

1. DESCRIPTION

IMPA TUFFCOTE is a two component solvent blend of epoxy resin and polyamine adducts. The product is air drying and is a high performance system for i.e. aluminium, galvanizing, steelwork and Phenolic Sheeting.

Provides long term corrosion protection of both ferrous and non-ferrous surfaces. This type of anine systems is also highly suitable as a lining system for water, chemical and fuel storage tanks.

2. PRODUCT FEATURES

- Suitable for contact with potable water.
- Dry service temperature up to 100°C.
- Excellent adhesion on correctly prepared surfaces.
- Good resistance to mechanical damage and abrasion.
- If fully cured it offers outstanding resistance to a wide range of industrial chemicals.
- Seamless and hygienic
- Available in range of colours
- Excellent protective qualities
- Can be used on a variety of substrates
- Gloss finish, easy to clean
- Excellent **flow** and **leveling** properties

3. LIMITATIONS

- The product will chalk on surface when exposed to sunlight.

4. SURFACE PREPARATION

STEEL SURFACES

- Decrease surfaces with **IMPA CLEANING THINNERS** followed by a high pressure water rise
- Grind and fettle weld spatter, protrusions & sharp edges to a minimum radius of 2 mm
- Abrasive blast clean to grade SA 2½ of ISO 8501-1 with blast profile 70- 100 µm
- Alternatively mechanically abrade the surface using grinding discs to achieve a similar profile **GALVANIZING**
- New Galvanizing – degree using **IMPA GALVANIZED IRON CLEANER**.
- Old Galvanizing – Abrade or abrasive blast with ultra-fine grit to remove corrosion product **ALUMINIUM**

HIGH PERFORMANCE FINISHES

TUFFCOTE EPOXY

TECHNICAL DATA

<i>Product Code</i>	EP602 Base: White & Standard Colours EP601 : Activator: Pale Translucent
<i>Pot Life</i> <i>Colour</i> <i>Appearance</i> <i>Shelf life</i> <i>Packaging</i> <i>Flashpoint</i>	90 min @23°C White & Standard Colours High Gloss 24 Months 5L 38°C
<i>Viscosity</i> <i>S.G (weight)</i> <i>Solids per volume</i> <i>Solids per mass</i>	Mixed: 100– 105Ku/23°C 1.33– 1.36g/cm³ 63-64% 59– 60%
<i>Practical Spreading rate</i> <i>(depending on porosity)</i> <i>Recommended finishing coats.</i>	4-5m²/L per coat @ 120µm 2 minimum
DRYING TIME <i>Touch dry time</i> <i>Recoating Time</i> <i>Full Cure</i>	 2-3 Hours at 23°C 4-6 Hour s at 23°C 3- 4Days
APPLICATION <i>Roller & Brush (Mohair preferred)</i> <i>Mixing Ratio</i>	 Ready for use 4 Base : 1 Activator by Volume
<i>Cleaning</i> <i>Mixing</i>	IMPA Epoxy Thinners IMPA Epoxy Thinners if needed

- Abrade lightly with aluminium oxide paper/water paper 200 grit to bright metallic finish
- Alternatively use an approved chemical conversion process **GRP**
- Abrade to a uniform matt finish using 200 grit water paper

5. MIXING

- Stir the base component well with a flat- bottomed paddle or mechanical mixer until product is uniform. Continue stirring and add the entire contents of the activator container. Continue stirring until the mixture is homogeneous.

6. APPLICATION

Brush: Apply uniform, even coating with high quality brushes.

Rollers: Apply uniform, even coating with short pile rollers.

Airless Spray: Pump ratio – 30 to 1 Min
Nozzle Orifice – 13 to 15 Thou
Tip Pressure – 145 Bar Min

Conventional Spray:

Air Assisted Airless
Pressure Pot – Pressure Feed Gun
Gravity Feed Gun
Various Nozzle sets are available to suit guns

7. PRECAUTIONS

In order to limit minor colour variations from batch to batch, it is advisable to use product from the same batch on large open areas. Batches may be factory blended on request.

- Application should be avoided in cold and moist weather conditions.
- **Do Not** apply the product at surface temperatures below 6°C (minimum of 2°C above dew point) and temperatures above 40°C
- **Do Not** apply if ambient temperature is less than 10°C or more than 40°C.
- **Do Not** apply if relative humidity temperature is less than 10°C or more than 85. °C
- Extremely cold conditions will make the drying time longer.
- Paint in area where there is good ventilation.
- Ensure that recommended mixing ratio is adhered to
- Discard any mixed material left over from the previous day
- **HARDENER** reacts readily with moisture. **Do not** expose to high humidity. Keep containers tightly sealed when not in use.
- **HARDENER** contains isocyanate – use suitable respirator, particularly during spray application of the mixed material.
- Take care with surface preparation

Environmental Health & Safety Information

DANGER! CONTAINS SULFAMIC ACID. CAN BURN EYES AND SKIN. SEVERELY HARMFUL IF SWALLOWED. HARMFUL IF INHALED. AVOID BREATHING IN DUST, MIST OR VAPORS. USE ONLY IN A WELL VENTILATED AREA. MAY CAUSE COUGHING, WHEEZING, THROAT IRRITATION, SHORTNESS OF BREATH, HEADACHE, NAUSEA OR VOMITING. DO NOT MIX CONTENTS WITH CHLORINE BLEACH OR ANY OTHER CLEANING PRODUCT OR DETERGENT. TO DO SO MAY EXPOSE YOU TO DANGEROUS GASES. MIX ONLY IN PLASTIC CONTAINERS.

Wear protective clothing, eyegoggles and acid resistant rubber gloves and footwear. Avoid contact with eyes and skin. **FIRST AID: If Swallowed:** Do not induce vomiting. Have victim drink lots of milk or water if conscious. Get medical attention immediately! **Eye and Skin Contact:** Flush immediately with plenty of water for at least 15 minutes; spread eyelids and occasionally flush underneath them. **Get medical attention immediately!** Remove contaminated clothing and shoes immediately. Wash contaminated clothing before reuse. If experiencing Respiratory Discomfort (e.g., throat irritation, coughing, wheezing): Remove victim to fresh air. Get medical attention immediately!

CAUTION: KEEP OUT OF REACH OF CHILDREN AND ANIMALS - DO NOT TAKE INTERNALLY.

Refer to Material Safety Data Sheet for additional health and safety information.

IN CASE OF FIRE: Use foam, CO₂, dry chemical, or water fog.

SPILL – Absorb with inert material and dispose of as specified under **Thinning/Clean-up**.

DISCLAIMER

The technical information contained in this document are given in good faith and are meant to be used as a guideline by the specifier or user. Whilst we are confident about the quality of our products, we cannot accept any liability for the incorrect use or application of our products. Surface preparation forms an integral part of the scope of works and it is expected that the highest standards are maintained during surface preparation and application, to ensure that our products perform as intended. Always ensure to use the same product batch numbers, refrain from doing spot touch-ups and paint surfaces from corner to corner to prevent colour and sheen variance. As technology may change over time we reserve the right to change products to keep up with changes in raw materials or product trends without pre notice. Although we will always prevail to keep clients informed about changes to be made, but cannot bind ourself to such notes Please ensure the use of the latest Technical Data Sheet.

Please note: that all our latest Product Data Sheets and Material Safety Data Sheets are available for viewing on our website at www.impa.co.za. All information listed is owned or used under licence of Impa Paints and its related companies. © 2010 Lurama 149 (Pty) Ltd. All rights is reserved.