

13500 KANEPOX COAT FLOW

PRODUCT DESCRIPTION

It is an epoxy-polyamine based, two component, zinc phosphate and mica iron oxide (MIOX) containing, high built, self priming mastic coating with low volatile organic content (VOC). It is specially designed as a surface tolerant coating with excellent adhesion on marginally prepared steel surfaces and a wide range of existing coatings. Applied coating could dry down to 0°C. It is most often used in those applications where high film thickness in one coat is required. It is suitable for flow application line.

RECOMMENDED USE

13500 KANEPOX COAT FLOW preferred for painting radiators, corrugated boilers and various accessories, DKP sheet, steel surface and zinc galvanized surfaces by pouring and/or spray method in the transformer paint industry, 13500 KANEPOX COAT FLOW can be applied on epoxy primers which contains zinc. It can be applied as a primer and midcoat in paint systems where Im1 to Im4 immersion categories and C2 to C5, also CX corrosion categories are required according to ISO 12944-5.

PRODUCT CHARACTERISTICS

Finish: Semi-Matt	Density (g/ml) 1.58±0,10
Colour: Grey	Spreading Rate (m ² /kg) ~4.43 (100 mikron DFT)
Thinner: Kanat Thinner 0620 Kanat Thinner 0621 Kanat Thinner 0625	Flash Point 43°C VOC (Volatile Organic Content) 269 gr/t
Mixing Ratio (by weight) 28 parts A comp. + 4 parts B comp	Application Methods Flow, Air /Airless Spray
Mixed Product;	Pot Life (20°C) 4-5 hours
Volume Solids (%) 70±2	

DRYING SCHEDULE(*)

(100 microns/4 mils film thickness)

Oven Dry	
80°C	40-50 minutes

Full cured: 7 days/ 20°C

*Curing time changes according to DFT and temperature

Note: If the oven process is not applied, the drying reaction will not occur

PACKAGING

One kit of **13500 KANEPOX COAT FLOW** is 32 kgs.
One pail of **13500 KANEPOX COAT FLOW** component A is 28 kgs,
One can of **KANEPOX HARDENER 0383** component B is 4 kgs.

SHELF LIFE

Part A—12 months, Part B—12 months when the material is stored in a cool and dry place in unopened original containers.

HEALTH/SAFETY PRECAUTIONS

Refer to the MSDS sheet prepared according to EU directives before use.

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SURFACE PREPARATION

Surfaces must be dry, clean, free of oil, grease and other foreign material according to SSPC-SP1.

New Steel Surfaces: Surface blasting to near white metal surface cleanliness according to SSPC-SP10 or ISO 8501-1 Sa ½ must be done to meet the requirements of 12944-6 standard ISO 12944-5. Depending on ambient conditions, power tool cleaned or blasted surfaces must be primed in maximum 5 hours with **13500 KANEPOX COAT FLOW**.

Blasting surface profile should be RZ : 40-70. Power tool cleaning to St2 - St3 according to ISO 8501-1 can be done. **Non-Blastable new surfaces:** Chemical processing (Phosphating and similar) should be done to clean and roughen the non-blastable surfaces from oil, dust, rust or any contamination. After this process, rinse should be done to remove the chemicals from the surface and then make sure that the surface is completely dry. Rust should not form on the dried surface.

Primed/Midcoated Surfaces: Be sure that overcoating period is not exceeded. Otherwise the surfaces must be blasted to have a surface profile.

Surfaces Other Than Steel: Galvanized panels should be placed in the furnace for 2 hours at 160°C in order to discharge gas from them. Surface can be blasted using mineral abrasive containing materials to meet the requirements of 12944-6 standard ISO 12944-5. Non-blasted surfaces which have swell, spilled coating, burrs or white rust should be corrected with hand tools. Then these surfaces should be cleaned, matted and roughened with chemical processing. In order to clean the chemicals on the surface after the process is done, it is necessary to rinse surface properly and leave them to be completely dry. Rust should not be formed on the dried surface.

Touch-up: Remove all dust, dirt and other foreign material and keep dry. Clean the surface to PSt 3 level mechanically according to ISO 8501-2 and complete the touch-up application as soon as possible. Abrasive blasting is preferable to P_{Sa} 2½. **13500 KANEPOX COAT FLOW** can be safely used for touch-up.

APPLICATION PROCEDURE

This is a two-component paint. Do not mix more material than you plan to use within the listed pot life. Complete containers must be mixed at one time.

MIXING RATIO (by weight)

Base 13500 : Curing Agent 0383
28 : 4 by weight

APPLICATION CONDITIONS

For the best results;

Temperature must be more than 0°C during the application and/or the curing process.

Surface Temperature: At least 3°C above dewpoint.

Relative Humidity: 85% maximum.

Good ventilation is required during application.

MIXING PROCEDURE

Prior to mixing, components A Base and B Hardener should be at room temperature (60-75° F/16-24°C). Combine 4 parts by weight of Part B Hardener with 28 parts by weight of Part A Base. Homogenize the mixture with a power mixer, add thinner if necessary and use mixed product must be used within 4-5 hours (20°C) without induction time.

APPLICATION

Stripe coat all crevices, welds and sharp angles. Apply paint at the recommended film thickness and spreading rate.

Application of coating above maximum or below minimum recommended spreading rate may adversely affect coating performance. The amount of thinner remaining in the pool should be taken into account for flow applications.

CLEAN UP

**KANAT THINNER 0606, KANAT THINNER 0620,
KANAT THINNER 0621, KANAT THINNER 0625**

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APPLICATION EQUIPMENT

(The table is a guide for 20°C)

Application Equipment	Flow (20-45")	Conventional Spray	Roller
Thinner maximum	%17	%25	%10
Pressure minimum (bar)	–	2,5	–
Nozzle(inch)	–	1,4-1,6	–

PRECAUTIONS

Recoating period is minimum 8-10 hours and maximum 1 month (20°C). Recoating interval depends on temperature, humidity and film thickness. If maximum recoating time is exceeded abrade surface, if the surface is highly contaminated apply pressurized fresh water cleaning before recoating.

Condensation forming on the coating during early times of curing may result in longer cure times, solvent entrapment, premature failure, discoloration or a surface haze or blush that must be removed before recoating.

High temperatures decrease resistance properties of epoxy based products. Epoxy based products also have a tendency to yellowing, chalking and have limited gloss retention on exterior surfaces.

If the oven process is not applied, the drying reaction will not occur.

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