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PROTECT ST

SURFACE TOLERANT EPOXY COATING

Product Description

Protect ST is a surface tolerant aluminium filled epoxy primer and has excellent anti corrosive properties. Protect ST can be used in areas where blast cleaning cannot be carried due to cost or environmental restrictions and can be applied to ISO 8501 St3 prepared steel.

Protect ST has excellent adhesion to most aged coatings and has a high film build by brush.

Typical Use

As a surface tolerant primer over aged coatings or mechanically prepared steel. It can be used under AeroShield 180 T15 as a primer in ambient conditions, do not use if the surface exceeds 120°C

Technical Data

Volume Solids 84 %+ /- 2%	Dry Temperature Resistance 120°C maximum	Number of Coats 1 or 2	Solvent Thinner No 6
Colour Aluminium	Finish Satin	Mix ratio 4-1 by volume	Pot Life 10°C 3 Hours. 20°C 2 Hours. 30°C 1 Hour.
Specific Gravity 1.41 kg/L	VOC >25°C	Packaging 5 and 20 Lt Steel pails	

Recommended Dry Film Thickness

	DFT per coat	WFT per coat	Theoretical Spreading rate m2/L
Range	125µm - 300µm	120 µm - 425 µm	8.4- 2.2
Recommended	150 µm	180 µm	5.6

Drying times

Substrate Temperature	Touch Dry	Dry to handle	Dry to re coat Minimum	Dry to re coat Maximum	Full Cure
10°C	6 Hours	24 Hours	18 Hours	15 Days	8 Days
20°C	3 Hours	20 Hours	12 Hours	10 Days	5 Days
30°C	1 Hours	16 Hours	12 Hours	10 Days	3 Days



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Surface Preparation

Blast Cleaning: The performance of this paint will depend on the degree of surface preparation. All surfaces should be clean, dry and free from contamination. Surfaces should be treated in accordance with ISO 8504:2000. The surfaces shall be blast cleaned to min. Sa 2, preferably Sa 2 (ISO 8501-1:2007). The surface profile and the anchor pattern shall be between 40 µm and 70 µm. The abrasives shall be free from oil, grease, moisture, chloride contamination etc.

Power Tool Cleaning: The performance of ProTect ST will depend on the degree of surface preparation. Surfaces should be treated in accordance with ISO 8504:2000. The surface shall be cleaned by high pressure steam/detergent cleaning to remove dirt, grease and/or salt deposits in accordance with SSPC SP1. Power-tool cleaning to min. St 2, preferably St 3 (ISO 8501-1:2007). Care shall be taken to ensure that power-tool cleaning does not polish the steel surface. If the surface being prepared lies adjacent to a coated surface, the power tool cleaning shall overlap the coated surface by at least 25 mm and the coated surface shall be feathered back to a firm edge.

Previously Painted Surfaces: All surfaces should be clean, dry and free from contamination. Surfaces should be treated in accordance with ISO 8504:2000. Ensure compatibility of the coated substrates with the selected paint system. If the remaining part of the existing coating system needs to be sweep-blasted, fine abrasive shall be used to avoid damage to the coating system. When recoating aged coated substrates ensure that the existing coatings will operate at the required temperature.

Application Conditions

The surface temperature must be a minimum of 3° above the dew point. Do not apply to substrates at temperatures below 10°C. Provide adequate ventilation during application and drying. The temperature of the paint should be at least 15°C.

Application Equipment

Airless spray
is the recommended method of application.
Tip pressure at nozzle: 180 - 250 bar.
Nozzle size: 0.41 - 0.58 mm.

Brush and roller
Thin up to 5% as required

Mixing

Mix the base (Part A) to a smooth consistency add the cure (Part b) to the base and mix thoroughly.

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Clean-up

Clean up immediately after use with Thinner No 2 Discard clean up material according to local environmental regulations.

Precautions

This product is for use only by professional Applicators in accordance with information in this Technical Data Sheet and the Safety Data Sheet (SDS). Refer to this product's SDS before using this material.

Material Storage

Store all coating materials in a dry place as close to room temperature as possible. Ideal storage temperature should be between 10°C to 27°C. Keep cans sealed and out of direct sun light when not use. Warm up cold material to room temperature before using. Do not allow the coating to freeze.

This information is given in good faith for the guidance of users but without warranty or liability. Any queries should be referred to our Technical Department. The above information, based on laboratory tests and practical experience has been proved valid at the date marked on the product data sheet. When necessary verify the validity of the product data sheet. The quality of the product is ensured by our operational system, based on the requirements of the standards ISO 9001. As a manufacturer, we cannot be responsible for any damages caused by using the product against our instructions or for inappropriate purposes. This product is for professional use only.