

TECHNICAL DATA SHEET

PERMALINE GF 922

SOLVENT FREE GLASS FLAKE EPOXY COATING

DESCRIPTION: A two component, amine cured, high build heavy duty epoxy coating containing glass flakes and corrosion inhibiting pigments.

RECOMMENDED USE: As a glass flake reinforced lining for both steel and concrete tanks. For the protection of steel or concrete structures in severe corrosive or abrasive environments such as splash zones, off shore structures and immersed conditions. It can be applied at 1000 microns in one coat.

RESISTANCE TO:	Moisture – Excellent	Alkali spillage – Excellent
	Abrasion – Excellent	Acid spillage - Moderate
	Petroleum Solvents – Excellent	Aliphatic Solvents – Excellent
	Sea water - Excellent	

PRODUCT INFORMATION:

Colour:	Limited range	
Finish:	Semi-matt	
Volume solids %:	100 % (ASTM-D2697-86)	
V.O.C.:	0 g/l (NB. – Thinning will affect VOC compliance and volume solids)	
Typical thickness:	250 - 1000 microns dry film thickness	
Theoretical coverage:	4 m ² /ltr. @ 250 microns dft	
Density:	1.4 ± 0.1 g/cc (mixed)	
Flash point	Base : >100°C	C/A : >23°C
Mixing ratio:	3 parts base to 1 part curing agent by volume	
Shelf life:	12 months from the date of manufacture	
Pot life:	3 hours @ 35°C	
Pack size:	Comp. A – 11 liters + Comp. B – 4 liters = 15 liters	

FILM THICKNESS AND SPREADING RATE:

	MIN.	MAX.	UNIT
Dry film thickness	250	1000	µm
Wet film thickness	250	1000	µm
Spreading rate	4	1	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.

SERVICE TEMPERATURE: Maximum dry exposure: 140°C and in water: 45°C

RECOMMENDED THINNER: Thinning is not recommended

DRYING & CURING TIME:

SUBSTRATE TEMPRATURE	15°C	23°C	35°C
Touch dry	3 hours	2 hours	1 hour
Dried to over coat (minimum)	16 hours	12 hours	8 hours
Walk-on-dry	36 hours	24 hours	12 hours
Dried/cured for service	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. For any surface imperfections, pitted steel or cracks use our epoxy putty, i.e. Permafill F 303 to get a smooth and gentle finish.

Concrete: The concrete must be fully cured and have water content less than 4% water capillary activity must be absent. Oil, grease, waxes and similar to be removed by sanding or grinding. Laitance layer to be removed by disc sanding, grinding or shot blasting. All cracks and holes must be treated properly with our epoxy smooth putty, i.e. Permafill F 303. The concrete surface to be painted should be dry, clean, free from laitance, dust, old paint residues (if any) and any other surface contaminants. Please refer to the product data sheet for further information about the surface preparation, paint application, drying time, over coating interval and application conditions.

RECOMMENDED COATING SYSTEM:

Primer for steel – Permagard P 270 (If required)

Primer for concrete – Permagard P 230 (If required)

Topcoat – Permaline GF 922

RECOMMENDED APPLICATION METHODS: Airless spray Roller

APPLICATION EQUIPMENT DETAILS:

AIRLESS SPRAY:

Nozzle Size: 0.92mm (36 thou)

Fan Angle: 40°

Operating Pressure: 115kg/cm² (3000 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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