

## Technical Data Sheet

# Indopoxy 645HB

### Epoxy High Build MIO Coating

## Product Description

Indopoxy 645HB is a Two component EPOXY based polyamide cured highly Corrosion Protective intermediate coating, pigmented with Micaceous Iron Oxide. It provides a tough coating with long term protection.

## Recommended Use

It is recommended as a high build epoxy coating to improve barrier protection for a range of anti-corrosive coating systems in a wide range of environments including offshore structures, petrochemical plants, cement plants, mining equipments and pulp and paper mills and bridges. It also improves long term overcoating properties, better facilitating application in the fabrication shop, prior to shipping, with final overcoating on site.

## Physical Data

Colour	: Reddish Brown
Finish	: Matt
Soild by Volume	: 60 ± 3%
Supply Weight (Kg/ Ltr)	: 1.80±0.05
Flash Point	: 31° C
Dry Heat Resistance	: Intermittent : 140°C, Continuous: 120°C
Shelf Life	: 12 months

## Film Thickness

### Recommended film thickness per coat

Dry Film Thickness	: 75-150μ in single coat
Wet Film Thickness	: 125-250μ in single coat
Therotical Coverage Rate	: 6 sq.mt / lit at recommended DFT of 100μ

## Surface Preparation

All surfaces to be coated should be clean, absolutely dry and oil or moisture free before painting application. Oil and grease should be removed by solvent cleaning.

**Primed Surface:** Primers under Indopoxy 645HB should be applied over blast cleaned surface to St3 or blast cleaned to Sa2 or better. Existing system should be dry and free from loose paint, salt, grease and other contaminants prior to overcoating.

**New steel:** Abrasive blasting to Sa 2½ (ISO 8501-1:2007). 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.

**Maintenance:** Remove oil and grease etc. thoroughly with suitable detergent. Remove salts and other contaminants by high pressure fresh water cleaning. Clean damaged areas thoroughly by power tool cleaning to St 3 (ISO 8501-1:2007) (minor areas) or by abrasive blasting to min. Sa 2, preferably to Sa 2½ (ISO 8501-1:2007). Improved surface preparation will improve the performance of the product.

**Metallic Zinc Primed:** To Ensure that the surface of the primer is clean, dry and free from contamination and zinc salts before application of Indopoxy 645HB. Ensure zinc primers are fully cured before overcoating.

## Application Data

Application Method	: Spray/ Airless Spray/Brush/ Roller
Mixing Ratio	: 5 Part (Base) : 1 Part (Hardener)
Pot Life	: Three Hours at 30°C
Thinner and Cleaner	: Indopoxy Epoxy Thinner (IK.1501)
Airless Nozzle Orifice	: 0.45 - 0.58mm
Nozzle Pressure	: 176 kg/cm <sup>2</sup> or 2500 psi

**Working Precautions:** Material should not be allowed to remain in pipeline, hoses, gun or spray equipment. Thoroughly flush all equipment with IK.1702 thinner. Once units of paint have been mixed they should not be resealed and it is advised that after prolonged stoppages, the work should recommences with freshly mixed units.

**Maintenance:** Clean all equipment immediately after use with IK.1702 thinner. It is good working practice to periodically flush out spray equipment during the course of the working day. All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.

## Drying Characteristics

Surface Dry	: 30 mins
Touch Dry (to Handle)	: 2.0 Hours
Hard Dry	: 24 Hours
Overcoating Interval	: Minimum 2 Hours, Maximum 30 Days

Drying and curing times are determined at 30°C under controlled temperatures and relative humidity below 85 %, and at average of the DFT range for the product.

## Compatibility

Previous Coating	: Epoxy, Epoxy Zinc Rich, Epoxy Mastic, Inorganic Zinc Silicates
Subsequent Coating	: Epoxy, Polyurethanes, Alkyds, Modified Alkyds, Acrylics

## Storage

This is solvent based coating and the containers should be kept in a dry, cool, well ventilated space and away from sources of heat and ignition. Containers must be kept tightly closed.

## Precautions

This product is for professional use only. The paint applicators should be trained, experienced and have the capability and equipment to mix and apply the coatings correctly as instructed. Applicators should use appropriate protection equipment when using this product.

This is solvent based product and should be use under well ventilated conditions. Do not inhale spray mist. Skin contact should be avoided. In case of spillage on the skin, it should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water.

### Limitation of Liability

This information is given to the best of our knowledge. Because of the multitude of formulations, production, and application conditions, all the above-mentioned statements have to be adjusted to the circumstances of the processor. Our products are often used under conditions beyond INDOKOTE's control. INDOKOTE cannot guarantee anything but the quality of the product itself. No liabilities can be derived from this fact for individual cases. This issue replaces all previous versions – Printed in India.

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