



LACNAM PAINTS AUSTRALIA
ABN 48 125 092 482
78-80 MANDOON, ROAD, GIRRAWEE, SYDNEY
NSW 2145 AUSTRALIA
TELEPHONE: (02) 9688 1999 FACSIMILE: (02) 9896 1606
EMAIL: sales@lacnam.com.au WEBSITE: www.lacnam.com.au

TECHNICAL INFORMATION SHEET

287 HIGH BUILD EPOXY BLACK

(Tar Free Epoxy Coating)

May 2009

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Description and uses:

287 High Build Epoxy is a two-pack chemically cured coating which has replaced the older type coal tar coatings. 287 High Build Epoxy has lower toxicity and will out perform coal tar epoxies in all respects. 287 High Build Epoxy has the following features:

- High film builds can be achieved.
- Excellent water immersion resistance.
- Does not contain coal tar.
- Excellent chemical resistance.

Typical areas of application are:

- Marine environments such as barges, ships, off shore structures etc.
- Water holding tanks, pipes, concrete structures, showers, chemical plant, refineries etc.

Note: Some chalking, and bleaching will occur with exterior exposure and contact with various chemicals i.e. (acids, alkalis and hydrocarbons), if not topcoated. This will not detract from the protective / performance properties of this product.

Technical Specifications:

FINISH: Black semi-gloss
MIXING RATIO: Part A / Part B 3/1 (Volume).
THINNERS: T180 epoxy thinner.
POT LIFE: 2 - 3 hours @ 25°C.
VOLUME SOLIDS: 78 - 80% (when mixed).
COVERAGE: 5.0 Square metres per litre at 150 microns D.F.T.
RECOMMENDED FILM THICKNESS: 150-200 microns dry.
APPLICATION: Spray, brush or roller.

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Technical Specifications:

Cure: (25°C & 50% Humidity) at 160 micron DFT.

Touch
5 Hours

Handle
16 Hours

Full Cure
7 Days

Recoat
16 Hours Min
28 Days Max

The above cure times are a guide only as factors such as thinners used, film thickness, ventilation, substrate temperature etc need to be taken into account. Ensure 287 HB Black Epoxy is free of contaminants before overcoating, clean with T192 (Wax & Grease Remover).

Overcoating after the suggested maximum time could reduce intercoat adhesion between coats. Abrade and clean 287 HB Epoxy Black surface with T192 (Wax & Grease Remover) before overcoating.

287 HB Black Epoxy should be Full Cured (7Days) before immersion.

APPLICATION DETAILS – SURFACE PREPARATION

SUBSTRATE	DETAILS
Steel	Abrasive blast according to AS1627.4 Class 2.5 for immersion and class 2 for non-immersion conditions.
Masonry surfaces	Lightly blast or acid etch to remove contaminants. (When applying first coat to masonry surfaces thin approximately 30% with thinner T180)

Surface Preparation:

- When overcoating; Aged paint coatings should be tested for adhesion using Crosshatch or Crosscut methods. If aged paint coating lifts remove it.
- Remove all rust, oxides, millscale and loose paint from metal surface.
- Round off all sharp edges, welding joints and weld spatter.
- All surfaces to be painted should be clean and free from dust, dirt, oil, grease and moisture.
- All abrasive blast clean ferrous surfaces should be coated within 4 hours to avoid flash rusting.
- Do not apply at temperatures below 10° Celsius. Do not apply at relative humidity above 85%, or when the substrate surface is less than 3° Celsius above dewpoint.
- Applied 287 HB Black Epoxy coat subjected to exterior exposure for extended period of time should be accessed for “Chalking” before applying suitable topcoat to achieve optimum intercoat adhesion.

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Application:

Note: For use by experienced industrial applicators. For best results mechanical mixing of Part A (base) and Part B (hardener) is recommended.

Brush or Roller: Thin as necessary to a max addition of 10%. After mixing Parts A & B, allow to stand 10 minutes then apply to substrate. Care should be taken that proper and uniform film thickness is obtained.

Conventional Spray: Thin as necessary to a max addition of 10%. After mixing Parts A & B allow to stand 10 minutes. For air spray application a fluid tip .070" to .086" (E or D DeVilbiss) and an air cap with good break up such as DeVilbiss 704 and 765 will give good results. The fluid pressure should be kept low, about 15 PSI, with just enough air pressure to get good break up of the coating. Excessive air pressure can cause overspray problems.

Airless Spray: Thinning not normally required. Where airless spray equipment is used, use heavy duty 30 to 1 airless pump, tip size .019" to .023" will provide a good spray pattern. Ideally, fluid hose should be 3/8" ID and maximum length 16 metres, not including short 1/4" ID whips. Larger diameter hoses should be used for long fluid lines. Long fluid lines with narrow hoses will greatly reduce fluid pressure at the gun, causing poor spray patterns.

Note: Thinning product may reduce maximum achievable film thickness per coat.

Clean Up: Clean equipment with T180 thinner.

Safety Instructions:

Storage: Store in a cool, dry banded area out of direct sunlight as required for Flammable liquids DG Class 3, PG II, Hazchem 3(Y)E.

Flammability: Highly flammable, all sources of ignition must be eliminated in or near area of use, on burning fumes emitted are toxic. Do not smoke in immediate area.

Handling: Adopt adequate Occupational Work Practices to avoid personal contamination with product. Always wash hands before smoking, eating, drinking or using toilet. Food and Drink should be to stored and consumed in separate area.

Personal Protection: Avoid contact with skin or eyes; wear suitable clothing such as impervious overalls, PVC or neoprene gloves, safety goggles and face mask.

Using: Avoid inhalation of spray mist and vapours – use with adequate ventilation and suitable Personal Protection Equipment (PPE).

Engineering controls: Ensure ventilation is adequate. When spraying, ensure product is applied in a fully functional spray-booth. Keep containers closed when not in use. Do not use near ignition sources.

REFER MSDS BEFORE USE

(Phone 02 9688 1999 or refer to www.lacnam.com.au for copy MSDS)

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