

Epoxy

PRODUCT DESCRIPTION

Enviroline 58HS is a high solids, low viscosity 250g/l VOC compliant rust inhibitive epoxy polyamide primer designed as an excellent holding primer for interior or exterior steel, concrete, and masonry surfaces requiring an extended recoat window.

INTENDED USES

For use as an anti-corrosive holding primer prior to application of chemically resistant linings in the Enviroline range.

Enviroline 58HS displays a number of benefits:

- Spray, roller or brush applied
- Long pot life
- Excellent adhesion
- Excellent corrosion resistance

Applications include off-shore rigs, tanks, rail cars and machinery.

PRACTICAL INFORMATION FOR ENVIROLINE 58HS

Colour	Tan
Gloss Level	Not applicable
Volume Solids	72%
Typical Thickness	50-100 microns (2-4 mils) dry equivalent to 69-139 microns (2.8-5.6 mils) wet
Theoretical Coverage	9.60 m ² /litre at 75 microns d.f.t and stated volume solids 385 sq.ft/US gallon at 3 mils d.f.t and stated volume solids
Practical Coverage	Allow appropriate loss factors
Method of Application	Airless Spray, Brush, Roller

Drying Time

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			Minimum	Maximum
25°C (77°F)	5 hours	12 hours	8 hours	90 days

REGULATORY DATA

Flash Point (Typical)	Part A 27°C (81°F); Part B 27°C (81°F); Mixed 27°C (81°F)		
Product Weight	1.44 kg/l (12.0 lb/gal)		
VOC	2.03 lb/gal (244 g/l)	EPA Method 24	

See Product Characteristics section for further details

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SURFACE PREPARATION

All surfaces to be coated should be clean, dry and free from contamination. Prior to application all surfaces should be assessed and treated in accordance with ISO 8504:2000
Oil or grease should be removed in accordance with SSPC-SP1 solvent cleaning.

Steel Substrates

For immersion service or service in humid conditions or elevated temperatures, this product should be applied to surfaces which have been prepared by abrasive blast cleaning to Sa3 (ISO 8501-1:2007), SSPC SP5 or NACE #1. For dry environments abrasive blast cleaning to Sa2½ (ISO 8501-1:2007), SSPC SP10 or NACE #2 will be suitable. A minimum surface profile of 75 microns (3 mils) is required.

Enviroline 58HS must be applied before oxidation of the steel occurs. If oxidation does occur the entire oxidised area should be reblasted to the standard specified above. Surface defects revealed by the blast cleaning process should be ground, filled or treated in the appropriate manner.

Concrete Substrates

Concrete should be well cured prior to priming with the appropriate primer. The concrete surface should be dry and pass the plastic sheet test (ASTM D4263). All surfaces should be clean, dry and free from curing compounds, release agents, trowelling compounds, surface hardeners, efflorescence, grease, oil, dirt, old coatings and loose or disintegrating concrete. All concrete surfaces must also be abrasive blast cleaned to provide a roughened surface and remove laitance. The surface tensile strength (ASTM 4541) as prepared should be at least 2MPa (300 psi). Refer to the Concrete Surface Preparation Guidelines for more information.

APPLICATION

Mixing	Material is supplied in two containers as a unit. Complete units should be stored, mixed and applied in accordance with the Enviroline Application Guidelines.	
Mix Ratio	3 part(s) : 1 part(s) by volume	
Working Pot Life	25°C (77°F) 3 hours	
Airless Spray	Recommended	Tip Range 0.48-0.65 mm (19-26 thou) Total output fluid pressure at spray tip not less than 177 kg/cm ² (2517 p.s.i.)
Brush	Suitable	
Roller	Suitable	
Thinner	Enviroline 76T	Do not thin more than allowed by local environmental legislation
Cleaner	Enviroline 71C	
Work Stoppages	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with Enviroline 71C. Once units of paint have been mixed, they should not be resealed and it is advised that after prolonged stoppages, work recommences with freshly mixed units.	
Clean Up	Clean all equipment immediately after use with Enviroline 71C. It is good working practice to periodically flush out spray equipment during the course of the working day. Frequency should depend upon amount sprayed, temperature and elapsed time, including any delays.	
	All surplus material and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.	

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PRODUCT CHARACTERISTICS

The detailed Enviroline Application Guidelines should be consulted prior to use.

This datasheet provides general guidance on the use of Enviroline 58HS. Specific project requirements will be dependent upon the service end use and operating conditions of the tank or vessel.

The detailed project coating specification provided by International Protective Coatings must be followed at all times.

Stripe coating is an essential part of good working practice and as such should form part of any lining specification.

Surface temperature must always be a minimum of 3°C (5°F) above dew point.

Use the following chart for preferred temperature conditions. These conditions plus adequate ventilation must be maintained throughout the curing cycle.

	<u>Substrate Temperature</u>	<u>Air Temperature</u>
Preferred	21-32°C (70-90°F)	21-32°C (70-90°F)
Minimum	13°C (55°F)	13°C (55°F)

Enviroline 58HS is not suitable for use on heavily pitted steel.

Maximum continuous dry temperature resistance for Enviroline 58HS is 121°C (250°F). Enviroline 58HS may discolour at temperatures above 60°C (140°F). Maximum immersion service temperature is 60°C (140°F).

Note: VOC values are typical and are provided for guidance purpose only. These may be subject to variation depending on factors such as differences in colour and normal manufacturing tolerances.

Low molecular weight reactive additives, which will form part of the film during normal ambient cure conditions, will also affect VOC values determined using EPA Method 24.

SYSTEMS COMPATIBILITY

Enviroline 58HS is compatible with a wide range of Enviroline linings. Please refer to the project coating specification for details.

Enviroline 58HS should always be used as part of a system; it is not intended to be a single coat system.

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ADDITIONAL INFORMATION

Further information regarding industry standards, terms and abbreviations used in this data sheet can be found in the following documents available at www.international-pc.com:

- Definitions & Abbreviations
- Surface Preparation
- Paint Application
- Theoretical & Practical Coverage
- Envioline Application Guidelines

Individual copies of these information sections are available upon request.

SAFETY PRECAUTIONS

This product is intended for use only by professional applicators in industrial situations. All work involving the application and use of this product should be performed in compliance with all relevant national Health, Safety and Environmental standards, regulations and legislation.

Proper ventilation must be provided during application and afterwards during curing (refer to product datasheets for typical curing times) to ensure safe limits and prevent fires and explosions. Forced extraction will be required in confined spaces. Ventilation and/or respiratory personal protective equipment (airfed hoods or appropriate cartridge masks) must be provided during application and curing. Take precautions to avoid skin and eye contact (overalls, gloves, goggles, masks, barrier cream, etc).

Before use, obtain, read and then follow the advice given on the Material Safety Data Sheets (Parts A and B if two-pack) and the Health and Safety section of the Coatings Applications Procedures for this product.

In the event that welding or flame cutting is performed on metal coated with this product, dust and fumes will be emitted which will require the use of appropriate personal protective equipment and adequate local exhaust ventilation.

The detailed safety measures are dependent on application methods and the work environment. If you do not fully understand these warnings and instructions or if you cannot strictly comply with them, do not use the product and consult International Protective Coatings.

Warning: This product contains liquid epoxies and modified polyamines and may cause skin sensitisation if not used correctly.

PACK SIZE	Unit Size	Part A		Part B	
		Vol	Pack	Vol	Pack
	20 litre	13.5 litre	20 litre	4.5 litre	5 litre
	4 US gal	3 US gal	5 US gal	1 US gal	2 US gal
For availability of other pack sizes, contact International Protective Coatings.					
SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A		Part B	
	20 litre	20.12 kg		4.19 kg	
	4 US gal	39.5 lb		9.5 lb	
STORAGE	Shelf Life	24 months minimum at 25°C (77°F) in original, unopened containers. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.			

Important Note

The information in this data sheet is not intended to be exhaustive; any person using the product for any purpose other than that specifically recommended in this data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at their own risk. All advice given or statements made about the product (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing to do so, we do not accept any liability at all for the performance of the product or for (subject to the maximum extent permitted by law) any loss or damage arising out of the use of the product. We hereby disclaim any warranties or representations, express or implied, by operation of law or otherwise, including, without limitation, any implied warranty of merchantability or fitness for a particular purpose. All products supplied and technical advice given are subject to our Conditions of Sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is liable to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to check with their local representative that this data sheet is current prior to using the product.

This Technical Data Sheet is available on our website at www.international-marine.com or www.international-pc.com, and should be the same as this document. Should there be any discrepancies between this document and the version of the Technical Data Sheet that appears on the website, then the version on the website will take precedence.

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