

TECHNICAL DATA SHEET

PERMAGRIP PF 251

EPOXY PHENOLIC PRIMER/FINISH

DESCRIPTION: PERMAGRIP PF 251 – A two component phenolic epoxy primer/finish

RECOMMENDED USE: For use as part of a two coat system for internal coating of crude oil

storage tanks and vessels containing water at temperatures up to 100°C. Suitable for insulated external carbon steel surfaces including equipment and pipework operating up to 200°C. Dry heat resistance

230°C maximum.

RESISTANCE TO: Moisture – Excellent Alkali spillage – Excellent

Abrasion – Excellent Acid spillage - Moderate
Petroleum Solvents – Excellent Aliphatic Solvents – Excellent

Weather – Excellent

PRODUCT INFORMATION:

Colour: Off white Finish: Matt

Volume solids %: $65 \pm 1 \%$ (ASTM-D2697-86)

V.O.C.: 235 g/l (NB. – Thinning will affect VOC compliance and volume solids)

Typical thickness: 100 - 150 microns dry film thickness

Theoretical coverage: 6.5 m²/ltr. @ 100 microns dft

Density: $1.5 \pm 0.1 \text{ g/cc (mixed)}$

Flash point Base: 24°C C/A: 24°C

Mixing ratio: 4 parts base to 1 part curing agent by volume Shelf life: 24 months from the date of manufacture

Pot life: 2 hours @ 35°C

Pack size: Comp. A - 16 liters + Comp. B - 4 liters = 20 liters

FILM THICKNESS AND SPREADING RATE:	MIN.	MAX.	UNIT
Dry film thickness	100	150	μm
Wet film thickness	154	231	μm
Consodios vata	CF	4.2	2/1/41

Spreading rate 6.5 4.3 m^2/I (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.

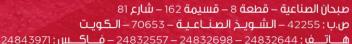
SERVICE TEMPERATURE: 230°C maximum dry

RECOMMENDED THINNER: Thinner No.5 (5%)

DRYING & CURING TIME:

SUBSTRATE TEMPRATURE	15°C	23°C	35°C
Touch dry	5 hours	4 hours	3.5 hours
Dried to over coat (minimum)	24 hours	16 hours	12 hours
Hard dry	36 hours	24 hours	16 hours
Fully cured	15 days	7 days	4 days







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SURFACE PREPARATION:

Steel: Remove all oil and grease in accordance with SSPC-SP1. Manually prepared surfaces should be prepared in accordance with SSPC-SP2 or SSPC-SP3. For more severe exposure, conditions blast cleaning to SSPC-SP 7 may be required. Abrasive blast clean to Sa 2 ½ BS7079:Part A1:1989. Average surface Profile 35 - 75 microns.

RECOMMENDED COATING SYSTEM:

Primer – Permagrip PF 251 Intermediate – Permagrip PF 251 Topcoat – Permagrip PF 251

Please contact KPC's technical team for system recommendations.

RECOMMENDED APPLICATION METHODS: Airless spray, Conventional spray & Brush

APPLICATION EQUIPMENT DETAILS:

AIRLESS SPRAY: CONVENTIONAL SPRAY:

Nozzle Size: 0.44mm (18 thou)

Nozzle Size: 1.27mm (50 thou)

Fan Angle: 30° Atomising pressure: 2.8kg/cm² (40 psi)
Operating Pressure: 233kg/cm² (3300 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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صبحان الصناعية – قطعة 8 – قسيمة 162 – شارع 81 ص.ب : 42255 – الشــويـخ الصـنــاعـيـة – 70653 – الــكـويــت هــــاتـــف : 24832644 – 24832559 – كــاكـــس : 24843971

Sabhan Industrial - Block 8 - Avenue 162 - Street 81 P.O. Box 42255 - Shuwaikh Industrial, 70653 Kuwait Tel. : +965 24832644 - 24832698 - 24832557 - Fax : +965 24843971