMARKS overleaf)
Indicated film thickness, wet:	500 microns/20 mils	
Indicated film thickness, dry:	500 microns/20 mils	(See REMARKS overleaf)
Recoat interval, min:	8 hours (20°C/68°F)	(See application instructions)
Recoat interval, max:	1 days (20°C/68°F)	(See application instructions)

BAJAPOX®SF 73525

Surface Preparation:	<p><u>Spot Repair & Maintenance:</u> Remove oil and grease etc., with suitable detergent. Remove salt and other contaminants by high pressure Fresh water cleaning. Abrasive blasting to minimum SA 2½, SSPC-SP 10. Surface profile corresponding to Rugotest No. 3, BN 11, Keane-tator comparator 5.5 GLS. After blasting, clean the surface carefully from abrasives and dust.</p> <p><u>On pit-corroded surfaces:</u> excessive amounts of salt residues may call for dry Abrasive blasting, high pressure fresh water hosing, drying, and finally, dry abrasive blasting again alternatively, jet-cleaning, drying and dry abrasive Blasting.</p>
Application Conditions:	Apply only on a dry and clean surface with a temperature 3°C above the dew point to avoid condensation. Use only where application and curing can proceed at Temperatures Above approximately 15°C/59°F. The temperature of the paint itself Should also be minimum 50 °C/59°F. In confined spaces Provide adequate Ventilation during application and drying.
Preceding Coat :	None, or BAJAPOX 12220
Subsequent Coat :	None, or according to specification.
Remarks:	Refer to separate APPLICATION INSTRUCTIONS.
Service Temperature:	Immersed service temperature: max: 50°C/122°F Dry service temperature: max. 130°C/266°F Buried service temperature: max. 80°C/176°F
Film Thickness:	May be specified in another film thickness than indicated depending on purpose and area of use. Normal range is 350-500 Mic. (14-20 mil.). This will alter spreading rate and may influence drying time and reciting interval. Concerning measurement of wet film thickness.
Pot-life:	The pot life is dependent upon temperature. For temperature at 35°C/95°Fthe pot life will be increased to approximately 15 minutes.
NOTE:	BAJAK®SF 73525 is for professional use only.
Safety:	Packing is provided with applicable safety labels, which should be observed. In addition, Material Safety Data Sheet(s) should be consulted and national or local regulations should be followed. As a general rule, inhalation of solvent vapors or paint mist, and contact of liquid paint with skin and eyes should be avoided. Forced ventilation should be provided when applying paint in confined spaces or stagnant air. Even when ventilation is provided, respiratory, skin, and eye protection are always recommended when spraying paint. Necessary precautions against the risk of fire or explosion must be taken.
Issued:	Feb. 2019

**BAJAPOX®SF 73525**

CURING AGENT 63525T

DESCRIPTION: **BAJAPOX SF 73525** is a two component, solvent free, inert pigmented polyamine cured epoxy phenolic paint with good wetting properties and low water permeability. It is self priming and forms a hard and tough coating which has good resistance against abrasion and impact as well as to seawater, mineral oils and aliphatic hydrocarbons

RECOMMENDED USE:

1. As a touch-up for internal coating for steel pipe exposed to potable water.
2. As a touch-up for tank coating for steel exposed to abrasion and/or severe corrosive environment

APPROVALS: Approved by Sharif University as a coating for potable water according to AWWA C210 and BS6920 standards .

AVAILABILITY: Subject to confirmation

PHYSICAL CONSTANTS:

Finish:	Semi-gloss to glossy.	
Color:	Grey	
Shade No:	7340	
Volume by solid:	100%	
Theoretical:	2.5	m ² /litre-400 micron
Spreading rate:	100	sq.ft/US gallon 16mils
Flash point:	100/212	°C/°F Abel- pensky. close cup
Specific gravity:	1.35±0.05	kg/litre
	11.2	lbs/US gallon
Surface dry:	2 (approx.)	hours at 40 °C/104°F (ISO 1517)
Dry to touch:	3 (approx.)	hours at 40 °C/104°F
Fully cured:	7	days at 20 °C/68°F

*The physical constants are subject to normal manufacturing tolerances.
Further reference is made to "Explanatory Notes" in the BAJAK Book.*

APPLICATION DETAILS:

Mixing Ratio:	BASE: BAJAPOX SF 73525 :	2 part by Weight
	CURING AGENT 63525T :	1 part by Weight
Application Method:	Brush (touch up)	
Thinner (max. vol.):	not recommend	
Pot-Life:	25 min. at (25°C/77°F)	
Cleaning of Tools:	BAJAK'S TOOL CLEANER 08027	(See REMARKS overleaf)
Indicated film thickness, wet:	500 microns/20 mils	
Indicated film thickness, dry:	500 microns/20 mils	(See REMARKS overleaf)
Recoat interval, min:	8 hours (20°C/68°F)	(See application instructions)
Recoat interval, max:	1 days (20°C/68°F)	(See application instructions)

BAJAPOX®SF 73525

Surface Preparation:	<u>Spot Repair & Maintenance:</u> Remove oil and grease etc., with suitable detergent. Remove salt and other contaminants by high pressure Fresh water cleaning. Power tools cleaning to minimum ST 3 and cleaning the surface carefully from dust.
Application Conditions:	Apply only on a dry and clean surface with a temperature 3°C above the dew point to avoid condensation. Use only where application and curing can proceed at Temperatures Above approximately 15°C/59°F. The temperature of the paint itself Should also be maximum 25 °C/77°F. In confined spaces Provide adequate Ventilation during application and drying.
Preceding Coat :	None, or BAJAPOX 12220
Subsequent Coat :	None, or according to specification.
Remarks:	Refer to separate APPLICATION INSTRUCTIONS.
Service Temperature:	Wet service temperature: max: 50°C/122°F Dry peak temperature: max. 100°C/212°F
Film Thickness:	May be specified in another film thickness than indicated depending on purpose and area of use. Normal range is 350-500 Mic. (14-20 mil.). This will alter spreading rate and may influence drying time and reciting interval. Concerning measurement of wet film thickness.
Pot-life:	The pot life is dependent upon temperature. For temperature at 20°C/68°Fthe pot life will be increased to approximately 30 minutes.
NOTE:	BAJAK®SF 73525 is for professional use only.
Safety:	Packing is provided with applicable safety labels, which should be observed. In addition, Material Safety Data Sheet(s) should be consulted and national or local regulations should be followed. As a general rule, inhalation of solvent vapors or paint mist, and contact of liquid paint with skin and eyes should be avoided. Forced ventilation should be provided when applying paint in confined spaces or stagnant air. Even when ventilation is provided, respiratory, skin, and eye protection are always recommended when spraying paint. Necessary precautions against the risk of fire or explosion must be taken.
Issued:	Feb. 2017



بازاڪ (سهامی خاص)

BAJAPOX MULTI-STRENGTH 73526

CURING AGENT 63526

Formerly 35530

Description:	BAJAPOX MULTI-STRENGTH 73526 is a solvent-free, two-component, high-build, polyamine cured epoxy paint, which cures to a coating with good resistance to fresh water, sea water, crude oil, and to abrasion. Applicable in thick coats by standard heavy duty airless spray equipment. Harmless to grain cargo.
Recommended use:	1. As a heavy duty coating on steel exposed to abrasion where solvent-free materials are required. Full colour retention will be of secondary importance. If solvent containing paints are accepted, BAJAPOX MULTI-STRENGTH 42526 substitutes. 2. As a lining in potable water tanks. Please see Certificates/Approvals. For application in warm climates. Please see APPLICATION CONDITIONS overleaf.
Service temperatures:	Dry: In fresh water (directly on steel): Maximum: 140°C 35°C (no temperature gradient) See REMARKS overleaf.
Availability:	Part of Group Assortment. Local availability subject to confirmation.
Certificate / Approvals:	Approved by WRAS as a coating for potable water according to BS 6920 standard
PHYSICAL CONSTANTS:	
Colours/Shade nos:	Grey/10500 - Red/51320
Finish:	Semi-gloss
Solids Content:	100 %
Theoretical spreading rate:	3.3 m ² /liter - 300 micron
Flash point:	100°C
Specific gravity:	1.3 kg/liter
Surface dry:	12 (approx.) hrs. at 20°C (ISO
Dry to touch:	1517) 24 (approx.) hours at 20°C
Fully cured:	7 days at 20°C
V.O.C.:	0 g/liter
Shelf life:	1 years (25°C/77°F) from time of production. Shelf life is depended on storage temperature.
APPLICATION DETAILS:	
Mixing ratio for 35530:	Base 73526 : Curing agent 63526 3 : 1 by volume Stir CURING AGENT before adding it to the BASE
Application method:	Airless spray , Brush (touch up) (Consult the separate APPLICATION INSTRUCTIONS)
Thinner (max.vol.):	Do not dilute (Consult the separate APPLICATION INSTRUCTIONS)
Pot life:	1 hour (20°C) (Consult the separate APPLICATION INSTRUCTIONS)
Nozzle orifice:	.019"-.031"
Nozzle pressure:	250 bar/3600 psi (Airless spray data are indicative and subject to adjustment)
Cleaning of tools:	BAJAK'S TOOL CLEANER 8000
Indicated film thickness, dry:	300 micron(See REMARKS overleaf)
Indicated film thickness, wet:	300 micron
Recoat interval, min:	See REMARKS overleaf and separate APPLICATION INSTRUCTIONS
Recoat interval, max:	See REMARKS overleaf and separate APPLICATION INSTRUCTIONS

Issued: Nov. 2016

2. BAJAPOX MULTI-STRENGTH 73526

SURFACE PREPARATION: When used as a heavy duty coating or in potable water tanks:
 Abrasive blasting to min. Sa 2½. Grit-blasted surfaces: recommended profile is Rz minimum 100 micron - maximum 150 micron corresponding to ISO Comparator Coarse (G). Oil and grease must be removed with suitable detergent, salts and other contaminants by (high pressure) fresh water hosing prior to blasting. After blasting, clean the surface carefully from abrasives and dust. On old steel surfaces having been exposed to salt water, excessive amounts of salt residues in pitting may call for abrasive blasting, high pressure fresh water hosing, drying, and finally, dry abrasive blasting again. Alternatively, water jetting may be used provided the steel surface has already the surface profile as described above.
 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, flame cleaning or acid etching. Seal surface with suitable sealer, eg BAJAPOX SEALER 23020 (furthermore, please see Product Data Sheet for 23020).

APPLICATION CONDITIONS: Use only where application and curing can proceed at temperatures above 10°C.
 The temperature of the paint itself must be above 15°C for proper application. In-can temperature of the paint should preferably be below 25°C.
 Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. Relative humidity max 85%.
 For application in warm climates, BAJAPOX MULTI-STRENGTH 42526 may preferably replace BAJAPOX MULTI-STRENGTH 73526 as a heavy duty coating. For potable water tanks please check local product assortment.

PRECEDING COAT: None, BAJAPOX SEALER 23020, BAJAPOX 13520 or according to specification.

SUBSEQUENT COAT: None, BAJAPOX or BAJATHANE qualities as per specification.

REMARKS
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.

Film thicknesses: 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 200-300 micron.

Recoating: Recoating intervals related to later conditions of exposure:
 (300 micron dry film thickness of BAJAPOX MULTI-STRENGTH 73526)

Physical data versus temperatures:				
	Minimum		Maximum	
SURFACE TEMPERATURE	20°C		20°C	
	Atmospheric	Water immersion	Atmospheric	Water immersion
Recoated with	Severe		Severe	
BAJAPOX	24 hours	24 hours	5 days	5 days
BAJATHANE	12 hours	Not relevant	24 hours	Not relevant

Mix and stir the two components until an even colour is achieved, where after the paint is ready for use. If improved colour stability is requested for exposure to sunshine, it is recommended to topcoat with e.g. BAJATHANE TOPCOAT 53551.

Potable water tanks: Do not put tanks into service before the coating is properly cured. When cured but before taking tank into use for potable water, fill twice with water, each time for a period of not less than 24 hours, and finally flush with fresh water. Alternatively hose down with warm fresh water (max. 50°C). Such cleaning may be subject to local/individual specification or regulation.

Note: **BAJAPOX MULTI-STRENGTH 73526 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.

This Product Data Sheet supersedes those previously issued. For definition and scope, see explanatory notes to applicable Product Data Sheets. Data, specifications, directions and recommendations given in this data sheet represent only test results or experience obtained under controlled or specially defined circumstances. Their accuracy, completeness or appropriateness under the actual conditions of any intended use of the Products herein must be determined exclusively by the Buyer and/or User. The Products are supplied and all technical assistance is given subject to BAJAK's GENERAL CONDITIONS OF SALES, DELIVERY AND SERVICE, unless otherwise expressly agreed in writing. The Manufacturer and Seller disclaim, and Buyer and/or User waive all claims involving, any liability, including but not limited to negligence, except as expressed in said GENERAL CONDITIONS for all results, injury or direct or consequential losses or damages arising from the use of the Products as recommended above, on the overleaf or otherwise. Product data are subject to change without notice and become void five years from the date of issue.

Issued: Nov. 2016

**BAJAPOX HB 73527**

CURING AGENT 63527HB

DESCRIPTION: **BAJAPOX HB 73527** is a two component, solvent free, inert pigmented polyamine cured epoxy paint with good wetting properties and low water permeability. It is self priming and forms a hard and tough coating which has good resistance against abrasion and impact as well as to seawater, mineral oils and aliphatic hydrocarbons. Application in thick coats by standard heavy duty hot dual airless spray equipment up to 1000 micron/40 mils in one working process is possible.

RECOMMENDED USE: 1_As an internal lining and external coating for buried steel pipe exposed to crude oil, sour gas and sea water.

2_As a tank coating for steel exposed to abrasion and/or severe corrosive environment.

AVAILABILITY: Subject to confirmation.

PHYSICAL CONSTANTS:

Finish:	Semi-gloss to glossy.	
Color:	White	
Shade No:	9000 series	
Volume by solid:	100%	
Theoretical	1.0 m ² /litre-600 micron	40 sq.ft/US gallon 40mils
Spreading rate:		
Flash point:	>100°C/212°F	Abel-pensky.close cup
Specific gravity:	1.5±0.05	kg/litre
	12.5±0.5	lbs/US gallon
Surface dry:	1 (approx.)	hours at 40 °C/104°F (ISO 1517)
Dry to touch:	2 (approx.)	hours at 40 °C/104°F
Fully cured:	7	days at 20 °C/68°F

The physical constants are subject to normal manufacturing tolerances. Further reference is made to "Explanatory Notes" in the BAJAK Book.

APPLICATION DETAILS:

Mixing Ratio:	BASE: BAJAPOX HB 73527	: 2 part by volume
	CURING AGENT 63527 HB	: 1 part by volume
Application Method:	hot airless Spray	Brush (touch up)
Thinner (max.vol):	not recommend	
Pot-Life:	6 min. at (60°C/140°F)	30 min. at (25°C/77°F)
Nozzle Orifice:	0.027" - 0.035"	(See application instructions)
Nozzle Pressure:	250 bar/3650 psi	(Airless spray data are indicative and subject to adjustment)
Cleaning of Tools:	BAJAK'S TOOL CLEANER 08020	
Indicated film thickness, wet:	1000 microns/40mils	(See REMARKS overleaf)
Indicated film thickness, dry:	1000 microns/40 mils	(See REMARKS overleaf)
Recoat interval, min:	8 hours (20°C/68°F)	(See application instructions)
Recoat interval, max:	3 days (20°C/68°F)	(See application instructions)

BAJAPOX 0HB 73527
Surface Preparation:

Spot Repair & Maintenance: Remove oil and grease etc., with suitable detergent. Remove salt and other contaminants by high pressure Fresh water cleaning. Abrasive blasting to minimum SA 2½, SSPC-SP 10. Surface profile corresponding to Rugotest No. 3, BN 11, Keane-After blasting, clean the Surface carefully from abrasives and dust.

Application Conditions:

On pit-corroded surfaces: excessive amounts of salt residues may call for dry Abrasive blasting, high pressure fresh water hosing, drying, and finally, dry abrasive blasting again alternatively, jet-cleaning, drying and dry abrasive Blasting.

Apply only on a dry and clean surface with a temperature 3°C above the dew point to avoid condensation. Use only where application and curing can proceed at Temperatures Above approximately 15°C/59°F. The temperature of the paint itself Should also be 60°C/140°F for 73527HB and be 40°C/104°F for 63527HB. In confined spaces Provide adequate Ventilation during application and drying.

Preceding Coat:

None, or BAJAPOX 12220

Subsequent Coat:

None, or according to specification.

Remarks:

Refer to separate APPLICATION INSTRUCTIONS.

Service Temperature:

Peak temperature: max. 120°C/248°F.

Film Thickness:

May be specified in another film thickness than indicated depending on purpose and area of use. Normal range is up to 1000 Mic. (40 mils). This will alter spreading rate and may influence drying and intervals times. Concerning measurement of wet film thickness,

Pot-life:

The pot life is dependent upon temperature. For temperature at 35°C/95°F the pot life will be increased to approximately 15 minutes.

NOTE:

BAJAK HB 73527 is for professional use only.

Safety:

Packing is provided with applicable safety labels, which should be observed. In addition, Material Safety Data Sheet(s) should be consulted and national or local regulations should be followed. As a general rule, inhalation of solvent vapors or paint mist, and contact of liquid paint with skin and eyes should be avoided. Forced ventilation should be provided when applying paint in confined spaces or stagnant air. Even when ventilation is provided, respiratory, skin, and eye protection are always recommended when spraying paint. Necessary precautions against the risk of fire or explosion must be taken.

REISSUED:

Dec. 2018



BAJAPOX®SF 73527

CURING AGENT 63527

DESCRIPTION:

BAJAPOX SF 73527 is a two component, solvent free, inert pigmented polyamine cured epoxy paint with good wetting properties and low water permeability. It is self priming and forms a hard and tough coating which has good resistance against abrasion and impact as well as to seawater, mineral oils and aliphatic hydrocarbons. Application in thick coats by standard heavy duty hot dual airless spray equipment up to 500 micron/20 mils in one working process is possible

RECOMMENDED USE:

1. As an internal coating for steel pipe exposed to potable water.
2. As a tank coating for steel exposed to abrasion and/or severe corrosive environment

Certificate / Approvals:

Approved by Power Research Center of IRAN (MATN) & Metra research institute as a coating for potable water according to AWWA C210 and BS6920 standards.

Subject to confirmation

Approved by **WRAS** from **UK** as a coating for potable water according to BS 6920 standard

PHYSICAL CONSTANTS:

Finish:	Semi-gloss to glossy.	
Color:	Light Green	
Shade No:	4050	
Volume by solid:	100%	
Theoretical:	2.5	m ² /litre-400 micron
Spreading rate:	100	sq.ft/US gallon 16mils
Flash point:	100/212	°C/°F Abel- pensky. close cup
Specific gravity:	1.43	kg/litre
	11.9	lbs/US gallon
Surface dry:	1 (approx.)	hours at 40 °C/104°F (ISO 1517)
Dry to touch:	2 (approx.)	hours at 40 °C/104°F
Fully cured:	7	days at 20 °C/68°F

The physical constants are subject to normal manufacturing tolerances. Further reference is made to "Explanatory Notes" in the BAJAK Book.

Shelf life:

1 years (25°C/77°F) from time of production.
Shelf life is depended on storage temperature.

APPLICATION DETAILS:

Mixing Ratio:	BASE: BAJAPOX SF 73527 :	2 part by volume
	CURING AGENT 63527 :	1 part by volume
Application Method:	hot airless Spray	Brush or roller (touch up)
Thinner (max. vol.):	not recommend	
Pot-Life:	6 min. at (60°C/140°F)	6 min. at (60°C/140°F)
Nozzle Orifice:	0.027" - 0.035"	(See application instructions)
Nozzle Pressure:	250 bar/3650 psi	(Airless spray data are indicative and subject to adjustment)
Cleaning of Tools:	BAJAK'S TOOL CLEANER 08027	(See REMARKS overleaf)
Indicated film thickness, wet:	500 microns/20 mils	
Indicated film thickness, dry:	500 microns/20 mils	(See REMARKS overleaf)
Recoat interval, min:	8 hours (20°C/68°F)	(See application instructions)
Recoat interval, max:	3 days (20°C/68°F)	(See application instructions)

BAJAPOX®SF 73527

Surface Preparation:	<p><u>Spot Repair & Maintenance:</u> Remove oil and grease etc., with suitable detergent. Remove salt and other contaminants by high pressure Fresh water cleaning. Abrasive blasting to minimum SA 2½, SSPC-SP 10. Surface profile corresponding to Rugotest No. 3, BN 11, Keane-tator comparator 5.5 GLS. After blasting, clean the surface carefully from abrasives and dust.</p> <p><u>On pit-corroded surfaces:</u> excessive amounts of salt residues may call for dry Abrasive blasting, high pressure fresh water hosing, drying, and finally, dry abrasive blasting again alternatively, jet-cleaning, drying and dry abrasive Blasting.</p>
Application Conditions:	Apply only on a dry and clean surface with a temperature 3°C above the dew point to avoid condensation. Use only where application and curing can proceed at Temperatures Above approximately 15°C/59°F. The temperature of the paint itself Should also be minimum 50 °C/59°F. In confined spaces Provide adequate Ventilation during application and drying.
Preceding Coat :	None, or BAJAPOX 12220
Subsequent Coat :	None, or according to specification.
Remarks:	Refer to separate APPLICATION INSTRUCTIONS.
Service Temperature:	Wet service temperature: max: 50°C/122°F Dry peak temperature: max. 100°C/212°F
Film Thickness:	May be specified in another film thickness than indicated depending on purpose and area of use. Normal range is 350-500 Mic. (14-20 mil.). This will alter spreading rate and may influence drying time and reciting interval. Concerning measurement of wet film thickness.
Pot-life:	The pot life is dependent upon temperature. For temperature at 35°C/95°Fthe pot life will be increased to approximately 15 minutes.
NOTE:	BAJAK®SF 73527 is for professional use only.
Safety:	Packing is provided with applicable safety labels, which should be observed. In addition, Material Safety Data Sheet(s) should be consulted and national or local regulations should be followed. As a general rule, inhalation of solvent vapors or paint mist, and contact of liquid paint with skin and eyes should be avoided. Forced ventilation should be provided when applying paint in confined spaces or stagnant air. Even when ventilation is provided, respiratory, skin, and eye protection are always recommended when spraying paint. Necessary precautions against the risk of fire or explosion must be taken.
Issued:	Jan. 2007

**BAJAPOX®SF 73527T**

CURING AGENT 63527T

DESCRIPTION: **BAJAPOX SF 73527T** is a two component, solvent free, inert pigmented polyamine cured epoxy paint with good wetting properties and low water permeability. It is self priming and forms a hard and tough coating which has good adhesion and surface wetting and resistance to water, mineral oils and aliphatic hydrocarbons. Application in thick coats by spatula to 500 micron/20 mils in one working process is possible

RECOMMENDED USE: As an internal coating for field joint and touch up of steel pipe exposed to potable water.

APPROVALS: Approved by Power Research Center of IRAN (MATN) , Sharif University and
AVAILABILITY: METRA as a coating for potable water according to AWWA C210 and BS6920 standards.
 Subject to confirmation

PHYSICAL CONSTANTS:

Finish:	Semi-gloss to glossy.	
Color:	Light Green	
Shade No:	4050	
Volume by solid:	100%	
Theoretical:	2.5	m ² /litre-400 micron
Spreading rate:	100	sq.ft/US gallon 16mils
Flash point:	>100/212	°C/°F Abel- pensky. close cup
Specific gravity:	1.43	kg/litre
	11.9	lbs/US gallon
Surface dry:	1 (approx.)	hours at 40 °C/104°F (ISO 1517)
Dry to touch:	2 (approx.)	hours at 40 °C/104°F
Fully cured:	7	days at 20 °C/68°F

*The physical constants are subject to normal manufacturing tolerances.
 Further reference is made to "Explanatory Notes" in the BAJAK Book.*

APPLICATION DETAILS:

Mixing Ratio:	BASE: BAJAPOX SF 73527T :	2 part by volume
	CURING AGENT 63527T :	1 part by volume
Application Method:	Spatula (field joint)	Brush (touch up)
Thinner (max. vol.):	not recommend	
Pot-Life:	30 min. at (20°C/68°F 500 gr)	
Sagging:	20 mils	
Cleaning of Tools:	BAJAK'S TOOL CLEANER 08027	(See REMARKS overleaf)
Indicated film thickness, wet:	400 microns/16 mils	
Indicated film thickness, dry:	400 microns/16 mils	(See REMARKS overleaf)
Recoat interval, min:	8 hours (20°C/68°F)	(See application instructions)
Recoat interval, max:	3 days (20°C/68°F)	(See application instructions)

BAJAPOX®SF 73527T

Surface Preparation:	<u>Spot Repair & Maintenance:</u> Remove oil and grease etc., with suitable detergent. Remove salt and other contaminants by high pressure Fresh water cleaning. Abrasive blasting to minimum SA 2½, SSPC-SP 10. Surface profile corresponding to Rugotest No. 3, BN 11, Keane-tator comparator 5.5 GLS. After blasting, clean the surface carefully from abrasives and dust.
Application Conditions:	Apply only on a dry and clean surface with a temperature at least 3°C above the dew point to avoid condensation. Use only where application and curing can proceed at Temperatures Above approximately 15°C/59°F. The temperature of the paint itself Should also be minimum 20 °C/68°F
Preceding Coat :	None, or BAJAPOX 12220
Subsequent Coat :	None, or according to specification.
Remarks:	Refer to separate APPLICATION INSTRUCTIONS.
Service Temperature:	Wet service temperature: max: 50°C/122°F Dry peak temperature: max. 100°C/212°F
Film Thickness:	May be specified in another film thickness than indicated depending on purpose and area of use. Normal range is 350-500 Mic. (14-20 mil.). This will alter spreading rate and may influence drying time and reciting interval. Concerning measurement of wet film thickness.
Pot-life:	The pot life is dependent upon temperature and amount. For temperature at 35°C/95°F the pot life will be decreased to approximately 15 minutes.
Packaging:	Each set of Base and Hardner pack is sufficient for application of one field joint.
NOTE:	BAJAK®SF 73527T is for professional use only.
Safety:	Packing is provided with applicable safety labels, which should be observed. In addition, Material Safety Data Sheet(s) should be consulted and national or local regulations should be followed. As a general rule, inhalation of solvent vapors or paint mist, and contact of liquid paint with skin and eyes should be avoided. Forced ventilation should be provided when applying paint in confined spaces or stagnant air. Even when ventilation is provided, respiratory, skin, and eye protection are always recommended when spraying paint. Necessary precautions against the risk of fire or explosion must be taken.
Issued:	Feb. 2007

**BAJAPOX®CT 73528**

CURING AGENT 63528

DESCRIPTION: **BAJAPOX CT 73528** is a two component, solvent free, inert pigmented polyamine cured coal tar epoxy paint with good wetting properties and low water permeability. It is self priming and forms a hard and tough coating which has good resistance against abrasion and impact as well as to seawater, mineral oils and aliphatic hydrocarbons. Application in thick coats by standard heavy duty hot dual airless spray equipment up to 600 micron/24mils in one working process is possible

RECOMMENDED USE:

1. As an internal coating for steel pipe exposed to water.
2. As a tank coating for steel exposed to abrasion and/or severe corrosive environment

APPROVALS:

AVAILABILITY: Subject to confirmation

PHYSICAL CONSTANTS:

Finish:	Semi-gloss to glossy.	
Color:	Dark Grey	
Shade No:	7345	
Volume by solid:	100%	
Theoretical:	1.67	m ² /litre-600 micron
Spreading rate:	67	sq.ft./US gallon 16mils
Flash point:	100/212	°C/°F Abel- pensky. close cup
Specific gravity:	1.35±0.05	kg/litre
	11.2	lbs/US gallon
Surface dry:	1 (approx.)	hours at 40 °C/104°F (ISO 1517)
Dry to touch:	2 (approx.)	hours at 40 °C/104°F
Fully cured:	7	days at 20 °C/68°F

The physical constants are subject to normal manufacturing tolerances. Further reference is made to "Explanatory Notes" in the BAJAK Book.

APPLICATION DETAILS:

Mixing Ratio:	BASE: BAJAPOX SF 73528 :	2 part by volume
	CURING AGENT 63528 :	1 part by volume
Application Method:	hot airless Spray	Brush (touch up)
Thinner (max. vol.):	not recommend	
Pot-Life:	6 min. at (60°C/140°F)	15 min. at (35°C/95°F)
Nozzle Orifice:	0.027" - 0.035"	(See application instructions)
Nozzle Pressure:	250 bar/3650 psi	(Airless spray data are indicative and subject to adjustment)
Cleaning of Tools:	BAJAK'S TOOL CLEANER 08027	(See REMARKS overleaf)
Indicated film thickness, wet:	600 microns/24mils	
Indicated film thickness, dry:	600 microns/24 mils	(See REMARKS overleaf)
Recoat interval, min:	8 hours (20°C/68°F)	(See application instructions)
Recoat interval, max:	1 days (20°C/68°F)	(See application instructions)

BAJAPOX®SF 73528

Surface Preparation:	<p><u>Spot Repair & Maintenance:</u> Remove oil and grease etc., with suitable detergent. Remove salt and other contaminants by high pressure Fresh water cleaning. Abrasive blasting to minimum SA 2½, SSPC-SP 10. Surface profile corresponding to Rugotest No. 3, BN 11, Keane-tator comparator 5.5 GLS. After blasting, clean the surface carefully from abrasives and dust.</p> <p><u>On pit-corroded surfaces:</u> excessive amounts of salt residues may call for dry Abrasive blasting, high pressure fresh water hosing, drying, and finally, dry abrasive blasting again alternatively, jet-cleaning, drying and dry abrasive Blasting.</p>
Application Conditions:	Apply only on a dry and clean surface with a temperature 3°C above the dew point to avoid condensation. Use only where application and curing can proceed at Temperatures Above approximately 15°C/59°F. The temperature of the paint itself Should also be minimum 50 °C/59°F. In confined spaces Provide adequate Ventilation during application and drying.
Preceding Coat :	None, or BAJAPOX 12220
Subsequent Coat :	None, or according to specification.
Remarks:	Refer to separate APPLICATION INSTRUCTIONS.
Service Temperature:	Wet service temperature: max: 50°C/122°F Dry peak temperature: max. 100°C/212°F
Film Thickness:	May be specified in another film thickness than indicated depending on purpose and area of use. Normal range is 450-600 Mic. (18-24 mil.). This will alter spreading rate and may influence drying time and reciting interval. Concerning measurement of wet film thickness.
Pot-life:	The pot life is dependent upon temperature. For temperature at 35°C/95°Fthe pot life will be increased to approximately 15 minutes.
NOTE:	BAJAK®SF 73528 is for professional use only.
Safety:	Packing is provided with applicable safety labels, which should be observed. In addition, Material Safety Data Sheet(s) should be consulted and national or local regulations should be followed. As a general rule, inhalation of solvent vapors or paint mist, and contact of liquid paint with skin and eyes should be avoided. Forced ventilation should be provided when applying paint in confined spaces or stagnant air. Even when ventilation is provided, respiratory, skin, and eye protection are always recommended when spraying paint. Necessary precautions against the risk of fire or explosion must be taken.
Issued:	Feb. 2015

**BAJAUREA®SF 73550**

CURING AGENT 63550

Description:

BAJAUREA SF 73550 is a two components, solvent free, inert pigmented pure polyurea paint with good wetting properties and low water permeability. It is self-priming and forms a hard and tough coating, which has good resistance against abrasion and impact as well as to seawater, mineral oils and wastewater. It displays outstanding physical properties and applicable in thick coats by heavy duty hot dual airless spray equipment up to 1000 microns/40 mils in one working process.

Recommended use:

- 1- As a humidity barrier on outer liner heat insulation foams.
- 2- As an abrasion resistance lining on concrete surfaces.
- 3- As an external coating for steel pipe exposed to soil and seawater.
- 4- As an internal coating for steel pipe exposed to waste water.

PHYSICAL CONSTANTS:

Mixed product:	73550
Colours/Shade no:	Grey – 7000 series
Finish:	Semi gloss to glossy
Volume Solids, %:	100
Theoretical spreading rate:	1m ² /litre – 1000 micron
Flash point:	Min. 100/212 C/F Abel-pensky. Close cup
Specific gravity:	1.1 (approx.) kg/litre
Surface dry:	60 (approx.) second at 23°C (ISO 1517)
Fully cured:	1 day at 23°C/68°F
Gel time:	8 - 10 second at 23°C
Shelf life:	12 months, Max temperature 25°C

APPLICATION DETAILS:

Mixing ratio for 73550:	Base BAJAUREA 73550:	1 part by volume
	Curing agent 63550:	1 part by volume
Application method:	Hot airless spray	
Thinner (max.vol.):	Not recommended	
Pot life:	5-10 sec. at (60°C/140°F)	
Nozzle orifice:	.027" - .035"	
Nozzle pressure:	200 bar/3000 psi (Airless spray data are indicative and subject to adjustment)	
Cleaning of tools:	BAJAK'S TOOL CLEANER 08055	
Indicative dft:	1000 microns/40 mils (See REMARKS overleaf)	
Indicative wft:	1000 microns/40 mils (See REMARKS overleaf)	
Recoat interval, min:	8 hours (20°C/68°F)	
Recoat interval, max:	3 days (20°C/68°F)	

2. BAJAUREA[®]SF 73550

SURFACE PREPARATION: Abrasive blasting to minimum Sa 2½, SSPC-SP 10. Surface profile corresponding to Rugotest No. 3, BN 11 according to Rugotest No. 3. After blasting, clean the surface carefully from abrasives and dust.

APPLICATION CONDITIONS: Apply only on a dry and clean surface. The product should be applied with heated plural component spray equipment such as products from Graco, WIWA. Experienced and motivated applicators should apply the product.

PRECEDING COAT: None, or BAJAPOX 12220

SUBSEQUENT COAT: None, or according to specification.

SERVICE TEMPERATURE: Wet service temperature : Max. : 50°C/122°F
Dry peak temperature : Max. : 150°C/302°F
Min. : -50°C/-58°F

Film thicknesses: May be specified in another film thickness than indicated depending on purpose and area of use. Normal thickness is 1000 Mic. (40 mil.). This will alter spreading rate and may influence drying time and reciting interval.

Typical properties:

Properties	Standard	Unit	Result
Hardness	DIN 53505	Shore D	45
Hardness	DIN 53505	Shore A	92
Tensile	DIN 53504	Mpa	21
Elongation	DIN 53504	%	420
Tear strength	DIN 53515	KN/m	65
Abrasion	ASTM D 4060	mg/1000 cycle C17	25

Pot life: The pot life is dependent upon temperature.

Note: **BAJAUREA[®]SF 73550 is for professional use only.**

Safety: Packing is provided with applicable safety labels, which should be observed. In addition, Material Safety Data sheet(s) should be consulted and national or local regulations should be followed. As a general rule, inhalation of solvent vapors or paint mist, and contact of liquid paint with skin and eyes should be avoided. Forced ventilation should be provided when applying paint in confined spaces or stagnant air. Even when ventilation is provided, respiratory, skin, and eye protection are always recommended when spraying paint. Necessary precautions against the risk of fire or explosion must be taken.

Issued: June 2008 – 73550



بازاک (سهامی خاص)

BAJAK PU-HYBRID SF 73553

CURING AGENT 63053

Description: BAJAK POLYURETHANE HYBRID SF73553 is a two component sprayable solvent free Polyurethane hybrid based on special polyol-poly amine and aromatic Isocyanate resins with an excellent abrasion resistance and flexibility on primed concrete and steel surfaces.

Recommended use: As lining on sealed concrete and primed buried steel substrates

Service temperature: Dry: Maximum 80°C Wet: Maximum 50°C

PHYSICAL CONSTANTS:

Colors/Shade No: Black RAL 9005
Finish: Glossy
Volume Solid: 100% (Curable material)
Weight Solid: 100% (Curable material)
Theoretical spreading rate: 1.0 m² /liter 1000 Mic. Dft.
Flash point: >96°C
Specific gravity: 1.05 – 1.10 kg/liter
Surface dry: Max. 10 min at 20°C (ISO 1517)
Dry to touch: Max. 15 min at 20°C
Fully cured: 2 days at 20°C
V.O.C.: 0 gr/liter
Shelf life: Base : 1 Year (25°C/77°F) from time of production. Depending on storage condition, mechanical stirring may be necessary before usage.
Hardner : 6 Mounth (25°C/77°F) from time of production..

APPLICATION DETAILS:

Mixing ratio for 73553 Base73553 : Curing agent 63055
1 : 1 by volume
Application method: Hot dual airless spray and gun
Thinner (max. vol.) Not recommend
Gel life: 10 sec. (60°C / 140°F)
Cleaning of tools: 08050
Indicated film thickness, dry: 1000 microns
Indicated film thickness, wet: 1000 microns
Recoat interval, min: 30 min (20°C)
Recoat interval, max: 2 days (20°C), See REMARKS overleaf

Issued: June 2009

2.BAJAK PU-HYBRID SF 73553

APPLICATION AND CURING CONDITIONS:	<p>CONCRETE : The surface must be completely clean and dry at the time of application and its temperature must be 5°C above the dew point to avoid condensation. Minimum temperature for curing is 5°C/41°F.</p> <p>At the freezing point and below, beware of the risk of ice on the surface which will hinder the adhesion. Condensation during application and the following 0.5 hours may adversely affect the film formation.</p> <p>STEEL : abrasive blast to SA2½ and minimum roughness of 60 µm.</p> <p>In confined spaces provide adequate ventilation during application and drying.</p>
PRECEDING COAT:	<p>BAJAK'S EPOXY SEALER 15026 for concrete</p> <p>BAJAK'S EPOXYPRIMER 15300 for steel</p>
SUBSEQUENT COAT:	None or BAJATHANE 55210 for decorative purposes or outdoor uses.
REMARKS:	
Film thicknesses:	<p>May be specified in another film thickness than indicated depending on purpose and area of use.</p> <p>This will alter spreading rate and may influence drying time and recoating interval. Normal range is 1000 microns/40 mils.</p>
Thinning:	Not recommend.
Physical property:	

Type of Physical property:	Result	Unit	Standard
Pressure strength	600	Kgf/cm ²	ASTM D695M
Elongation at break	Min. 12	%	ISO 527
Hardness (Persoz)	Min. 200	Sec	ASTM D4366
Abrasion Resistance	Max. 25 mg	1000 cycle CS17	ASTM D4060
Adhesion pull off on steel (Min.)	1500	Psi	ASTM D4541
Shore hardness	60-70	Shore D	ASTM 2240
Flexibility	≥5	%	EN10290-Annex K
Cathodic disbondment (30 days/23°C)	≤8 length	mm	EN10290-Annex E
Specific coating resistivity (100 days/23°C)	≥10 ⁸ (1000 mic dft)	Ωm ²	EN10290-Annex F

A completely clean surface is mandatory to ensure intercoat adhesion, especially at long recoating intervals. Any dirt, oil, and grease have to be removed, e.g. with suitable detergent.

Salts to be removed by fresh water hosing. To check an adequate quality of the surface cleaning a test patch is recommended before actual recoating.

SAFETY:	<p>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 and national safety regulations. Harmful or fatal if swallowed; immediately seek medical assistance swallowed. Avoid inhalations of possible solvent vapors or paint mist, as well as paint contact with skin and eyes. Apply only on well-ventilated areas and ensure that adequate forced ventilation exists when applying paint in confined spaces or when the air is stagnant. Always take precautions against the risks of fire and explosions.</p>
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Issued: June 2009



بازاک (سهامی خاص)

BAJAK POLYURETHANE SF 73555

CURING AGENT 63055

Description: BAJAK POLYURETHANE SF73555 is a two component sprayable solvent free Polyurethane based on special polyol and aromatic Isocyanate resins with an excellent abrasion resistance and flexibility on sealed concrete and steel surfaces.

Recommended use: As lining on sealed concrete and buried steel substrates.

Service temperature: Dry: Maximum 80°C Wet: Maximum 50°C

PHYSICAL CONSTANTS:

Colors/Shade No: Grey /7280
Finish: Glossy
Volume Solid: 100% (Curable material) (ISO 3233)
Weight Solid: 100% (Curable material) (ISO 3233)
Theoretical spreading rate: 1.0 m² /liter 1000 Mic. Dft.
Flash point: > 100°C
Specific gravity: 1.30 – 1.35 kg/liter
Dry to touch: Max. 1 hours at 20°C
Hard Dry: Max. 4 hours at 20°C
Fully cured: 7 days at 20°C
V.O.C.: 0 gr/liter
Shelf life: Base : 2 Years (25°C/77°F) from time of production. Depending on storage condition, mechanical stirring may be necessary before usage.
Hardner : 12 Mounth (25°C/77°F) from time of production..

APPLICATION DETAILS:

Mixing ratio for 73555 Base73555 : Curing Agent 63055
2.5 : 1 by volume
Application method: Hot dual airless spray
Thinner (max. vol.) Not recommend
Pot life: 10 min. (60°C / 140°F) 50 ml
Cleaning of tools: 08050
Indicated film thickness, dry: 1500 microns
Indicated film thickness, wet: 1500 microns
Recoat interval, min: 4 hours (20°C)
Recoat interval, max: 24 hours (20°C), See REMARKS overleaf

Issued: April 2011

2.BAJAK POLYURETHANE SF 73555

APPLICATION AND CURING CONDITIONS:	<p>CONCRETE : The surface must be completely clean and dry at the time of application and its temperature must be min 5 °C above the dew point to avoid condensation. Minimum temperature for curing is 5°C/41°F.</p> <p>At the freezing point and below, beware of the risk of ice on the surface which will hinder the adhesion. High humidity and/or condensation during application and the following 16 hours (20°C/68°F) may adversely affect the film formation. Maximum concrete moisture content should be 4%.</p> <p>STEEL : abrasive blast to SA2½ and minimum roughness of 60 µm.</p> <p>In confined spaces provide adequate ventilation during application and drying.</p>
PRECEDING COAT:	<p>For concrete : BAJAK'S EPOXY SEALER 15026</p> <p>For steel : None , or BAJAK'S EPOXYPRIMER 15300 as per spec.</p>
SUBSEQUENT COAT:	None or BAJATHANE 55210 for decorative purposes or outdoor uses.
REMARKS:	
Film thicknesses:	<p>May be specified in another film thickness than indicated depending on purpose and area of use.</p> <p>This will alter spreading rate and may influence drying time and recoating interval. Normal range is 1500 microns/60 mils.</p>
Thinning:	Not recommend.
Physical property:	

Type of Physical property:	Result	Unit	Standard
Pressure strength	600	Kgf/cm2	ASTM D695M
Elongation at break	Min. 12	%	ISO 527
Hardness (Persoz)	Min. 200	Sec	ASTM D4366
Abrasion Resistance	Max. 50 mg	1000 cycle CS17	ASTM D4060
Adhesion pull off on steel (Min.)	> 1500	Psi	ASTM D4541
Hardness Shore D	65-75	Shore D	ASTM 2240
Flexibility	≥5	%	EN10290-Annex K
Cathodic disbondment (30 days/23 °C)	≤8	mm	EN10290-Annex E
Specific coating resistivity (100 days/23 °C)	≥10 ⁸ (1000 mic dft)	Ωm ²	EN10290-Annex F

A completely clean surface is mandatory to ensure intercoat adhesion, especially at long recoating intervals. Any dirt,oil,and grease have to be removed, e.g. with suitable detergent.

Salts to be removed by fresh water hosing. To check an adequate quality of the surface cleaning a test patch is recommended before actual recoating.

SAFETY:	<p>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 and national safety regulations. Harmful or fatal if swallowed; immediately seek medical assistance swallowed. Avoid inhalations of possible solvent vapors or paint mist, as well as paint contact with skin and eyes. Apply only on well-ventilated areas and ensure that adequate forced ventilation exists when applying paint in confined spaces or when the air is stagnant. Always take precautions against the risks of fire and explosions.</p>
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Issued:	April 2011
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بازاک (سهامی خاص)

Application Instructions

BAJAK'S POLYURETHANE SF 73555

CURING AGENT 63055

Scope:

These Application Instructions cover surface preparation, application equipment, application details and repair for BAJAK'S POLYURETHANE SF 73555.

Preparation of the metal surface:

Surface preparation is a very important phase and must be carried out with particular care. The quality of the stripping and dust removal phases has a considerable influence on the adhesion performance of the coating.

Before blasting any deposits of grease or oil must be removed from the steel surface with a suitable detergent followed by fresh water hosing. Minor spots of oil/grease may be cleaned with thinner and clean rags - avoid smearing out the contamination. Possible alkali weld deposits, chemicals used for testing of welds, soap residues from the pressure testing must be removed by fresh water hosing.

Contaminants should be eliminated by any appropriate means and products that are compatible with the coating to be applied.

Before blasting, old steel surfaces must be checked for any contamination. Possible blisters must be broken. If thick rust scale has been removed or deep pittings have been encountered, control procedures for contamination must be carried out. If still contaminated, the abrasive blast cleaned steel surface will need a repeated cleaning for salts and/or oil/grease followed by final abrasive blast cleaning. Spot-checking for possible salt contamination of the surface to be executed before and after abrasive sweep blasting.

When blasting, the importance of working systematically must be stressed. Poorly blasted areas covered with dust are very difficult to locate during the blast inspection made after the rough cleaning.

The substrates to be coated should be blast cleaned by projection of abrasives so as to obtain minimum a Sa 2½ surface finish (ISO 8501-1). The abrasive should be chosen to obtain an ideally angular surface roughness profile and must not contain more than 0.05% of water soluble materials. The compressed air must be dry and oil-free. The abrasive cleaned surface must have a roughness Rz (ISO 8503-4) of around 70 µm or the surface profile must be equivalent to Rugotest No. 3, BN9-BN10 or Keane-Tator Comparator, 3.0 G/S. According to ISO 8503-1 the grade will be MEDIUM (G).

And it must be coated in as short a time as possible. It is recommended that the following times are not exceeded:

- 2 hours for a relative humidity above 70%
- 6 hours for a relative humidity below 70%.

After abrasive cleaning, the surface must be inspected. Any slivers, scale, weld splatter and imperfections made visible by the abrasive cleaning must be eliminated. If after preparing the surface to be coated, it becomes contaminated or covered with rust, it must be partially or totally abrasive cleaned once again in order to enable application of the coating in accordance with all of the previous instructions.

Before applying the coating, any abrasive remaining on the surface must be eliminated by an appropriate procedure and the surface to be coated must be dry and free of any soiling (such as existing coatings, paints and non-adherent particles, grease, oil, etc.) that can adversely affect surface preparation.

If an adjacent coating is to be over-coated, the area in question should be roughened or finely abrasive blasted to promote inter-coat adhesion. In the case of a very thick coating, the edge should be chamfered. This operation should be followed by careful removal of dust. In the case of a polyolefin coating (polyethylene or polypropylene), the chamfered area should be flame treated at a temperature between 120°C and 160°C for 5 to 10 seconds.

The maximum allowable concentration of chlorides on steel surfaces immediately before application is 20 mg/m² as detected by the "Bresle Method".

In the case of contamination, cleaning procedures must be repeated and/or improved. Especially pit-corroded steel will need special attention and the only possible way to remove contamination from the pits may often be to carry out very thorough cleaning with fresh water after abrasive blast cleaning. After repeated control and drying, the entire surface will need abrasive blast cleaning to obtain the specified degree of cleaning. Alternatively, the pit-corroded areas are cleaned by water jet, any surplus of water is mopped up or removed by vacuum cleaning. Allow to dry.

Application:

The temperature of the substrate should be between + 10°C and + 60°C and maintained at least 5°C above the dew point during the application and drying of BAJAK'S POLYURETHANE SF 73555 in order to avoid any condensation.

The ambient temperature should be between + 10°C and + 40°C and the relative humidity should not exceed 80 %.

To accelerate the hardening of the coating, the substrate may be preheated to between 30 and 60°C. The time the substrate is heated should not lead to any surface oxidation, which can adversely affect the good quality and resistance of the coating.

BAJAK'S POLYURETHANE SF 73555 is applied by airless spray (minimum 250 bars pressure, 24 to 43/1000" nozzles) in two or three passes, with spray equipment that enables automatic and controlled metering and mixing of the two components (by volume: 2.5 part A, 1 part B) and also enables the temperature of both components to be maintained (part A: 50°C to 70°C - part B: 20°C to 40°C) from the storage tanks to the spray gun. During application, the wet film thickness should be measured using, for example, method n° 6 of the ISO 2808 Standard.

The compressed air used in the application equipment must be dry and oil-free. While in use, the drums should be stored under shelter.

Since the pot life of the mixture is only several seconds at 60°C, the application equipment should be immediately rinsed and cleaned after use with Thinner 77885.

To accelerate hardening, post-curing at 80°C is possible.

In the case of pipes, in order not to adversely affect the good quality of the weld or coating, the length of the uncoated ends should be around 50 to 100 mm. The film attains a sufficient level of hardness to be handled after around 10 to 15 minutes. This time depends on the ambient temperature, the weight and the shape of the coated parts.

Control of the coating:

When the film has attained a sufficient degree of hardness (minimum 4 h at 20°C), the following controls should be carried out:

- The appearance and the continuity of the entire coating should be visually inspected. The coating should have a uniform color and appearance, exempt of any defects that could adversely affect the quality of the coating.
- The thickness of the coating measured according to the EN10290 Standard, Appendix A should comply in every respect with the contract or the specification.
- The non-porosity of the coating should be checked using the EN 10290 Standard, appendix B. The applied voltage should be 8 volts per micron of dry film thickness with a maximum of 20 KV.
- The Shore D hardness (ISO 868 Standard) of the coating should be measured and must be at least 70.

Repairs:

All defects should be repaired with BAJAK'S 73552 two component touch-up polyurethane paste. The defect area should be stripped bare. All non-adherent elements should be removed. The area of overlap with the adjacent coating should be roughened. In the case of a very thick coating, the edge should be chamfered.

These operations should be followed by careful removal of dust.

All repairs should be controlled again for porosity and thickness as described above.

2.BAJAK POLYURETHANE SF 73555

APPLICATION AND CURING CONDITIONS:	<p>CONCRETE : The surface must be completely clean and dry at the time of application and its temperature must be min 5 °C above the dew point to avoid condensation. Minimum temperature for curing is 5°C/41°F.</p> <p>At the freezing point and below, beware of the risk of ice on the surface which will hinder the adhesion. High humidity and/or condensation during application and the following 16 hours (20°C/68°F) may adversely affect the film formation. Maximum concrete moisture content should be 4%.</p> <p>STEEL : abrasive blast to SA2½ and minimum roughness of 60 µm.</p> <p>In confined spaces provide adequate ventilation during application and drying.</p>
PRECEDING COAT:	<p>For concrete : BAJAK'S EPOXY SEALER 15026</p> <p>For steel : None , or BAJAK'S EPOXYPRIMER 15300</p>
SUBSEQUENT COAT:	None or BAJATHANE 55210 for decorative purposes or outdoor uses.
REMARKS: Film thicknesses:	<p>May be specified in another film thickness than indicated depending on purpose and area of use.</p> <p>This will alter spreading rate and may influence drying time and recoating interval. Normal range is 1500 microns/60 mils.</p>
Thinning: Physical property:	Not recommend.

Type of Physical property:	Result	Unit	Standard
Pressure strength	600	Kgf/cm2	ASTM D695M
Elongation at break	Min. 12	%	ISO 527
Hardness (Persoz)	Min. 200	Sec	ASTM D4366
Abrasion Resistance	Max. 50 mg	1000 cycle CS17	ASTM D4060
Adhesion pull off on steel (Min.)	> 1500	Psi	ASTM D4541
Shore hardness	60-70	Shore D	ASTM 2240
Flexibility	Pass		EN10290-Annex K
Cathodic disbondment (30 days/23 °C)	≤8 length	mm	EN10290-Annex E
Specific coating resistivity (100 days/23 °C)	≥10 ⁸ (1000 mic dft)	Ωm ²	EN10290-Annex F

A completely clean surface is mandatory to ensure intercoat adhesion, especially at long recoating intervals. Any dirt,oil,and grease have to be removed, e.g. with suitable detergent.

Salts to be removed by fresh water hosing. To check an adequate quality of the surface cleaning a test patch is recommended before actual recoating.

SAFETY:	<p>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 and national safety regulations. Harmful or fatal if swallowed; immediately seek medical assistance swallowed. Avoid inhalations of possible solvent vapors or paint mist, as well as paint contact with skin and eyes. Apply only on well-ventilated areas and ensure that adequate forced ventilation exists when applying paint in confined spaces or when the air is stagnant. Always take precautions against the risks of fire and explosions.</p>
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Issued: April 2011



بازاک (سهامی خاص)

BAJAK POLYURETHANE 73556

CURING AGENT 63055

Description: BAJAK POLYURETHANE 73556 is a two component sprayable high solid Polyurethane based on special polyol and aromatic Isocyanate resins with an excellent abrasion resistance and flexibility on primed concrete and steel surfaces.

Recommended use: As lining on sealed concrete and buried steel substrates.

Service temperature: Dry: Maximum 80°C Wet: Maximum 50°C

PHYSICAL CONSTANTS:

Colors/Shade No: Light Grey RAL 7035/7153
Finish: Glossy
Volume Solid: 90% (Curable material)
Weight Solid: 93% (Curable material)
Theoretical spreading rate: 2.6 m² /liter 350 Mic. Dft.
Flash point: 26°C
Specific gravity: 1.20 – 1.3 kg/liter
Surface dry: Max. 16 hours at 20°C (ISO 1517)
Dry to handle: Max. 24 hours at 20°C
Fully cured: 7 days at 20°C
V.O.C.: 85 gr/liter
Shelf life: Base : 1 Year (25°C/77°F) from time of production. Depending on storage condition, mechanical stirring may be necessary before usage.
Hardner : 6 Mounth (25°C/77°F) from time of production..

APPLICATION DETAILS:

Mixing ratio for 73555 Base73555 : Curing agent 63055
3 : 1 by weight
Application method: Airless spray
Thinner (max. vol.) Not recommend
Pot life: 30 min. (25°C / 77°F)
Cleaning of tools: 08050
Indicated film thickness, dry: 350 microns
Indicated film thickness, wet: 400 microns
Recoat interval, min: 24 hours (20°C)
Recoat interval, max: 7 days (20°C), See REMARKS overleaf

Issued: Aug 2010

2.BAJAK POLYURETHANE 73556

APPLICATION AND CURING CONDITIONS:	<p>CONCRETE : The surface must be completely clean and dry at the time of application and its temperature must be min 5 °C above the dew point to avoid condensation. Minimum temperature for curing is 5°C/41°F.</p> <p>At the freezing point and below, beware of the risk of ice on the surface which will hinder the adhesion. High humidity and/or condensation during application and the following 16 hours (20°C/68°F) may adversely affect the film formation. Maximum concrete moisture content should be 4%.</p> <p>STEEL : abrasive blast to SA2½ and minimum roughness of 60 µm.</p> <p>In confined spaces provide adequate ventilation during application and drying.</p>
PRECEDING COAT:	<p>BAJAK'S EPOXY SEALER 15026 for concrete</p> <p>BAJAK'S EPOXYPRIMER 15300 for steel</p>
SUBSEQUENT COAT:	None or BAJATHANE 55210 for decorative purposes or outdoor uses.
REMARKS: Film thicknesses:	<p>May be specified in another film thickness than indicated depending on purpose and area of use.</p> <p>This will alter spreading rate and may influence drying time and recoating interval. Normal range is 350microns/14 mils.</p>
Thinning: Physical property:	<p>Not recommend.</p> <p>DFT 2x350 micron</p>

Type of Physical property:	Result	Unit	Standard
Pressure strength	600	Kgf/cm2	ASTM D695M
Elongation at break	Min. 12	%	ISO 527
Hardness (Persoz)	Min. 200	Sec	ASTM D4366
Abrasion Resistance	Max. 25 mg	1000 cycle CS17	ASTM D4060
Adhesion pull off on steel (Min.)	> 1500	Psi	ASTM D4541
Shore hardness	60-70	Shore D	ASTM 2240
Flexibility	≥5	%	EN10290-Annex K
Cathodic disbondment (30 days/23 °C)	≤8 length	mm	EN10290-Annex E
Specific coating resistivity (100 days/23 °C)	≥10 ⁸ (1000 mic dft)	Ωm ²	EN10290-Annex F

A completely clean surface is mandatory to ensure intercoat adhesion, especially at long recoating intervals. Any dirt,oil,and grease have to be removed, e.g. with suitable detergent.

Salts to be removed by fresh water hosing. To check an adequate quality of the surface cleaning a test patch is recommended before actual recoating.

SAFETY:	<p>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 and national safety regulations. Harmful or fatal if swallowed; immediately seek medical assistance swallowed. Avoid inhalations of possible solvent vapors or paint mist, as well as paint contact with skin and eyes. Apply only on well-ventilated areas and ensure that adequate forced ventilation exists when applying paint in confined spaces or when the air is stagnant. Always take precautions against the risks of fire and explosions.</p>
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Issued: Aug 2010



بازاک (سهامی خاص)

BAJAK POLYURETHANE TU 73557

CURING AGENT 63055

Description: BAJAK POLYURETHANE TU73557 is a two component touch up grade solvent free Polyurethane based on special polyol and aromatic Isocyanate resins with an excellent abrasion resistance and flexibility on primed concrete and steel surfaces.

Recommended use: As touch up on PU lining.

Service temperature: Dry: Maximum 80°C Wet: Maximum 50°C

PHYSICAL CONSTANTS:

Colors/Shade No: Grey /7280
Finish: Glossy
Volume Solid: 100% (Curable material) (ISO 3233)
Weight Solid: 100% (Curable material) (ISO 3233)
Theoretical spreading rate: 1.0 m² /liter 1000 Mic. Dft.
Flash point: > 100°C
Specific gravity: 1.30 - 1.40 kg/liter
Dry to touch: Max. 1 hours at 20°C
Hard Dry: Max. 4 hours at 20°C
Fully cured: 7 days at 20°C
V.O.C.: 0 gr/liter
Shelf life: Base : 2 Years (25°C/77°F) from time of production. Depending on storage condition, mechanical stirring may be necessary before usage.
Hardner : 12 Mounth (25°C/77°F) from time of production..

APPLICATION DETAILS:

Mixing ratio for 73555 Base73555 : Curing Agent 63055
3 : 1 by volume
Application method: Hot dual airless spray
Thinner (max. vol.) Not recommend
Pot life: 20 min. (30°C / 86°F) 50 ml
Cleaning of tools: 08050
Indicated film thickness, dry: 1500 microns
Indicated film thickness, wet: 1500 microns
Recoat interval, min: 4 hours (20°C)
Recoat interval, max: 24 hours (20°C), See REMARKS overleaf

Issued: April 2011

2.BAJAK POLYURETHANE TU 73557

APPLICATION AND CURING CONDITIONS:
PRECEDING COAT:

Abrade with sandpaper No. 60 or 80 defect area and at least 50 mm around of defected area

For concrete : BAJAK'S EPOXY SEALER 15026

For steel : None , or BAJAK'S EPOXYPRIMER 15300

SUBSEQUENT COAT:

None or BAJATHANE 55210 for decorative purposes or outdoor uses.

REMARKS:
Film thicknesses:

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 is 1000 microns/40 mils.

Thinning:
Physical property:

Not recommend.

Type of Physical property:	Result	Unit	Standard
Pressure strength	600	Kgf/cm2	ASTM D695M
Elongation at break	25 - 50	%	ISO 527
Hardness (Persoz)	Min. 200	Sec	ASTM D4366
Abrasion Resistance	Max. 50 mg	1000 cycle CS17	ASTM D4060
Adhesion pull off on steel (Min.)	> 1500	Psi	ASTM D4541
Hardness Shore D	50-60	Shore D	ASTM 2240
Flexibility	≥5	%	EN10290-Annex K
Cathodic disbondment (30 days/23°C)		mm	EN10290-Annex E
Specific coating resistivity (100 days/23°C)	≥10 ⁸ (1000 mic dft)	Ωm ²	EN10290-Annex F

A completely clean surface is mandatory to ensure intercoat adhesion, especially at long recoating intervals. Any dirt,oil,and grease have to be removed, e.g. with suitable detergent.

Salts to be removed by fresh water hosing. To check an adequate quality of the surface cleaning a test patch is recommended before actual recoating.

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 and national safety regulations. Harmful or fatal if swallowed; immediately seek medical assistance swallowed. Avoid inhalations of possible solvent vapors or paint mist, as well as paint contact with skin and eyes. Apply only on well-ventilated areas and ensure that adequate forced ventilation exists when applying paint in confined spaces or when the air is stagnant. Always take precautions against the risks of fire and explosions.

Issued: April 2011

BAJAPOX® GF 73726

CURING AGENT 63726

DESCRIPTION: **BAJAPOX GF 73726** is a two component, high solids, glass flake pigmented polyamine cured modified epoxy paint with good wetting properties and low water permeability. It is self priming and forms a hard and tough coating which has good resistance against abrasion and impact as well as to seawater, mineral oils, aliphatic hydrocarbons and splashes from petrol, jet fuel, lubrication oil and related products. Application in thick coats by standard heavy duty airless spray equipment up to 500 micron/20 mils in one working process is possible.

RECOMMENDED USE: As a coating for steel exposed to abrasion and/or severe corrosive environment.
As a self-primed, high build coating primarily for areas subject to abrasion and/or to a highly corrosive environment. e.g. splash zones, jetty pilings, crude oil and condensate tanks, and working decks.

APPROVALS: Approved by COT according to Norsok M501 system #7

PHYSICAL CONSTANTS:

Colours:	Grey	
Finish:	Semi-gloss. Slightly structured Surface.	
Volume by solid:	90%	
Theoretical	1.8	m2/litre-500 micron
Spreading rate:		
Flash point:	25°C	Abel-pensky.close cup
Specific gravity:	1.4	kg/litre
Surface dry:	5 (approx.)	hours at 20 °C (ISO 1517)
Dry to touch:	6 (approx.)	hours at 20 °C
Fully cured:	7	days at 20 °C

APPLICATION DETAILS:

Mixing Ratio:	BASE: BAJAPOX GF 73726	3.3 part by volume
	CURING AGENT: 63726	1.0 part by volume
Application Method:	Airless Spray	Brush (See application instructions)
Thinner (max.vol):	It is recommended not to use any thinning as this may delay the drying and curing. If deemed necessary, anyhow up to 2% methel ethyl ketone may be used.	
Pot-Life:	1 hour (20°C)	1 1/2 hours (20°C) (See REMARKS overleaf)
Nozzle Orifice:	0.045" reversible nozzle	(See application instructions)
Nozzle Pressure:	250 bar/3600 psi	
Cleaning of Tools:	BAJAK TOOL CLEANER 99610	
Indicated film thickness, wet:	550 microns/22mils	(See REMARKS overleaf)
Indicated film thickness, dry:	500 microns/20 mils	(See REMARKS overleaf)
Recoat Interval, min:	12 hours (20°C)	(See application instructions)
Recoat interval, max:	4 days (20°C)	(See application instructions)

BAJAPOX® GF 73726

- Surface Preparation:** **Spot Repair & Maintenance:** Remove oil and grease etc., with suitable detergent. Remove salt and other contaminants by high pressure Fresh water cleaning. Abrasive blasting to minimum Sa 2½, SSPC-SP 10. Surface profile corresponding to Rugotest No. 3, BN 11, Keane-After blasting, clean the Surface carefully from abrasives and dust.
- On pit-corroded surfaces:** excessive amounts of salt residues may call for dry Abrasive blasting, high pressure fresh water hosing, drying, and finally, dry abrasive blasting again alternatively, jet cleaning, drying and dry abrasive Blasting.
- Application Conditions:** Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. Use only where application and curing can proceed at Temperatures above approximately 15°C. The temperature of the paint itself should also be minimum 15°C. At high temperature 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 BAJAPOX 15590
- Subsequent Coat:** None, or according to specification.
- Remarks:** Refer to separate APPLICATION INSTRUCTIONS.
- Service Temperature:** Dry service temperature: max: 120°C
Dry peak temperature: max. 140°C
- Film Thickness:** May be specified in another film thickness than indicated depending on purpose and area of use. Normal range is 500-1000 Mic.. This will alter spreading rate and may influence drying time and reciting interval. Concerning measurement of wet film thickness, please consult separate APPLICATION INSTRUCTIONS. For optimum performance two layers, each 500 micron/20 mils dry film thickness is recommended.
- Pot-life:** The pot life is dependent upon packing size and temperature. For temperature at 35°C the pot life will be reduced to approximately 15 minutes.
- Note:** **BAJPOX GF 73726 is for professional use only.**
- Safety:** Packing is provided with applicable safety labels, which should be observed. In addition, Material Safety Data Sheet(s) should be consulted and national or local regulations should be followed. As a general rule, inhalation of solvent vapors or paint mist, and contact of liquid paint with skin and eyes should be avoided. Forced ventilation should be provided when applying paint in confined spaces or stagnant air. Even when ventilation is provided, respiratory, skin, and eye protection are always recommended when spraying paint. Necessary precautions against the risk of fire or explosion must be taken.

BAJAPOX® GF 73727

CURING AGENT 63726

DESCRIPTION:

BAJAPOX GF 73727 is a two component, high solids, glass flake pigmented polyamine cured modified epoxy novolac paint with good wetting properties and low water permeability. It is self priming and forms a hard and tough coating which has good resistance against abrasion and impact as well as to seawater, mineral oils, aliphatic hydrocarbons and splashes from petrol, jet fuel, lubrication oil and related products. Application in thick coats by standard heavy duty airless spray equipment up to 500 micron/20 mils in one working process is possible.

RECOMMENDED USE:

As a coating for steel exposed to abrasion and/or severe corrosive environment.

As a self-primed, high build coating primarily for areas subject to abrasion and/or to a highly corrosive environment. e.g. splash zones, jetty pilings, crude oil and condensate tanks, and working decks.

PHYSICAL CONSTANTS:

Colours:	Grey	
Finish:	Semi-gloss. Slightly structured Surface.	
Volume by solid:	90%	
Theoretical Spreading rate:	1.8	m ² /litre-500 micron
Flash point:	25°C	Abel-pensky.close cup
Specific gravity:	1.4	kg/litre
Surface dry:	5 (approx.)	hours at 20 °C (ISO 1517)
Dry to touch:	6 (approx.)	hours at 20 °C
Fully cured:	7	days at 20 °C

APPLICATION DETAILS:

Mixing Ratio:	BASE: BAJAPOX GF 73727	3.3 part by volume
	CURING AGENT: 63726	1.0 part by volume
Application Method:	Airless Spray	Brush (See application instructions)
Thinner (max.vol):	It is recommended not to use any thinning as this may delay the drying and curing. If deemed necessary, anyhow up to 2% methel ethyl ketone may be used.	
Pot-Life:	1 hour (20°C)	1 1/2 hours (20°C) (See REMARKS overleaf)
Nozzle Orifice:	0.045" reversible nozzle	(See application instructions)
Nozzle Pressure:	250 bar/3600 psi	
Cleaning of Tools:	BAJAK TOOL CLEANER 99610	
Indicated film thickness, wet:	550 microns/22mils	(See REMARKS overleaf)
Indicated film thickness, dry:	500 microns/20 mils	(See REMARKS overleaf)
Recoat Interval, min:	12 hours (20°C)	(See application instructions)
Recoat interval, max:	4 days (20°C)	(See application instructions)

BAJAPOX® GF 73727

- Surface Preparation:** **Spot Repair & Maintenance:** Remove oil and grease etc., with suitable detergent. Remove salt and other contaminants by high pressure Fresh water cleaning. Abrasive blasting to minimum Sa 2½, SSPC-SP 10. Surface profile corresponding to Rugotest No. 3, BN 11, Keane-After blasting, clean the Surface carefully from abrasives and dust.
- On pit-corroded surfaces:** excessive amounts of salt residues may call for dry Abrasive blasting, high pressure fresh water hosing, drying, and finally, dry abrasive blasting again alternatively, jet cleaning, drying and dry abrasive Blasting.
- Application Conditions:** Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. Use only where application and curing can proceed at Temperatures above approximately 15°C. The temperature of the paint itself should also be minimum 15°C. At high temperature 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 BAJAPOX 15590
- Subsequent Coat:** None, or according to specification.
- Remarks:** Refer to separate APPLICATION INSTRUCTIONS.
- Service Temperature:** Dry service temperature: max: 120°C
Dry peak temperature: max. 140°C
- Film Thickness:** May be specified in another film thickness than indicated depending on purpose and area of use. Normal range is 500-1000 Mic.. This will alter spreading rate and may influence drying time and reciting interval. Concerning measurement of wet film thickness, please consult separate APPLICATION INSTRUCTIONS. For optimum performance two layers, each 500 micron/20 mils dry film thickness is recommended.
- Pot-life:** The pot life is dependent upon packing size and temperature. For temperature at 35°C the pot life will be reduced to approximately 15 minutes.
- Note:** **BAJPOX GF 73727 is for professional use only.**
- Safety:** Packing is provided with applicable safety labels, which should be observed. In addition, Material Safety Data Sheet(s) should be consulted and national or local regulations should be followed. As a general rule, inhalation of solvent vapors or paint mist, and contact of liquid paint with skin and eyes should be avoided. Forced ventilation should be provided when applying paint in confined spaces or stagnant air. Even when ventilation is provided, respiratory, skin, and eye protection are always recommended when spraying paint. Necessary precautions against the risk of fire or explosion must be taken.



BAJAK'S DRUM LINING 74520

Description: BAJAK'S DRUM LINING 74520 is a one-component, baking coat based on special phenolic epoxy resins for optimum adhesion, hardness and chemical resistance. It has excellent physical and chemical properties such as: mechanical properties and excellent flexibility, resistance against water and some chemicals.

Recommended use: As single coat for drum lining

Certificate/Approvals:

PHYSICAL CONSTANTS:

Product:	74520
Colours/Shade no:	Red (Other shades according to assortment list) /1095
Finish:	glossy
Volume Solids, %:	33 ± 1
Theoretical spreading rate:	22 M2 / liter @ 15 Mic. dft
Flash point:	24°C/75°F
Specific gravity:	1.15 – 1.25 kg/liter
Flash time:	10 minutes at 20°C/68°F
Cure conditions:	10 min. at 210 °C/410°F
V.O.C.:	450 g/liter

Shelf life: 12 months (25°C/77°F) from date of production.
Shelf life is dependent on storage temperature. Shelf life is reduced at storage temperatures above 25°C/77°F. Do not store above 40°C/104°F or below 5°C/40°F.
Shelf life is exceeded if the liquid is gelled or viscosity increased.

APPLICATION DETAILS:

Application method:	Air spray	Brush (touch up)
Thinner (max.vol.):	08028 (30%)	08028 (15%)
Nozzle orifice:	1.8	
Air pressure:	4 -6 bar	
Cleaning of tools:	THINNER 08028	
Indicative dft:	15 micron	
Indicative wft:	45 micron	
Recoat interval, min:	After flash time	
Recoat interval, max:	Before baking	

2. BAJAK'S DRUM LINING 74520

SURFACE PREPARATION:	Remove oil and grease with suitable detergent.
APPLICATION CONDITIONS:	The surface must be completely clean and dry with a temperature above the dew point to avoid condensation.
SUBSEQUENT COAT:	None, or as per specification.
REMARKS: Film thicknesses and theoretical spreading rate:	On steel 15 micron/0.6 mil film thickness .Increase in DFT causes decrease in theoretical spreading rate and mechanical properties.
Thinning:	Selection of proper thinner is related to application conditions.
Curing:	Baking time is shorter at higher temperatures.
Shelf life:	1 Year at 25°C/77°F, in higher temperatures shelf life decreased.
Note:	BAJAK'S DRUM LINING 74520 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.
Issued:	October 2012



BAJAK'S DRUM LINING 74520A

Description: BAJAK'S DRUM LINING 74520A is a one-component, baking coat based on special phenolic epoxy resins for optimum adhesion, hardness and chemical resistance. It has excellent physical and chemical properties such as: mechanical properties and excellent flexibility, resistance against water and some chemicals.

Recommended use: As single coat for drum lining

Certificate/Approvals:

PHYSICAL CONSTANTS:

Product:	74520A
Colours/Shade no:	Red (Other shades according to assortment list) /1095
Finish:	glossy
Volume Solids, %:	33 ± 1
Theoretical spreading rate:	22 M2 / liter @ 15 Mic. dft
Flash point:	24°C/75°F
Specific gravity:	1.15 – 1.25 kg/liter
Flash time:	10 minutes at 20°C/68°F
Cure conditions:	10 min. at 210 °C/410°F
V.O.C.:	450 g/liter

Shelf life: 12 months (25°C/77°F) from date of production.
Shelf life is dependent on storage temperature. Shelf life is reduced at storage temperatures above 25°C/77°F. Do not store above 40°C/104°F or below 5°C/40°F.
Shelf life is exceeded if the liquid is gelled or viscosity increased.

APPLICATION DETAILS:

Application method:	Air spray	Brush (touch up)
Thinner (max.vol.):	08028 (30%)	08028 (15%)
Nozzle orifice:	1.8	
Air pressure:	4 -6 bar	
Cleaning of tools:	THINNER 08028	
Indicative dft:	15 micron	
Indicative wft:	45 micron	
Recoat interval, min:	After flash time	
Recoat interval, max:	Before baking	

2. BAJAK'S DRUM LINING 74520A

SURFACE PREPARATION:	Remove oil and grease with suitable detergent.
APPLICATION CONDITIONS:	The surface must be completely clean and dry with a temperature above the dew point to avoid condensation.
SUBSEQUENT COAT:	None, or as per specification.
REMARKS: Film thicknesses and theoretical spreading rate:	On steel 15 micron/0.6 mil film thickness .Increase in DFT causes decrease in theoretical spreading rate and mechanical properties.
Thinning:	Selection of proper thinner is related to application conditions.
Curing:	Baking time is shorter at higher temperatures.
Shelf life:	1 Year at 25°C/77°F, in higher temperatures shelf life decreased.
Note:	BAJAK'S DRUM LINING 74520A 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.
Issued:	October 2012



بازاک (سهامی خاص)

BAJAK POLYURETHANE SF 74558

CURING AGENT 63055

Description: BAJAK POLYURETHANE SF74558 is a two component sprayable solvent free Polyurethane based on special polyol and aromatic Isocyanate resins with an excellent abrasion resistance and low water permission on primed concrete and steel potable water pipe surfaces.

Recommended use: As lining on steel potable water pipe.

Service temperature: Maximum 50°C

PHYSICAL CONSTANTS:

Colors/Shade No: Light Grey RAL 7035/7153
Finish: Glossy
Volume Solid: 100% (Curable material)
Weight Solid: 100% (Curable material)
Theoretical spreading rate: 2.0 m² /liter 500 Mic. Dft.
Flash point: 105 °C
Specific gravity: 1.20 – 1.25 kg/liter
Dry to touch: Max. 1 hour at 20°C
Hard Dry: Max. 5 hrs at 20°C
Fully cured: 7 days at 20°C
V.O.C.: 0 gr/liter
Shelf life: Base : 24 Mounth (25°C/77°F) from time of production. Depending on storage condition, mechanical stirring may be necessary before usage.
Hardner : 12 Mounth (25°C/77°F) from time of production..

APPLICATION DETAILS:

Mixing ratio for 73555 Base74558: Curing agent 63055
3 : 1 by volume
Application method: Hot dual airless spray
Thinner (max. vol.) Not recommend
Pot life: 10 min. (60°C / 140°F) 50 ml
Cleaning of tools: 08050
Indicated film thickness, dry: 500 microns
Indicated film thickness, wet: 500 microns
Recoat interval, min: 4 hours (20°C)
Recoat interval, max: 24 hours (20°C), See REMARKS overleaf

Issued: April 2011

2.BAJAK POLYURETHANE SF 74558

APPLICATION AND CURING CONDITIONS: CONCRETE : The surface must be completely clean and dry at the time of application and its temperature must be min 5 °C above the dew point to avoid condensation. Minimum temperature for curing is 5°C/41°F.
At the freezing point and below, beware of the risk of ice on the surface which will hinder the adhesion. High humidity and/or condensation during application and the following 16 hours (20°C/68°F) may adversely affect the film formation. Maximum concrete moisture content should be 4%.
STEEL : abrasive blast to SA2½ and minimum roughness of 60 µm.
In confined spaces provide adequate ventilation during application and drying.

PRECEDING COAT: For concrete : BAJAK'S EPOXY SEALER 15026
For steel : None , or BAJAK'S EPOXYPRIMER 15300

SUBSEQUENT COAT: None .

REMARKS: Film thicknesses: 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 is 500 microns/20 mils.

Thinning: Not recommend.
Physical property:

Type of Physical property:	Result	Unit	Standard
Pressure strength	600	Kgf/cm2	ASTM D695M
Elongation at break	Min. 12	%	ISO 527
Hardness (Persoz)	Min. 200	Sec	ASTM D4366
Abrasion Resistance	Max. 50 mg	1000 cycle CS17	ASTM D4060
Adhesion pull off on steel (Min.)	> 1500	Psi	ASTM D4541
Shore hardness	60-70	Shore D	ASTM 2240
Flexibility	≥5	%	EN10290-Annex K
Cathodic disbondment (30 days/23 °C)	≤8 length	mm	EN10290-Annex E
Specific coating resistivity (100 days/23 °C)	≥10 ⁸ (1000 mic dft)	Ωm ²	EN10290-Annex F

A completely clean surface is mandatory to ensure intercoat adhesion, especially at long recoating intervals. Any dirt,oil,and grease have to be removed, e.g. with suitable detergent.

Salts to be removed by fresh water hosing. To check an adequate quality of the surface cleaning a test patch is recommended before actual recoating.

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 and national safety regulations. Harmful or fatal if swallowed; immediately seek medical assistance swallowed. Avoid inhalations of possible solvent vapors or paint mist, as well as paint contact with skin and eyes. Apply only on well-ventilated areas and ensure that adequate forced ventilation exists when applying paint in confined spaces or when the air is stagnant. Always take precautions against the risks of fire and explosions.

Issued: April 2011



بازاک (سهامی خاص)

BAJATHANE ANTISTATIC TOPCOAT 74750

CURING AGENT 63055

Description: BAJATHANE ANTISTATIC TOPCOAT 74750 is high performance solvent free antistatic topcoat on primed concrete floors.

Recommended use: 1.As a high performance antistatic topcoat with excellent mechanical properties and adhesion to a wide range of existing coatings on primed concrete.

Service temperatures: Dry:
Maximum: 100°C/212°F

PHYSICAL CONSTANTS:

Colours: Light grey
Finish: Glossy
Solids Content, %: 100
Theoretical spreading rate: 1 m²/litre-1000 micron
40 sq.ft./US gallon - 40 mils
Flash point: >100°C/212°F
Specific gravity: 1.4 kg/litre
Surface dry: 3 (approx.) hrs at 20°C/68°F (ISO 1517)
Dry to touch: 5 (approx.) hours at 20°C/68°F
Fully cured: 5 days at 20°C/68°F
V.O.C.: 0 g/litre

APPLICATION DETAILS:

Mixing ratio for 74750: Base 74750: Curing agent 63055
4 : 1 by weight
Application method: Roller & knife
(Consult the separate APPLICATION INSTRUCTIONS)
Thinner (max.vol.): Do not dilute
Pot life: 0.5 hour (20°C/68°F)
Nozzle orifice: -
Nozzle pressure: -

Clearing of tools: BAJAK'S THINNER 8050
Indicated film thickness, dry: 1000
Indicated film thickness, wet: 1000

2. BAJATHANE ANTISTATIC TOPCOAT 74750

SURFACE PREPARATION:	Primed concrete surface should be clean from dust and grease with thinner or suitable detergent and dry.
APPLICATION CONDITIONS:	Use only where application and curing can proceed at temperatures above 10°C/50°F. The temperature of the paint itself must be above 15°C/59°F for proper application. In-can temperature of the paint should preferably be below 25°C/77°F. Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. Relative humidity max 50%. Concrete humidity must be less than 4%.
PRECEDING COAT:	BAJAPOX ANTISTATIC PRIMER 11726.
SUBSEQUENT COAT:	None.
REMARKS:	The natural tendency of aromatic polyurethane coatings to discoloration in outdoor exposure is also reflected in this product.
Dry film thicknesses:	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. Normal range of dry film thickness is 700-1000 mic.
Recoating:	None.
Repair:	For any repair on the product please consult with BAJAK technical section.
Note:	BAJATHANE ANTISTATIC TOPCOAT 74750 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.
Issued:	May 2009



بازاک (سهامی خاص)

BAJAFIRE 74826

Description: BAJAFIRE 74826 is intumescent fire protection coating with an excellent thermal efficiency in today's market. From a design standpoint, it is now possible to achieve 30 Minutes hydrocarbon fire protection to steel structural with only 3 mm. thickness.

Recommended use: As an intermediate and topcoat on primed steel to protect that from hydrocarbon fire.

Service temperature: Dry: Maximum 50°C

Approval:

PHYSICAL CONSTANTS:

Colors/Shade No: Light Blue

Finish: Glossy

Volume solid: 100%

Theoretical spreading rate: 0.33 m²/liter – DFT: 3000 μm

Flash point: >100 °C

Specific gravity: App. 1.25 kg/liter

Surface dry: Max. 4 hours at 20°C (ISO 1517)

Dry to touch: Max. 6 hours at 20°C

Fully cured: 7 days

Shelf life: 1 Year (25°C/77°F) from time of production. Depending on storage condition, mechanical stirring may be necessary before usage.

APPLICATION DETAILS:

Mixing ratio for 74826: Base 74826 : 4 by weight

Hardner 64826 : 1

Application method: Trowel & putty knife
or similar

Thinner (max. vol.) No

Nozzle orifice: -

Nozzle pressure: -

Cleaning of tools: 8000

Indicated film thickness, dry: 3000 microns

Indicated film thickness, wet: 3000 microns

Recoat interval, min: 8 hours (20°C)

Recoat interval, max: 3 days

Issued: July 2016

Bajafire 74826

SURFACE PREPARATION:	Remove oil and grease, etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. Abrasive blasting to Sa 2½ SSPC-SP-10, with a sharp-edged surface profile corresponding to Rugotest No. 3, BN9a, Keane-Tator Comparator, 2.0 G/S, 2 S, or ISO Comparator, Medium (G) corresponding to Segment 2.
APPLICATION AND CURING CONDITIONS:	The surface must be completely clean and dry at the time of application. And its temperature must be above the dew point to avoid condensation. Minimum temperature for curing is 5°C At the freezing point and below, be aware of the risk of ice on the surface which will hinder the adhesion. High humidity and/or condensation during application and the following 16 hours (20°C) may adversely affect the film formation. In confined spaces provide adequate ventilation during application and drying.
PRECEDING COAT:	BAJAK zinc phosphate 12220
SUBSEQUENT COAT:	74826
REMARKS:	
Film thicknesses:	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 is 300 microns/12 mils. For more than 2 hours fire protection more coats should be applied. A completely clean surface is mandatory to ensure inter coat adhesion, especially at long recoating intervals. Any dirt, oil, and grease have to be removed, e.g. with suitable detergent. Salts to be removed by fresh water hosing. To check an adequate quality of the surface cleaning a test patch is recommended before actual recoating.
SAFETY:	Handle with care. Before and during use, observe all safety labels on packing and paint containers, consult BAJAK material safety data sheets and follow all local and national safety regulations. Harmful or fatal if swallowed; immediately seek medical assistance swallowed. Avoid inhalations of possible solvent vapors or paint mist, as well as paint contact with skin and eyes. Apply only on well-ventilated areas and ensure that adequate forced ventilation exists when applying paint in confined spaces or when the air is stagnant. Always take precautions against the risks of fire and explosions.
Issued:	July 2016

BAJAK'S ROOF COATING 81540

FORMERLY 58810B

Description: BAJAK ROOF COATING 58810B is a high-build acrylic coating. It forms a durable elastomeric membrane with excellent flexibility and water-proofing properties. The appearance is slightly textured.

Area of use: **Exterior:** Roofs and walls.

Substrates: Concrete, masonry, woodwork, tiles, steel, PU foam, etc.

PHYSICAL CONSTANTS:

Colour/Shade nos:	White/10000		
Finish:	Semi-flat		
Volume Solids, %:	37±2%		
Theoretical spreading rate:	2.5 m ² /litre at 150 micron*		
Flash point:	>66°C		
Specific gravity:	1.27 kg/litre		
Dry to touch:	6 hours (10°C)	3 hours (20°C)	1 hour (40°C)

***The theoretical spreading rate** has been calculated for the stated volume solids and dry film thickness.

A practical spreading rate will depend on the actual dry film thickness, the nature of the substrate, and the relevant consumption factor.

The physical constants are subject to normal manufacturing tolerances. Further reference is made to "Explanatory Notes".

APPLICATION DETAILS:

Application method:	Brush/roller	Conventional spray	Airless spray
Thinner (max. vol.):	None	None	None
Cleaning of tools:	Fresh water		
Indicated film thickness, dry:	150 micron		
Indicated film thickness, wet:	400 micron		
Recoat interval, min:	6-12 hours (10°C)	3-6 hours (20°C)	1-3 hours (40°C)
Recoat interval, max:	None	None	None

Surface condition: The surface should be stable, firm, dry and free of dust, sand, loose old paint, Sealer/primer, laitance, dirt, grease and oil. It is recommended to apply a primer/sealer prior to the specified filling procedure. Touch-up with primer/sealer on areas repaired with filler is recommended prior to application of topcoats.

Fillings: Mix 2-3 parts of sand to 1 part of BAJAK'S ROOF COATING 81540 to fill small cracks in the concrete. For large holes and cracks, BAJAK'S EPOXY GROUT 93026 is recommended.

Sealing:
On concrete: BAJAK'S ACRYLIC PRIMER/SEALER 21541.
On ferrous metal: BAJALIN PRIMER 12210.

Remarks: Use only where application and drying can proceed at temperatures above 5°C, preferably above 10°C. Drying data given is on the assumption that proper ventilation is provided.

Note: **BAJAK'S ROOF COATING 81540 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. Harmful or fatal if swallowed; immediately seek medical assistance if swallowed. Avoid inhalation of possible solvent vapors or paint mist, as well as paint contact with skin and eyes. 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. Always take precautions against the risks of fire and explosions.

Issued: May 2016



بازاک (سهامی خاص)

BAJAK'S RUST CONVERTER 83540

Description: 83540 is a rust converter primer based on acrylic resin emulsion modified with suitable chelating agent for optimum adhesion on rusted surfaces.

Recommended use: As a primer in epoxy system on rusted steel surfaces specially where abrasive blasting is impossible or prohibited. Used in moderate to severe corrosive environment.

Application condition: The surface must be clean to St2 grade at the time of application, Minimum temperature for application is 5°C. Applicable on damp surfaces.

PHYSICAL CONSTANTS:

Mixed product:	83540
Colours:	White
Finish:	Semi-gloss
Volume Solids, %:	25±2
Theoretical spreading rate:	3.8 m ² /litre at 65 microns 2.8 m ² /litre at 90 microns
Specific gravity:	1.05±0.02 kg/litre
Dry to touch:	30 min at 20°C
Dry to handle:	60 min at 20°C
Fully cured:	24 hours at 20°C
V.O.C.:	0 gr/litre

APPLICATION DETAILS:

Application method:	Brush
Thinner (max.vol.):	Water
PH:	1-2
Shelf life:	6 months on standard storage condition
Recommended dft:	65-90 microns
Recoat interval, min:	24 hours at 20°C
Recoat interval, max:	None

Issued:

Feb. 2007

2. BAJAK'S RUST CONVERTER 83540

SUBSEQUENT: COAT:	Epoxy coatings or according to specification.
PRECEDING COAT:	None.
STORAGE:	The product should be stored and kept in temperatures between 10°C to 25°C. Due to freezing of the product, temperature should never drop below the freezing point.
REMARKS: Color change:	Rust converter occurs during change in color from milky white to brown – black.
FILM THICKNESS:	Normal thickness for each coat is 65-90 microns, depend on degree of rust on the surface it may be variable. In case of applying in high total film thicknesses, in order to avoid sagging it should be applied in two or three coats.
Recoating:	Before recoating after exposure in contaminated environment, clean the surface thoroughly by fresh water hosing and allow to dry.
Safety:	Handle with care. Before and during use, observe all safety labels on packaging and paint containers, our 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 directs 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.
Issued:	Feb. 2007

BAJAK'S WB COATING 83545

Description: BAJAK WB COATING 83545 is a high-build acrylic coating. It forms a durable elastomeric membrane with excellent flexibility and water-proofing properties. The appearance is slightly textured.

Area of use: **Exterior:** walls.

Substrates: Concrete, masonry, woodwork, tiles, steel, PU foam, etc.

PHYSICAL CONSTANTS:

Colour/Shade nos:	Black/7035		
Finish:	Flat		
Volume Solids, %:	38%		
Theoretical spreading rate:	7.6 m ² /litre at 50 micron*		
Flash point:	-		
Specific gravity:	1.23 kg/litre		
Dry to touch:	3 hours (10°C)	1 hours (20°C)	0.5 hour (40°C)

***The theoretical spreading rate** has been calculated for the stated volume solids and dry film thickness.

A practical spreading rate will depend on the actual dry film thickness, the nature of the substrate, and the relevant consumption factor.

The physical constants are subject to normal manufacturing tolerances. Further reference is made to "Explanatory Notes".

APPLICATION DETAILS:

Application method:	Brush/roller	Conventional spray	Airless spray
Thinner (max. vol.):	None	None	None
Cleaning of tools:	Fresh water		
Indicated film thickness, dry:	50 micron		
Indicated film thickness, wet:	130 micron		
Recoat interval, min:	6-12 hours (10°C)	3-6 hours (20°C)	1-3 hours (40°C)
Recoat interval, max:	None	None	None

Surface condition: The surface should be stable, firm, dry and free of dust, sand, loose old paint, Sealer/primer, laitance, dirt, grease and oil. It is recommended to apply a primer/sealer prior to the specified filling procedure. Touch-up with primer/sealer on areas repaired with filler is recommended prior to application of topcoats.

Sealing:	On concrete:	BAJAK'S ACRYLIC PRIMER/SEALER 26630B.
	On ferrous metal:	BAJALIN PRIMER 12050B.
	On wood:	BAJAK'S ALKYD UNDERCOAT 22460B.

Remarks: Use only where application and drying can proceed at temperatures above 5°C, preferably above 10°C. Drying data given is on the assumption that proper ventilation is provided.

Note: **BAJAK'S WB COATING 83545 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. Harmful or fatal if swallowed; immediately seek medical assistance if swallowed. Avoid inhalation of possible solvent vapors or paint mist, as well as paint contact with skin and eyes. 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. Always take precautions against the risks of fire and explosions.

Issued: August 2011

**BAJAPOX 85671A**

CURING AGENT 97371A

Description:	BAPAOX 85671A is a two-component, amine adduct cured phenolic epoxy (novolac) coating with very good adhesion and high temperature, water and superior chemical resistance.
Recommended use:	As an interior lining in tanks etc. for hot water, brine, crude oil, etc. For coating of potable water tanks. As a primer coat in specific painting systems.
Service temperatures:	Dry: In water (maximum gradient 15°C/59°F): Maximum: 160°C/320°F 90°C/194°F May be specified for design temperatures up to 260°C/500°F dry. For higher temperatures see REMARKS overleaf.

PHYSICAL CONSTANTS:

Colours:	Off-white , Light red
Finish:	Semi flat
Volume Solids, %:	68 ± 1
Theoretical spreading rate:	6.8 m ² /litre - 100 micron 273 sq.ft./US gallon - 4 mils
Flash point:	24°C/75°F
Specific gravity:	1.6 kg/litre – 13.4 lbs/US gallon
Surface dry:	2-3 hours at 20°C/68°F
Dry to touch:	6 (approx.) hours at 20°C/68°F
Fully cured:	10 days at 20°C/68°F
V.O.C.:	320 g/litre – 2.7 lbs/US gallon
Shelf life:	½ year (25°C/77°F) from time of production. Depending on storage conditions, mechanical stirring may be necessary before usage. If the shelf life is exceeded please contact BAJAK for further advice.

APPLICATION DETAILS:

Mixing ratio for 85671A:	Base 85671A : Curing agent 97371A 6 : 1 by volume 11 : 1.0 by weight
Application method:	Airless spray (spinning disc) Brush (touch up)
Thinner (max.vol.):	08450 (See application instructions) 08450 (See application instructions)
Pot life:	3 hours (20°C/68°F) (See REMARKS overleaf)
Induction time:	15 minutes (20°C/68°F) (See REMARKS overleaf)
Nozzle orifice:	.018"-.021"
Nozzle pressure:	200 bar/2900 psi (Airless spray data are indicative and subject to adjustment)
Cleaning of tools:	BAJAK'S TOOL CLEANER 99610
Indicative dft:	50 micron/ 2 mils (See REMARKS overleaf)
Indicative wft:	75 micron/ 3 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. 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.
Issued:	Dec. 2008

2. BAJAPOX 85671A

SURFACE PREPARATION:	For optimum performance abrasive blasting to very near white metal Sa 2½ - 3, with a surface profile corresponding to Rugo test No. 3, BN10, Keane-Tator Comparator 3.0 G/S, or ISO Comparator Rough Medium(G).
APPLICATION CONDITIONS:	Use only where application and curing can proceed at temperatures above 10° C/50° F. The temperature of the paint itself must be above 15° C / 59° F, best results are obtained at 17-23°C/62-73 °F. Relative humidity max. 80% preferably 40-80%. Apply on a dry and clean surface with a temperature above the dew point to avoid condensation. Furthermore, reference is made to special APPLICATION INSTRUCTIONS. Provide adequate ventilation during application and drying in confined spaces.
PRECEDING COAT:	None.
SUBSEQUENT COAT:	None.
REMARKS:	
High temperature service:	May be used under insulation, pipes and the like in one or two coat systems. Dry film thicknesses should not exceed 250 micron/10 mils. However, at temperatures above 175 °C/ 350 °F max 260 °C/500 °F is recommended to apply max 125 micron/5 mils. The coating should be cured for at least 7 days at 20 °C/68 °F before exposure to high temperatures. The coating will discolour at high service temperatures.
Film thicknesses:	The minimum total dry film thickness for the system is 300 microns/12 mils. May be specified in higher film thickness than indicated depending on purpose and area of use. This will alter spreading rate, influence drying time and prolong minimum recoating intervals. The specification may read up to 125 micron/5 mils dry film thickness per coat, exceptionally 150 micron/6 mils.
Pot life:	As per Aramco's requirements, gel time is above 8 hours at a can temperature of 23 °C/73 °F and above 2 hours at a can temperature of 40 °C/164 °F. For optimum spray application properties, the mixture should be used within 2 hours at 20 °C/68 °F.
Recoating Intervals:	Minimum: Non-potable water service: 36 hours (20 °C/68 °F) between the first and second coat, 24 hours (20 °C/68 °F) between the second and third coat. Potable water service: 3 days (20 °C/68 °F) between coats. Maximum: 21 days (20 °C/68 °F). If the maximum recoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion.
Notes to application and recoating:	<ul style="list-style-type: none">• The coating is to be applied in a dry film thickness as near as possible to the specified 100 micron/4 mils (or higher if specified).• Film formation of each coat has to be of good quality, free from defects such as pinholes and without any dry spray.• Drying and curing conditions have to be according to APPLICATION CONDITIONS until full curing has been obtained.• No kind of surface contamination must exist except loose dust, abrasives, loose dry-spray, which is possible to remove by vacuum cleaning before overcoating. The surface MUST be completely clean before overcoating.• The coating must only be (exceptionally) exposed to strong direct sunlight. (ultraviolet light) in short periods.• The coating is to be checked carefully and should have no patchy, whitish, and/or greasy formation, which can hinder adhesion of the subsequent coat. <p>Note: Exudation of the curing agent causes the mentioned patchy, whitish, and/or greasy formation, which will take place if BAJAPOX 85571 is applied at low temperatures without proper induction time and/or if the coating is exposed to water(rain, condensation) during drying and curing.</p>
Mixing:	The thoroughly mixed BASE and AGENT must be preheated before application (15 mixtures at 20 °C/68 °F) . Keep thinning at an absolute minimum. Do not dilute the components separately –only the mixture.
Note:	BAJAPOX 85671A is for professional use only.

**BAJAPOX 85671**

CURING AGENT 97371

Description: BAPAOX 85671 is a two-component, amine adduct cured phenolic epoxy (novolac) coating with very good adhesion and high temperature, water and chemical resistance.

Recommended use: As an interior lining in tanks etc. for hot water, brine, crude oil, etc.
For coating of potable water tanks.
As a primer coat in specific painting systems.

Service temperatures:

	Dry:	In water (maximum gradient 15°C/59°F):
Maximum:	160°C/320°F	90°C/194°F

May be specified for design temperatures up to 260°C/500°F dry.
For higher temperatures see REMARKS overleaf.

APPROVALS: Approved by Power Research Center of IRAN (MATN) as a coating for potable water according to AWWA C210 and BS6920 standards.

PHYSICAL CONSTANTS:

Colours:	Off-white , Light red
Finish:	Flat
Volume Solids, %:	68 ± 1
Theoretical spreading rate:	6.8 m ² /litre - 100 micron 273 sq.ft./US gallon - 4 mils
Flash point:	24°C/75°F
Specific gravity:	1.7 kg/litre – 14.2 lbs/US gallon
Surface dry:	2-3 hours at 20°C/68°F
Dry to touch:	6 (approx.) hours at 20°C/68°F
Fully cured:	10 days at 20°C/68°F
V.O.C.:	320 g/litre – 2.7 lbs/US gallon

Shelf life: ½ year (25°C/77°F) from time of production. Depending on storage conditions, mechanical stirring may be necessary before usage.
If the shelf life is exceeded please contact BAJAK for further advice.

APPLICATION DETAILS:

Mixing ratio for 85671:	Base 85671 : Curing agent 97371 8.8 : 1.2 by volume 13.8 : 1.0 by weight
Application method:	Airless spray (spinning disc) Brush (touch up)
Thinner (max.vol.):	08450 (See application instructions) 08450 (See application instructions)
Pot life:	3 hours (20°C/68°F) (See REMARKS overleaf)
Induction time:	15 minutes (20°C/68°F) (See REMARKS overleaf)
Nozzle orifice:	.018"-.021"
Nozzle pressure:	200 bar/2900 psi (Airless spray data are indicative and subject to adjustment)
Cleaning of tools:	BAJAK'S TOOL CLEANER 99610
Indicative dft:	100 micron/ 4 mils (See REMARKS overleaf)
Indicative wft:	150 micron/ 6 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. 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 85671

SURFACE PREPARATION:	For optimum performance abrasive blasting to very near white metal Sa 2½ - 3, with a surface profile corresponding to Rugo test No. 3, BN10, Keane-Tator Comparator 3.0 G/S, or ISO Comparator Rough Medium(G).
APPLICATION CONDITIONS:	Use only where application and curing can proceed at temperatures above 10° C/50° F. The temperature of the paint itself must be above 15° C / 59° F, best results are obtained at 17-23°C/62-73 °F. Relative humidity max. 80% preferably 40-60%. Apply on a dry and clean surface with a temperature above the dew point to avoid condensation. Furthermore, reference is made to special APPLICATION INSTRUCTIONS. Provide adequate ventilation during application and drying in confined spaces.
PRECEDING COAT:	None.
SUBSEQUENT COAT:	None.
REMARKS:	
High temperature service:	May be used under insulation, pipes and the like in one or two coat systems. Dry film thicknesses should not exceed 250 micron/10 mils. However, at temperatures above 175 °C/ 350 °F max 260 °C/500 °F , it is recommended to apply max 125 micron/5 mils. The coating should be cured for at least 7 days at 20°C/68°F before exposure to high temperatures. The coating will discolour at high service temperatures.
Film thicknesses:	The minimum total dry film thickness for the system is 300 microns/12 mils. May be specified in higher film thickness than indicated depending on purpose and area of use. This will alter spreading rate, influence drying time and prolong minimum recoating intervals. The specification may read up to 125 micron/5 mils dry film thickness per coat, exceptionally 150 micron/6 mils.
Pot life:	As per Aramco's requirements, gel time is above 8 hours at a can temperature of 23°C/73°F and above 2 hours at a can temperature of 40°C/164°F. For optimum spray application properties, the mixture should be used within 2 hours at 20°C/68°F.
Recoating Intervals:	Minimum: Non-potable water service: 36 hours (20°C/68°F) between the first and second coat, 24 hours (20°C/68°F) between the second and third coat. Potable water service: 3 days (20°C/68°F) between coats. Maximum: 21 days (20°C/68°F). If the maximum recoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion.
Notes to application and recoating:	<ul style="list-style-type: none">• The coating is to be applied in a dry film thickness as near as possible to the specified 100 micron/4 mils (or higher if specified).• Film formation of each coat has to be of good quality, free from defects such as pinholes and without any dry spray.• Drying and curing conditions have to be according to APPLICATION CONDITIONS until full curing has been obtained.• No kind of surface contamination must exist except loose dust, abrasives, loose dry-spray, which is possible to remove by vacuum cleaning before overcoating. The surface MUST be completely clean before overcoating.• The coating must only be (exceptionally) exposed to strong, direct sunlight. (ultraviolet light) in short periods.• The coating is to be checked carefully and should have no patchy, whitish, and/or greasy formation, which can hinder adhesion of the subsequent coat. <p>Note: Exudation of the curing agent causes the mentioned patchy, whitish, and/or greasy formation, which will take place if BAJAPOX 85671 is applied at low temperatures without proper induction time and/or if the coating is exposed to water (rain, condensation) during drying and curing.</p>
Mixing:	The thoroughly mixed BASE and AGENT must be prereacted before application (15 minutes at 20°C/68°F). Keep thinning at an absolute minimum. Do not dilute the components separately – only the mixture.
Note:	BAJAPOX 85671 is for professional use only.



BAJAK PAINT REMOVER 90000

DESCRIPTION:	BAJAK PAINT REMOVER 90000 is a gelatinous substance with a strong dissolving effect on most kinds of old paint and varnish.
RECOMMENDED USE:	As a paint and varnish remover. Can also be used for restoring stiffened paint brushes and rollers. (See REMARKS)
AVAILABILITY:	Subject to confirmation
PHYSICAL CONSTANTS:	
Colour:	Transparent
Shade No:	00000
Volume Solids:	4%
Flash Point:	Not measurable
Specific Gravity:	1.2 kg/litre 10.0 lbs/US gallon
APPLICATION DETAILS:	
Application Method:	Apply BAJAK PAINT REMOVER 90000 by brush in a thick layer and leave it on for 5-10 minutes after which the paint or varnish is removed with a scraper. Should not normally be left on for more than 1 hour as difficulties may arise when scraping. Alternatively, cover the area in question with a polyethylene sheet to prevent evaporation. On very thick layers of old paint, or if the softened paint dries up, repeat the process. The consumption depends on the nature and the thickness of the paint or varnish to be removed. As a guideline a spreading rate of 3-6 m ² per litre/120-245 sq.ft per US gallon is indicated.
Remarks:	Do not use at temperatures above 25C/77F, in direct sunlight, or in strong wind as the evaporation will then proceed too rapidly - alternatively cover with a polyethylene sheet. <u>Subsequent Treatment</u> <u>Wood & Steel:</u> Wash down thoroughly with a weak solution of ammonia water (oak, teak, and mahogany may be discoloured by ammonia), followed by hosing down with fresh water. <u>Brushes & Rollers:</u> Rinse thoroughly in fresh water and hang up. <u>Cautions:</u> Unscrew the lid with caution due to risk of over-pressure in the tin. Do not use on cloth, linoleum, plexiglass, plastics, asphalt floors, and similar. Contains chlorinated solvent. Do not apply on hot surfaces. Do not store or use in direct sunshine or near to heat and open flame (eg: welding and burning) as poisonous gas can develop.
Note:	BAJAK PAINT REMOVER 90000 is for professional use only.
Safety:	Packings are provided with applicable safety labels which should be observed. In addition, national or local safety regulations should be followed. As a general rule, inhalation of solvent vapours or paint mist, and contact of liquid paint and paint remover with skin and eyes should be avoided. Forced ventilation should be provided when working with paint remover in confined spaces or stagnant air. Even when ventilation is provided, respiratory, skin, and eye protection are always recommended.
REISSUED:	Jan. 2011

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باجاک (سهامی خاص)

BAJAK PAINT REMOVER 90000D

DESCRIPTION: **BAJAK PAINT REMOVER 90000D** is a gelatinous substance with a strong dissolving effect on most kinds of old paint and varnish.

RECOMMENDED USE: As a paint and varnish remover. Can also be used for restoring stiffened paint brushes and rollers. (See REMARKS)

AVAILABILITY: Subject to confirmation

PHYSICAL CONSTANTS:

Colour.	Transparen
Shade	00000
No:	4%
Volume Solids:	Not measurable
Flash Point	1.2 kg/litre
Specific Gravity:	10.0 lbs/US gallon

APPLICATION DETAILS:

Application Method:

Apply BAJAK PAINT REMOVER 90000D by brush in a thick layer and leave it on for 5-10 minutes after which the paint or varnish is removed with a scraper. Should not normally be left on for more than 1 hour as difficulties may arise when scraping. Alternatively, cover the area in question with a polyethylene sheet to prevent evaporation.

On very thick layers of old paint, or if the softened paint dries up, repeat the process.

The consumption depends on the nature and the thickness of the paint or varnish to be removed. As a guideline a spreading rate of 3-6 m² per litre/120-245 sq.ft per US gallon is indicated.

Remarks:

Do not use at temperatures above 25C/77F, in direct sunlight, or in strong wind as the evaporation will then proceed too rapidly • alternatively cover with a polyethylene sheet

Subsequent Treatment

Wood & Steel: Wash down thoroughly with a weak solution of ammonia water (oak, teak, and mahogany may be discoloured by ammonia), followed by hosing down with fresh water.

Brushes & Rollers: Rinse thoroughly in fresh water and hang up.

Cautions: Unscrew the lid with caution due to risk of over-pressure in the tin. Do not use on cloth, linoleum, plexiglass, plastics, asphalt floors, and similar. Contains chlorinated solvent. Do not apply on hot surfaces. Do not store or use in direct sunshine or near to heat and open flame (eg: welding and burning) as poisonous gas can develop.

BAJAK PAINT REMOVER 90000D is for professional use only.

Note:
Safety:

Packings are provided with applicable safety labels which should be observed. In addition, national or local safety regulations should be followed.

As a general rule, inhalation of solvent vapours or paint mist, and contact of liquid paint and paint remover with skin and eyes should be avoided. Forced ventilation should be provided when working with paint remover in confined spaces or stagnant air. Even when ventilation is provided, respiratory, skin, and eye protection are always recommended.

REISSUED:

Jan. 2011

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BAJAK PAINT REMOVER 90000

DESCRIPTION:	BAJAK PAINT REMOVER 90000 is a gelatinous substance with a strong dissolving effect on most kinds of old paint and varnish.
RECOMMENDED USE:	As a paint and varnish remover. Can also be used for restoring stiffened paint brushes and rollers. (See REMARKS)
AVAILABILITY:	Subject to confirmation
PHYSICAL CONSTANTS:	
Colour:	Transparent
Shade No:	00000
Volume Solids:	4%
Flash Point:	Not measurable
Specific Gravity:	1.2 kg/litre 10.0 lbs/US gallon
APPLICATION DETAILS:	
Application Method:	Apply BAJAK PAINT REMOVER 90000 by brush in a thick layer and leave it on for 5-10 minutes after which the paint or varnish is removed with a scraper. Should not normally be left on for more than 1 hour as difficulties may arise when scraping. Alternatively, cover the area in question with a polyethylene sheet to prevent evaporation. On very thick layers of old paint, or if the softened paint dries up, repeat the process. The consumption depends on the nature and the thickness of the paint or varnish to be removed. As a guideline a spreading rate of 3-6 m ² per litre/120-245 sq.ft per US gallon is indicated.
Remarks:	Do not use at temperatures above 35°C/95°F, in direct sunlight, or in strong wind as the evaporation will then proceed too rapidly - alternatively cover with a polyethylene sheet. <u>Subsequent Treatment</u> <u>Wood & Steel:</u> Wash down thoroughly with a weak solution of ammonia water (oak, teak, and mahogany may be discoloured by ammonia), followed by hosing down with fresh water. <u>Brushes & Rollers:</u> Rinse thoroughly in fresh water and hang up. <u>Cautions:</u> Unscrew the lid with caution due to risk of over-pressure in the tin. Do not use on cloth, linoleum, plexiglass, plastics, asphalt floors, and similar. Contains chlorinated solvent. Do not apply on hot surfaces. Do not store or use in direct sunshine or near to heat and open flame (eg: welding and burning) as poisonous gas can develop.
Note:	BAJAK PAINT REMOVER 90000 is for professional use only.
Safety:	Packings are provided with applicable safety labels which should be observed. In addition, national or local safety regulations should be followed. As a general rule, inhalation of solvent vapours or paint mist, and contact of liquid paint and paint remover with skin and eyes should be avoided. Forced ventilation should be provided when working with paint remover in confined spaces or stagnant air. Even when ventilation is provided, respiratory, skin, and eye protection are always recommended.
REISSUED:	Jan. 2011

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2.BAJAK'S POLYURETHANE SEALANT 93555

APPLICATION AND CURING CONDITIONS:	<p>The surface must be completely clean and dry at the time of application. And its temperature must be above the dew point to avoid condensation. Minimum temperature for curing is 5°C/41°F.</p> <p>At the freezing point and below, beware of the risk of ice on the surface which will hinder the adhesion. High humidity and/or condensation during application and the following 16 hours (20°C/68°F) may adversely affect the film formation. Maximum concrete moisture content should be 4%.</p> <p>In confined spaces provide adequate ventilation during application and drying.</p>
PRECEDING COAT:	BAJAK'S EPOXY SEALER 15026 for concrete surface.
SUBSEQUENT COAT:	Acc. To specification.
REMARKS: Film thicknesses:	<p>May be specified in another thickness than indicated depending on purpose and area of use.</p> <p>This will alter spreading rate and may influence drying time and recoating interval</p>
Thinning: Physical property:	Not recommend.

Type of Physical property:	Result	Unit	Standard
Pressure strength	600	Kgf/cm ²	ASTM D695M
Elongation strength	250	Kgf/cm ²	ASTM D638M
Hardness persos	250	Sec	ASTM D4366
Abrasion Resistance	20 mg	1000 cycle	ASTM D4060
Elongation at break	100	%	ASTM D638M

A completely clean surface is mandatory to ensure intercoat adhesion, especially at long recoating intervals. Any dirt,oil,and grease have to be removed, e.g. with suitable detergent.

Salts to be removed by fresh water hosing. To check an adequate quality of the surface cleaning a test patch is recommended before actual recoating.

SAFETY:	<p>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 and national safety regulations. Harmful or fatal if swallowed; immediately seek medical assistance swallowed. Avoid inhalations of possible solvent vapors or paint mist, as well as paint contact with skin and eyes. Apply only on well-ventilated areas and ensure that adequate forced ventilation exists when applying paint in confined spaces or when the air is stagnant. Always take precautions against the risks of fire and explosions.</p>
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Issued:	June 2008
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2.BAJAK'S POLYURETHANE SEALANT 93556

APPLICATION AND CURING CONDITIONS:	<p>The surface must be completely clean and dry at the time of application. And its temperature must be above the dew point to avoid condensation. Minimum temperature for curing is 5°C/41°F.</p> <p>At the freezing point and below, beware of the risk of ice on the surface which will hinder the adhesion. High humidity and/or condensation during application and the following 16 hours (20°C/68°F) may adversely affect the film formation. Maximum concrete moisture content should be 4%.</p> <p>In confined spaces provide adequate ventilation during application and drying.</p>
PRECEDING COAT:	BAJAK'S EPOXY SEALER 15026 for concrete surface.
SUBSEQUENT COAT:	Acc. To specification.
REMARKS: Film thicknesses:	<p>May be specified in another thickness than indicated depending on purpose and area of use.</p> <p>This will alter spreading rate and may influence drying time and recoating interval</p>
Thinning: Physical property:	Not recommend.

Type of Physical property:	Result	Unit	Standard
Pressure strength	600	Kgf/cm ²	ASTM D695M
Elongation strength	250	Kgf/cm ²	ASTM D638M
Hardness persos	250	Sec	ASTM D4366
Abrasion Resistance	20 mg	1000 cycle	ASTM D4060
Elongation at break	100	%	ASTM D638M

A completely clean surface is mandatory to ensure intercoat adhesion, especially at long recoating intervals. Any dirt,oil,and grease have to be removed, e.g. with suitable detergent.

Salts to be removed by fresh water hosing. To check an adequate quality of the surface cleaning a test patch is recommended before actual recoating.

SAFETY:	<p>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 and national safety regulations. Harmful or fatal if swallowed; immediately seek medical assistance swallowed. Avoid inhalations of possible solvent vapors or paint mist, as well as paint contact with skin and eyes. Apply only on well-ventilated areas and ensure that adequate forced ventilation exists when applying paint in confined spaces or when the air is stagnant. Always take precautions against the risks of fire and explosions.</p>
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Issued: June 2008



BAJAK'S THINNERS 08..

BAJAK PAINT is produced and supplied in such a way that thinning is normally not necessary provided the paint is properly mixed/stirred. However, if the paint is to be applied in a low film thickness (for instance as a "sealer coat") or if the paint has become too thick, e.g. in cold weather, the BAJAK THINNER(s) indicated on the product data sheet may be added to obtain a consistency most suitable for application. As a general rule, thinning should be kept at a minimum as the quality of the paint work will suffer from too liberal thinning. However, if application is to take place at high temperatures (air and/or steel), thinning may even beyond the limits mentioned on the data sheets exceptionally be necessary in order to avoid dry-spray and poor film formation. BAJAK'S THINNERS are blended to give the best results with regard to brush ability, spray properties, etc.

In some cases ordinary solvents may substitute. As such products are beyond our control, we disclaim any responsibility for the results.

In each case the respective product data sheet and - when available - the APPLICATION INSTRUCTIONS should be consulted. As regards the use of THINNERS for cleaning of tools, see REMARKS overleaf.

BAJAK'S THINNER NO.	FLASH POINT (Setaflash closed cup)	EXAMPLES OF GENERAL USE
08080	25°C/77°F	BAJAK'S ANTIFOULINGS CLASSICs, NAUTIC SP-ACEs, ECONOMIC SP-SEA and GLOBIC SP-SEA
08230	32°C/90°F	Thinner for BAJALIN qualities (except BAJALIN DECKPAINT 53240)
08450	23°C/73°F	General purpose thinner for BAJAPOX qualities.
08450 F	21°C/70°F	General purpose thinner as cleaner
08510	3°C/37°F HIGHLY FLAMMABLE	Special purpose thinner for BAJATHANE ENAMEL 55100 BAJATHANE TOPCOAT 55210
08570	4°C/39°F	BAJAK'S SHOPPRIMER E 15280 BAJAK'S SHOPPRIMER ZS 15722 BAJAK'S SHOPPRIMER ZS 15890
08700	24°C/75°F	BAJAK'S GALVOSILs For BAJAPOX used as non-popping sealers on GALVOSILs

REMARKS: THINNER 08230 has a stronger thinning effect than white spirit or turpentine.

Tools can usually be cleaned with the THINNER prescribed for the product.

For cleaning of tools which have been used for BAJAPOX products, BAJAK'S TOOL CLEANER 99610 is recommended. Do not use it for thinning, **nor for cleaning after use of polyurethane products, BAJATHANEs.**

Note : **BAJAK'S THINNERS are 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. Harmful or fatal if swallowed; immediately seek medical assistance if swallowed. Avoid inhalation of possible solvent vapours or paint mist, as well as paint contact with skin and eyes. 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. Always take precautions against the risks of fire and explosions.

Issued: March 2004