Technical Data sheet

Indopoxy 630HB

Product Description

Indopoxy 630HB is a Two component Polymide cured anti corrosive high performance primer containing Zinc Phosphate as corrosion inhibiting pigments.

Recommended Use

It is recommended as primer on M.S. surface in diverse areas of tank interiors, exteriors, pipelines, structural steel etc. It has also suitable for flow and dip application and provides excellent chemical and corrosion protection. Indopoxy 630HB is recommended for Thermal, Hydro Power Projects, Petrochemical, Transformers and Refineries due to its excellent corrosion and abrasion protection qualities.

Physical Properties

Composition : Epoxy Resin cured with polyamide and pigmented with Zinc Phosphate

Volume Solids	: 60 ± 2%	**Temperature Resistance :**	
Mixing Ratio: Base: catalys	: 4:1 (ByV/V)	Continuous	: 100^0 C
Pot Life:	: Min. 3-5 Hours	Intermittent	: 120^0 C
Application	: Flow/Airless spray/Convetinal spray		
Recommended DFT	: 70-100 µ's per coat	**Flexibility**	: Excellent
Recommended WFT	: 116 - 166 µ's per coat	**Abrasion Resistance**	: Excellent
Theoretical Spreading Rate	: 6 - 8.57 m^2/ ltr	**Colour**	: Grey
Drying Time :		**Finish**	: Matt to Egg Shell
Surface Dry	: Max. 45 Min. @ 30^0C	**Packing** .	: 25 Ltrs combi
Tack Free	: Max. 4 hours @30^0C	**Thinner**	: Thinner IK-1501
Hard dry	: 10-12 Hours@30^0C	**Chemic resistanace:**	
Overcoating Interval :		**Acid & Alkali**	: Very good with top Coat
MIN.	: 10 - 12 Hours	**Oil resistance**	: Very good with top Coat
MAX.	: 60 days	**Solvent Resistance**	: Very good with top Coat

The given drying data must be considered as guidelines only. The actual drying time/times before recoating may be shorter or longer, depending on film thickness,ventilation, humidity, underlying paint system, requirement for early handling and mechanical strength etc

Storage Life : Upto 12 months when kept under sealed and controlled condition.

Surface Preparation

All surfaces should be clean, dry and free from contamination. The surface should be assessed and treated in accordance with ISO 8504. Oil or grease should be removed in accordance with SSPC-SP1 solvent cleaning. Damaged Area Damage area should be prepared with abrasive blast cleaning to Sa 2½ (ISO 8501-1:2007). When abrasive blasting is not possible, mechanical cleaning to St 3 (ISO 8501-1:2007) is acceptable.

Appliaction Details

Stir components A and B separately and then mix the base and Hardener as per recomende mixing ratio. Stir well to homogeneous after mixing base and hardener and allow it to mature for 10-15 minutes stir again before use and during application. For **conventional Spray** Add thinner IK-1501 20-30% to get a proper application pattern. **Brush:** Apply preferably without thinning. However, add up to 5% Thinner IK-1501 if required during the application. Brushing is recommended for stripe coats and touch-ups of critical areas.

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For Airless Spray : Tip Size : 0.017" – 0.031"
Pressure at Nozzle : 180 – 200 kg/cm2
Thinner : Add thinner 5-10%

Recommended system:

Finish Coat:

1. Nippothane 1066F
2. Nippothane 1067HS
3. Nippothane 1070
4. Nippothane 1066HS

Precautions

1. Do not apply in rain, fog or mist and when the surface temperature is 50^0C and above.
2. Material should be used under speculate pot life.
3. The spray machine hose and paint storage equipment should clean with thinner 1501 or 1702 to avoid blockage and damage.
4. Below 10^0 C and above 85% Relative humidity appliaction should be avoided. It creates paint defect.
5. application should be avoided when substrate temperature is less than 3^0C than the dew point temperature

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