SAKSHI LINE 450 (2K EPOXY PHENOL NOVOLAC)

DATA SHEET

DESCRIPTION

SAKSHI LINE 450 high performances, highly cross linked two component Epoxy Phenol Novolac coating with excellent heat, Chemical and Solvent resistance.

PRINCIPAL CHARACTERISTICS

SAKSHI LINE 450 is suitable to use for the internal lining of chemical and crude oil storage tank and process vessels in petrochemical plants.

Heat resistance up to125°C.

SAKSHI LINE 450 having excellent Chemical and solvent resistance

Provides good resistance to aromatic and aliphatic solvents.

SAKSHI LINE 450 to achieve its full chemical resistance properties, after full curing

COLOURS AND GLOSS	Limited range and Gloss level not applicable
BASIC DATA	
Volume solids	65 ±2%
Recommended Dry Film Thickness Theoretical Spreading Rate	85 -125 microns (127-187microns) wet 6.5 m2/l, at 100 microns DFT
Surface dry @ 30 ^{0}C Hard dry @ 30 ^{0}C	4 hours 16 hours
Over coating interval	Min 16 hours Max - 7 days
Flash Point	Part A 26°C; Part B 48°C, Mixed 24°C
Product weight	1.80± 0.03 kg/litre
VOC	286g/lt (calculated

DATA SHEET

RECOMMENDED SUBSTRATE SUBSTRATE CONDITIONS AND TEMPERATURES	-Steel blast cleaned to SSPC SP10 or Sa 2 ½ (ISO 8501–1:2007) -All surfaces to be coated should be clean, dry and free from Contamination. -Oil and greases should be removed as per SSPC-SP1 solvent Cleaning. -Remove weld spatter and smooth weld seams and sharp edges - A sharp, angular surface profile of 50-75 microns is recommended. - Substrate temperature should be at least 3°C above dew point and Maximum relative humidity should be 85%.
INSTRUCTIONS FOR USE	**Mixing Ratio by volume: base to hardener 6:1** - The temperature of the mixed base and hardener should preferably be above 15°C, otherwise extra solvent may be required to obtain application viscosity - Too much solvent results in reduced sag resistance and slower cure - Thinner should be added after mixing the components
POT LIFE	1.5 hours **at** 30 ^{0} C
AIRLESS SPRAY:	
Recommended Thinner	SAKSHI THINNER 400
Volume of Thinner	0-5% depending on required thickness and application conditions
Nozzle Orifice	Approx. 0.43 – 0.53 mm (17– 21thou)
Nozzle Pressure	Approx. 176 kg/ cm^2(2503 psi)
AIR SPRAY	SAKSHI THINNER 400 Use suitable proprietary equipment. Thinning may be required.
BRUSH/ROLLER	Only for touch up and spot repair (50-75 microns) can be achieved
Recommended Thinner	SAKSHI THINNER 400
Volume of Thinner	0-5 %
CLEANING SOLVENT	SAKSHI THINNER 400

DATA SHEET

SAFETY PRECAUTIONS

This is a solvent based paint and care should be taken to avoid inhalation of spray mist or vapour as well as contact between the wet paint and exposed skin and eyes.

ADDITIONAL DATA

Film Thickness and Spreading Rate

Theoretical spreading rate m^2/l	7.65	6.50	5.20
Dft in µm	85	100	125

Maximum dft when brushing (touch up and spot repair) 50µm

Over coating table for DFT up to 125 µm:

Substrate Temperature	20°C	30°C	40°C
Minimum interval	20 Hrs	16 Hrs	14 hours
Maximum Interval	5 days	3 days	3 days

SYSTEM COMPATIBILITY : **SAKSHI LINE 450** is self-priming can be applied directly to the Substrate and can be over coated with itself.
No other primers and top coats are recommended for this Product.

PACK SIZE **20ltr, 10Ltr and 4ltr**

SHELF LIFE 12months minimum at 30°C (86°F).
Store in dry &shaded conditions, away from sources of heat and Ignition.
Protect from frost.