PLASCOTUFF 3000 SURFACE TOLERANT EPOXY

PRODUCT CODE: PEX 3000 Series (Base) & PEH 3 (Curing Agent)

TECHNICAL DATA SHEET

Product Description

A two component high build; high solids surface tolerant epoxy coating.

Intended Uses

For application to a wide variety of substrates including lightly corroded steel, hand and mechanically prepared, abrasive blast cleaned and hydro blasted steel, and a wide range of intact, aged coatings. (Test patch required)

Features & Benefits

- Surface tolerant
- Excellent corrosion resistance
- A high dry film thickness can be obtained
- Available in an aluminium pigmented version to provide superior wet-ability and barrier protection.
- Can be applied to steel or galvanised steel

Product Information

<table>
<thead>
<tr>
<th>Colour</th>
<th>White (PEX 3001), Black (PEX 3002), Grey (PEX 3004), Aluminium (PEX 3005) and a selected colour range via tinting system (PET 3001/2/3)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Appearance</td>
<td>Semi-gloss</td>
</tr>
<tr>
<td>Volume solids</td>
<td>80%</td>
</tr>
<tr>
<td>Recommended DFT</td>
<td>Min: 100 µm Max 200 µm D.F.T.</td>
</tr>
<tr>
<td>Recommended WFT</td>
<td>Min: 125 µm Max: 250 µm W.F.T.</td>
</tr>
<tr>
<td>Theoretical Spreading rate</td>
<td>5.3 m²/litre at 150 µm D.F.T. at stated volume solids.</td>
</tr>
<tr>
<td>VOC</td>
<td>150 g/l</td>
</tr>
<tr>
<td>Flash Point</td>
<td>27 °C for both components &amp; mixed paint</td>
</tr>
</tbody>
</table>

Application Details

Mixing ratio

4 parts PEX 3000 (base) to 1 part PEH 3 (curing agent) by volume

Mixing

Stir both components separately with a power mixer until homogenous. Add the hardener to the base and mix thoroughly together. Mix only in proportions shown above. Do not split packs.

Method

Airless spray: Recommended Tip size: 0.019” – 0.025”

Nozzle pressure: 172 – 207 bar (2.500-3000 p.s.i)

Conventional Spray (Pressure Pot):

Recommended Gun De Vilbiss MBC or JGA, Air Cap 704 or 765

Fluid Tip E

Brush: Min: 100(µm) Max: 125 (µm) can be achieved.

Roller: Typically, 75-100 (µm) can be achieved.

Application Environment

Surface Temperature | Ambient Temperature | Relative Humidity
Min: 10 °C | Min: 10 °C | Min: 10%
Max: 40 °C | Max: 40 °C | Max: 85%
Or 3 °C above dew point

Thinner

Not normally required. Can be thinned with EPOXY REDUCER (EPT 2) if necessary.

Cleaner

EPOXY REDUCER (EPT 2)

Pot life

2 hours @ 23 °C

Drying time

<table>
<thead>
<tr>
<th>Temp</th>
<th>Touch dry</th>
<th>Hard dry</th>
<th>Overcoating Interval</th>
</tr>
</thead>
<tbody>
<tr>
<td>10°C</td>
<td>10 Hrs</td>
<td>24 Hrs</td>
<td>4 Weeks</td>
</tr>
<tr>
<td>23°C</td>
<td>5 Hrs</td>
<td>18 Hrs</td>
<td>2 Weeks</td>
</tr>
<tr>
<td>40°C</td>
<td>2 Hrs</td>
<td>10 Hrs</td>
<td>7 Days</td>
</tr>
</tbody>
</table>

Storage and Packaging

Store away from direct sun, heat, open flames, sparks or severe cold.

Shelf life: 12 months

Dual Packs: 20 ℥ unit: 16 ℥ in a 20 litre container Base (PEX 3000) 4 ℥ in a 5 litre container Curing Agent (PEH 3)

5 ℥ unit: 4 ℥ in a 5 litre container Base (PEX 3000) 1 ℥ in a 1 litre container Curing Agent (PEH 3)
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Surface Preparation
Prior to paint application all surfaces should be assessed and treated in accordance with ISO 8504:1992.

STEEL:
- The surfaces to be over coated must be clean, dry and free from contamination.
- Oil and grease should be removed using PLASCON AQUASOLV DEGREASER (GR1) followed by clean water rinses.
- Dust and debris not to exceed 0.3% when tested in accordance with SANS test method 769.
- Soluble chloride content may not exceed 75mg per m².
- Preferred surface preparation is abrasive blast cleaned to Sa 2½ of the International standard ISO 8501-1:1988 to achieve a blast profile 50 - 75µm or mechanically abrade to Grade St 3 of ISO 8501-1:1988.
- The primer must be applied before oxidation of the steel occurs. If oxidation does occur the entire oxidised area should be re-blasted to the standard specified above.

GALVANISED STEEL:
- Preferred surface preparation: Sweep blast using Garnet Mica to achieve a blast profile of 30 – 40 µm. or if sweep blasting is not possible, clean surface area using PLASCON GALVANISED IRON CLEANER (GIC 1) and rinse until a water break free surface is obtained.

Caution
- This product is not suitable for immersion.
- Will not cure adequately below 10°C. For maximum performance curing temperature should be 3°C above dew point.
- In common with all epoxies, these products will chalk on exterior exposure. Rate of chalking will depend on climatic conditions.
- This product is not recommended where thermoplastic coatings such as chlorinated rubbers and vinyl’s have been previously been used.
- Please Note maximum over coating intervals.

Safety Precautions
- Always keep paint out of reach of children.
- Ensure good ventilation during application and drying.
- If accidental contact with skin should occur, wash immediately with soap and water or a recognised skin cleaner.
- Take care to avoid contact with the eyes. In case of contact, immediately rinse the eyes with plenty of water and seek medical attention.
- Harmful if swallowed. Seek medical attention and do not induce vomiting.
- Do not smoke while painting.
- Flammable. Store in a cool dry place away from heat and sparks.
- Refer to Material Safety Data Sheet for complete information.

Shipping Weight
UN Shipping No: 1263
Dual Pack: 20 ℥ - 27,51kg (PEX 3000), 5 ℥ - 4,276kg (PEH 3)
Dual Pack: 5 ℥ - 6,966kg (PEX 3000), 1 ℥ - 1,12kg (PEH 3)

DISCLAIMER:
The recommendations contained herein are given in all good faith and are meant to guide the specifier or the user. They are based on results gained from our tests and experiences and are believed to be reliable. No guarantee is implied by the recommendations contained herein since conditions of use, method of application and cleanliness of the substrate prior to painting are beyond our control.

N.B. Technology may change with time necessitating changes to this Technical Data Sheet (TDS). It is the responsibility of the user to ensure that the latest TDS is being used.

NB: TO ORDER: Quote product name, product code number, packaging and colour.

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