

## 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 ± 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 m<sup>2</sup>/ltr. @ 100 microns dft  
 Density: 1.5 ± 0.1 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
Spreading rate	6.5	4.3	m <sup>2</sup> /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.

**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

# PERMAGRIP PF 251

## EPOXY PHENOLIC PRIMER/FINISH

### 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:

Nozzle Size: 0.44mm (18 thou)

Fan Angle: 30°

Operating Pressure: 233kg/cm<sup>2</sup> (3300 psi)

#### CONVENTIONAL SPRAY:

Nozzle Size: 1.27mm (50 thou)

Atomising pressure: 2.8kg/cm<sup>2</sup> (40 psi)

Fluid Pressure: 0.7kg/cm<sup>2</sup> (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.

Date of issue 22.02.2021. Please note that this data sheet supersedes the previous version.