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Product Data Sheet

"PHILATRIA PLASTOFOND AS"

Product Information

Double-component, epoxy-polyamide, high thickness, intermediate primer – it can be applied at low temperatures and with high humidity. Philatria Plastofond AS is a "surface tolerant", epoxy-polyamide resins-based coating, with braking, lamellar pigments. This composition provides the product with excellent and easy applicability and maintenance, strong adhesion on the uncoated substrate or surfaces primed with epoxy primers or organic – inorganic zincking products. The dry film is hard – elastic, waterproof, extremely filling. It can be over-applied with different kinds of finishes (chlorine-caoutchouc, vinyl, epoxy, polyurethane finishes).

Philatria Plastofond AS displays very good compatibility with various well-known producers.

Recommended Purpose

Product is suitable for iron surfaces or external substrates of industrial and sea structures, which have been primed with zincking products. It can also be applied over concrete, wooden, light alloy surfaces. It is recommended for industrial, marine and country humid environments. immersion in fresh and sea water, salt solutions, oil, petrol, diesel oil.

Physical Properties

Sheen: Flat

Colors: Yellow – pale and dark grey

Volume Solids (%): 60 ± 2

Theoretical spreading rate Sq.m/L – gr/m2: 7,5 Sq.m./l. - 187 g/Sq.m. for two coats

Typical thickness wet/dry micron: 134 wet / 80 dry

Flash Point: 26 °C

Density Kg/Lit.: 1,40 ± 0,05

Heat resistance: 120 °C outdoors

Application Data

Mixing Ratio: Base 85, Curing Agent 15 by weight.

Readiness Time: 15 minutes in a proper temperature.

Thinner: Epoxy Thinner PH 300, non-toxic thinner or ethyl alcohol

Pot Life: 8 hours at 20 °C

Painting Method:

Brush: 2 - 5% thinning

Roller: 3% not optimal thinning

Spray - not optimal: 10 - 15 % thinning. Nozzle's diameter 1,7 – 1,9 mm. Tank Pressure 4 – 5 kg/ m^2 (atm).

Airless spray: 3 - 7 % thinning. Nozzle's diameter 0,5 – 0,6 mm.

Compression Ratio 45:1. Exit Pressure 150 – 180 kg/ m^2 (atm).

Use proper equipment. Actual safety measures and precautions are very important from the selected method and environment work. Emergency Contact Numbers are available Worldwide upon any request.

Optimal Application Conditions:

The temperature of the substrate should be at least 3°C above the dew point of the air. Temperature and relative humidity should be measured near the substrate. The maximum recommended surface temperature is approx. 40°C. Higher steel temperatures are acceptable provided dry-spray is avoided by proper spray application and extra thinning if required. In extreme cases it may be necessary to reduce film thickness to avoid sagging. When applying the paint in confined spaces, provide adequate ventilation during application and drying. The temperature of the mixed paint should be at least 15°C, otherwise extra solvent may be required to obtain a proper application viscosity.

Drying and Over coating Conditions:

Temperature of basis material	10°C
Untouched (1)	2 hours
Dry to the touch	6 hours
Absolutely dry (2)	18 hours
Min./ Max. over-coating times	18 hrs. / no limitation

(1) The given data must be considered as guidelines only. The actual drying time/times before recoating may be shorter or longer, depending on film thickness, ventilation, humidity, preceding paint system etc.
(2) The surface should be dry and free from contaminants prior to overcoating. The best intercoat adhesion is achieved when the subsequent coat is applied before the preceding coat is fully cured. After prolonged exposure it may be necessary to roughen the surface to ensure intercoat adhesion. When recoating with single pack products, maximum recoat interval is limited to 16-24 hours. When in doubt, consult with Philadelphia Coatings LLC Technical Department.

Coating Specification

Long overcoat period if temperatures are around freezing point. Proper selection of the systems, coating application procedures and surface preparation are made depending on actual existing film. Best specific design factors and conditions are tested in a controlled laboratory. Consult with Philadelphia Coatings LLC Technical Department before and throughout testing process.
Product is not recommended for immersion in acid alkaline solutions, thinners, drinking water and foodstuffs.

Tender Item:

Application of Philatria Plastofond AS, double-component, waterproof, high thickness, epoxy-polyamide resin based intermediate coat, with braking, lamellar pigmentation, to be applied over external and internal surfaces with a thickness of 80 micron- dry film - consumption of 0,190 kg/Sq.m., excluded practical operating loss.

Surface Preparation

Surface must be clean, dry, and in sound condition. Remove all oil, dust, grease, dirt, loose rust, and other foreign material to ensure adequate adhesion.

New iron:

Sanded and properly primed with an epoxy primer or with an organic or inorganic zincking primer. Apply one coat of Philatria Plastofond AS with a minimum thickness of 80 – 100 micron – dry film.

Painted iron:

Remove any trace of old peeling paintwork, sand the whole surface to be treated, apply over uncoated areas one coat of epoxy primer. After drying, apply one or two coats of Philatria Plastofond AS. Allow drying and apply a proper finish paint.

Galvanized iron:

Wash off any trace of oil or grease with a thinner or alkaline cleansing compounds. Sand slightly to remove the glossy layer. Apply Philatria Plastofond AS in one or two coats and coat with a proper finish.

New wood:

Make sure that the surface has perfectly seasoned, sand to remove any imperfections, apply one coat of hydrodilutable, double-component, 30% water thinned primer, PhilaDure WP PHDE, or a double-component, thinner based, 20-30% solvent thinned primer. After drying, apply Philatria Plastofond AS, with a thickness of 80 – 100 micron – dry film and apply, afterwards, a proper finish.

Old wood:

Remove any trace of old peeling paintwork, sandblast the whole surface to be treated, remove any trace of dirt or dust. Apply a first coat of 20-30% solvent thinned Philatria Plastofond AS, over uncoated areas. After drying, even out any imperfections with an epoxy or polyester putty, sandblast and clean. Apply Philatria Plastofond AS and coat, afterwards, with a proper finish.

Masonry works:

Make sure that the surface has seasoned for at least 28 days, that it is dry and free from salt efflorescence. Mechanically remove any peeling parts, remove dust and apply one coat of double-component, water based primer PhilaDure WP PHDE, even out any imperfections with the smoothing product CLS 5 or with Phila epoxy putty. Sandblast and apply one or two coats of Philatria Plastofond AS.

Application note:

Apply at temperatures above - 5° or below + 50°, with air relative humidity below 90%. Wash tools immediately after their use with a thinner.

The product, as any epoxy coating is subject to light peeling, after an extended exposure to the sunlight.

Minimum recommended surface preparation:

Substrate	Minimum	Recommended
Carbon steel	St 2 (ISO 8501-1)	Sa 2 (ISO 8501-1)
Stainless steel	The surface shall be hand or machine abraded with non-metallic abrasives or bonded fibre machine or hand abrasive pads to impart a scratch pattern to the surface and to remove all polish from the surface.	Abrasive blast cleaning to achieve a surface profile using non-metallic abrasive media which is suitable to achieve a sharp and angular surface profile.
Galvanised steel	The surface shall be clean, dry and appear with a rough and dull profile.	Light brush blasting using nonmetallic abrasive leaving a clean, rough and even pattern.
Coated surfaces	Clean, dry and undamaged compatible coating (ISO 12944-4 6.1.4)	Clean, dry and undamaged compatible coating (ISO 12944-4 6.1.4)
Concrete	Low pressure water washing to a rough, clean, dry and laitance free surface.	Minimum 4 weeks curing. Moisture content maximum 5 %. Prepare the surface by means of enclosed blast shot or diamond grinding and other appropriate means to abrade the surrounding concrete and to remove laitance.

Optimum performance, including adhesion, corrosion protection, heat resistance and chemical resistance is achieved with recommended surface preparation.

Storage

Circa 24 months at 25°C, stored at dry, shaded and ventilated condition. The container/paint, must be kept sealed and away from heat and ignition.
In some markets commercial shelf life can be dictated shorter by local legislation. The above is minimum shelf life, thereafter the paint quality is subject to re-inspection.

Color Variation

When applicable, products primarily intended for use as primers or antifoulings may have slight color variations from batch to batch. Such products may fade and chalk when exposed to sunlight and weathering. Color and gloss retention on topcoats/finish coats may vary depending on type of color, exposure environment such as temperature, UV intensity etc., and application quality. For further information, please consult with Philadelphia Coatings LLC.

Pack Size

kg 25 – kg 5 drum. If other packing specifications are needed, please consult with Philadelphia Coatings LLC.

Shipping weight

kg 25 – kg 5 drum.

Health and Safety

Prior to use, obtain, consult and follow the Material Safety Data Sheet for this product concerning health and safety information. Read carefully and conform to precautions on MSDS and packing vessels. To avoid eye and skin contact, tools such as gloves, goggles and face mask etc. should be used during work with product (proper safety measures should be taken according to construction methods and circumstances). All work with the product must be carried out according to all relevant national health, safety and environment standards and codes. This product is for professional use only.

Limitation of liability

All information is given for guidance only and is subject to regional variation depending upon local climate and environmental condition. An excessive film thickness delays the final curing and creates sagging. Over coating interval will increase with the number of paint layers and the thickness of the paint film. For recommended paints at special circumstances, please consult with Philadelphia Coatings LLC. Apply in good weather. The relative humidity must not exceed 80% temperature of the surface to be coated must be at least 3°C above the dew point. All data from the tests is obtained under lab conditions, so Philadelphia Coatings LLC will not bear any liabilities from the condition whether the data could reflect the objective status of the actual application circumstance or not.

Disclaimer

The information in the product manual is based on our experiences from tests and practice. For the application without our knowledge, we could only make sure that our products themselves are warranted. We may modify the data in this product manual according to our continuous development and experience accumulation without advanced notice.