

TECHNICAL DATA SHEET

PERMAGRIP IT 653

HIGH BUILD EPOXY INTERMEDIATE / FINISH

DESCRIPTION: A high build, two component epoxy coating.

RECOMMENDED USE: As a high build undercoat or finish coat over suitable primed steel or concrete surfaces. Suitable for moderate to severely corrosive environments

RESISTANCE TO:

Moisture – Excellent	Aliphatic Solvents –Excellent
Abrasion – Excellent	Weather – Excellent
Acid spillage - Moderate	Petroleum solvent - Excellent

PRODUCT INFORMATION:

Colour: White & limited range

Finish: Semi-gloss

Volume solids %: 65 ± 3% (ASTM-D2697-86)

V.O.C.: 340 g/l (NB. – Thinning will affect VOC compliance and volume solids)

Typical thickness: 100 - 200 microns dry film thickness

Theoretical coverage: 7.5 m²/ltr. @ 100 microns dft

Density: 1.50 ± 0.1 g/cc (mixed)

Flash point: 25°C

Mixing ratio: 4 part base to 1 part curing agent by volume

Shelf life: 24 months from the date of manufacture

Pot life: 1 hour

Pack size: 20 liters (16 litres base + 4 liters curing agent)

FILM THICKNESS AND SPREADING RATE:	MIN.	MAX.	UNIT
Dry film thickness	100	200	µm
Wet film thickness	153	307	µm
Spreading rate	6.5	3.25	m ² /l (theoretical)

This figure makes no allowance for surface profile, uneven application, overspray or losses in containers and equipment. Film thickness will vary depending on actual use and specification.

RECOMMENDED THINNER: Thinner No.5 (5-10%)

DRYING & CURING TIME:

SUBSTRATE TEMPRATURE	15°C	23°C	35°C
Touch dry	3 hours	2 hours	1 hour
Dried to over coat (minimum)	12 hours	10 hours	6 hours
Hard dry	48 hours	36 hours	24 hours

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SURFACE PREPARATION:

Ensure surfaces to be coated are clean, dry and free from all surface contamination

RECOMMENDED COATING SYSTEM:

Primer: PERMAGRIP P 984/PERMAPRIME 984ZR/PERMAGRIP P 400

Topcoat: PERMATHANE T 137 / PERMAGRIP IT 401

Note: The above mentioned is a generally used system for steel structures, and if any alternative systems are required, please contact the KPC's technical team.

RECOMMENDED APPLICATION METHODS:

Airless spray, conventional spray, roller, brush

APPLICATION EQUIPMENT DETAILS:

Airless spray

Nozzle Size : 0.53mm (21 thou)

Fan Angle : 40°

Operating pressure : 115kg/cm² (2200 psi)

Conventional spray

Nozzle Size : 1.27mm (50 thou)

Atmospheric pressure : 2.8kg/cm² (40 psi)

Fluid pressure : 0.7kg/cm² (10 psi)

APPLICATION CONDITIONS AND OVER COATINGS:

This material should preferably be applied at temperatures in excess of 10°C. In conditions of high relative humidity, i.e. 80-85%, good ventilation conditions are essential. Substrate temperature should be at least 3°C above the dew point and always above 0°C. At application temperatures below 10°C, drying and curing times will be significantly extended, and spraying characteristics may be impaired. Application at ambient air temperatures below 5°C is not recommended.

HEALTH AND SAFETY:

Please observe the precautionary notices displayed on the container. Do not breathe or inhale mist. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water and medical attention sought immediately.

Consult Product Health and Material Safety Data Sheet for information on safe storage, handling and application of this product.

Disclaimer: The information in this document is given to the best of KPC Paint's knowledge that based on laboratory testing and practical experience Products are often used under conditions beyond KPC's control and KPC Paints cannot guarantee anything but the quality of the product itself.

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