

PLASGARD 410[®]

Solvent Free Epoxy Coating

DESCRIPTION	PLASGARD 410 is a two pack high build solvent free epoxy coating. It is capable of underwater curing in either salt or fresh water.	
USES	For use against a wide range of acids, alkalis and organic chemicals. A highly abrasion-resistant coating providing long-term protection in aggressive erosion/corrosion situations. Suitable as a coating for concrete surfaces. <i>DRY INSERVICE TEMPERATURE RANGE : up to 120°C</i> <i>Areas of Use :</i> For concrete and steel surfaces in the water and food industries; Industrial plant; Pipe and tank linings; Storage tanks; Offshore and Marine structures; Reservoirs.	
COLOUR	Red, Black, Blue and White.	
PHYSICAL PROPERTIES	<i>Flash Point</i> <i>Volume Solids</i> <i>Specific Gravity</i> <i>Drying Times at 20°C :</i>	NON FLAMMABLE 100% 1.3 (Mixed) Surface Dry : 120 minutes Hard Dry : 16 hours Drying times may be extended at lower temperatures.
STORAGE	Minimum of 2 years when stored in original sealed containers at temperatures below 35°C.	
POT LIFE	40 minutes at 20°C. Increase in temperature will decrease pot life. Only mix enough to be used within the pot life. Mixed material should not be included in subsequent mixes.	
THINNING/CLEANING	Not to be thinned. Clean all equipment with SOLVENT 102 immediately after use.	
THEORETICAL COVERAGE	Up to 4 sq.m. per litre – subject to surface profile, conditions and application techniques at 250 microns dft.	
FILM THICKNESS	Wet : 250 microns	Dry : 250 microns
HEALTH & SAFETY	NON FLAMMABLE. Wear face mask when spraying and ensure adequate ventilation. Avoid contact with skin and eyes. Material Safety Data Sheets giving full information are available.	
PACKAGING	For brush application	0.75 litre packs
	For spray application	5 litre packs

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These brief instructions should be used as a guide to surface preparation and application methods. A product data sheet and further technical information can be obtained from LONG PRODUCTS.

SURFACE PREPARATION

All surfaces should be :

- smooth, clean and free from projections
- brushed clean of any dust or debris and
- if oil or grease contamination is suspected, remove with Solvent 102

Ideally steel surfaces should be wet abrasive blast cleaned to ISO 8501 (Grade 2½) (for immersed conditions Grade Sa 3 is recommended.) Less efficient methods of surface preparation may result in a reduction in the life of the system. In dry conditions and/or where environmental conditions do not permit blast cleaning, the surface should be at least wire brushed.

Concrete must be clean and dust free; laitance and other contaminants must be removed before application.

MIXING

Supplied in 2 parts
Mixing Ratio

Part A (Base) / Part B (Curing Agent)
Part A2 : 1 Part B (by volume)

If dual feed hot airless spray equipment is to be used, consult Long Products. When Part A and Part B are to be mixed from spray equipment, bring each part separately to 20°C to assist mixing. Stir contents of Part A, continue to stir and gradually add the total contents of Part B. Mix thoroughly.

Mix only enough to be used within the recommended pot life. Materials nearing the end of their pot life MUST NOT be mixed with freshly mixed coating.

Pot Life

40 minutes at 20°

Increase in temperatures will decrease pot life.

APPLICATION

Do not apply when the temperature of the substrate or atmosphere is below 0°C

Where spray application is not possible, short stiff bristle brushes or nap rollers should be used. A minimum of two coats will be required when using brush or roller

application to ensure the coating is free from holidays, thin edges, runs, snags, etc.

Roller application is recommended for underwater application.

DRYING AND OVERCOATING

The coating becomes tack free after 2 hours at 20°C and hard dry after 16 hours.

The maximum time prior to overcoating is 36 hours at 20°C, if this is exceeded then light abrasion of the surface using a light flash blast or light wire brushing will be necessary to ensure adhesion of the following coat of PLASGARD 410.

PLASGARD 410 will cure down to 0°C and under fresh and sea water. Curing times are extended at lower temperatures.

Clean equipment after use with SOLVENT 102.

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