

Bare steel

Cleanliness: Blast cleaning to min. Sa 2 ½ (ISO 8501 1:2007). Roughness: using abrasives suitable to achieve Grade Medium G (50 - 85 µm, Ry5) (ISO 8503-2).

Coated surfaces

Approved on top of thin coat (50 µm) of Tankguard HB

Other surfaces

The coating may be used on other substrates. Please contact your local Jotun office for more information.

Condition during application

The temperature of the substrate should be minimum 10°C and at least 3°C above the dew point of the air, temperature and relative humidity measured in the vicinity of the substrate. Good ventilation is required in confined areas to ensure proper drying. The coating should not be exposed to oil, chemicals or mechanical stress until cured.

Application methods

Spray	Use airless spray
Brush	Recommended for stripe coating and small areas, care must be taken to achieve the specified dry film thickness.

Application data

Mixing ratio (volume)	4 parts Comp. A (base) to be mixed thoroughly with 1 part Comp. B (curing agent)
Induction time	20 minutes.
Pot life (23 °C)	3 hours (Reduced at higher temp.)
Thinner/Cleaner	Jotun Thinner No. 23
Guiding data airless spray	
Pressure at nozzle	15 MPa (150 kp/cm ² , 2100 psi)
Nozzle tip	0.46-0.69 mm (0.018-0.027")
Spray angle	40-80°
Filter	Check to ensure that filters are clean.

Drying time

Drying times are generally related to air circulation, temperature, film thickness and number of coats, and will be affected correspondingly. The figures given in the table are typical with:

- * Good ventilation (Outdoor exposure or free circulation of air)
- * Typical film thickness
- * One coat on top of inert substrate

Substrate temperature	10°C	15°C	23°C	40°C
Surface dry	18 h	10 h	5,5 h	2 h
Through dry	36 h	16 h	8,5 h	4 h
Cured	- d	14 d	7 d	3 d
Dry to recoat, minimum ²	52 h	36 h	20 h	10 h
Dry to recoat, maximum ¹	18 d	12 d	7 d	4 d

1. The surface should be free from chalking and contamination prior to application. If the maximum dry to recoat time is exceeded, please contact Jotun for advice.
2. In order to achieve full product resistance, a combined total of 14 days curing at minimum 15°C is required during build period.

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, underlying paint system, requirement for early handling and mechanical strength etc. A complete system can be described on a system sheet, where all parameters and special conditions could be included.

Typical paint system

Tankguard Special Primer	100 µm (Dry Film Thickness)
Tankguard Special Mid-Coat	100 µm (Dry Film Thickness)
Tankguard Special Topcoat	100 µm (Dry Film Thickness)

Other systems may be specified, depending on area of use

Storage

The product must be stored in accordance with national regulations. Storage conditions are to keep the containers in a dry, cool, well ventilated space and away from source of heat and ignition. Containers must be kept tightly closed.

Handling

Handle with care. Stir well before use.

Packing size

20 litre unit: 16 litres Comp. A (base) in a 20 litre container and 4 litres Comp. B (curing agent) in a 5 litre container
Packing may vary from country to country according to local requirements.

Health and safety

Please observe the precautionary notices displayed on the container. Use under well ventilated conditions. 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.

For detailed information on the health and safety hazards and precautions for use of this product, we refer to the Material Safety Data Sheet.

DISCLAIMER

The information in this data sheet is given to the best of our knowledge based on laboratory testing and practical experience. However, as the product can be used under conditions beyond our control, we can only guarantee the quality of the product itself. We also reserve the right to change the given data without notice. Minor product variations may be implemented in order to comply with local requirements.

If there is any inconsistency in the text the English (UK) version will prevail.

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THIS DATA SHEET SUPERSEDES THOSE PREVIOUSLY ISSUED