



PROTECTIVE
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PROTECT STC

SURFACE TOLERANT EPOXY COATING

Product Description

Protect STC is a surface tolerant coloured epoxy coating, it has excellent film build properties and is generally used as a high build undercoat / intermediate coating. Protect STC can be used in areas where blast cleaning cannot be carried due to cost or environmental restrictions and has excellent adhesion to ISO 8501 St3 prepared steel

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

Typical Use

As a high build intermediate undercoat ProTect STC can be applied over aged coatings or mechanically prepared steel to ISO 8501 St3

Technical Data

Volume Solids 82 %+ /- 2%	Dry Temperature Resistance 120°C maximum	VOC 148 grams per Litre	Packaging 5 and 20 Lt Steel pails
Colour Grey / Red brown (other colours available subject to minimum order)	Finish Semi Gloss	Number of Coats 1 or 2	Solvent Thinner No 6
Specific Gravity 1.41 kg/L	Flash Point >25°C	Mix ratio 4-1 by volume	Pot Life 10°C 3 Hours. 20°C 2 Hours. 30°C 1 Hour.

Recommended Dry Film Thickness

	DFT per coat	WFT per coat	Theoretical Spreading rate m2/L
Range	100 µm - 400µm	120 µm - 490 µm	8.2- 2
Recommended	150 µm	180 µm	5.5

Drying times

Substrate Temperature	Touch Dry	Dry to handle	Dry to re coat Minimum	Dry to re coat Maximum 2K Coating Only	Full Cure
10°C	6 Hours	24 Hours	18 Hours	Indefinite *	8 Days
20°C	3 Hours	20 Hours	12 Hours	Indefinite *	5 Days
30°C	1 Hours	16 Hours	12 Hours	Indefinite *	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.

Water jetting: Surfaces should be treated in accordance with ISO 8504:2000. All surfaces should be clean, dry and free from contamination. Water jetting in accordance to ISO 8591-4: 2006 to a cleanliness of Wa 2 or better for atmospheric exposure and Wa 2,5 for immersion. Acceptable flash rust degree is M (medium) but degree L (light) is preferred. A water pressure of at least of 1000 bar (approx. 15.000 psi) is recommended

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

Apply using a clean well loaded brush.

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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Thinning

If thinning is necessary, this should be added after mixing of the two components add no more than 10% thinners No 6. Avoid excessive thinning as it will result in lower sag resistance and slower cure.

Clean-up

Clean up immediately after use with Thinner No 6. 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.

Note

* Indefinite all coatings must be clean and sound.

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.