

## 15510 KANEPOX TOL

### PRODUCT DESCRIPTION

**15510 KANEPOX TOL** is an epoxy-polyamine based, two component, high built, self priming mastic coating containing zinc phosphate. It is specially designed as a surface tolerant coating with excellent adhesion on marginally prepared steel surfaces and a wide range of existing coatings. It is most often used in those applications where high film thickness in one coat is required.

### RECOMMENDED USE

Surface tolerant primer/midcoat (one coat where UV resistance is not important) of the paint systems on mechanically cleaned steel surfaces without blasting or surfaces with existing coating for;

- Moist steel surfaces.
- Petrochemical plants.
- Industrial and marine structures (including concrete surfaces).
- Ship building and maintenance industry, below or above water .
- Bridge structures, below or above water .

### APPROVALS & QUALIFICATIONS

Cathodic disbonding resistance has been tested by Exova-England according to ASTM G8:2003.

### PRODUCT CHARACTERISTICS

Finish: Semi-Matt	Density (g/ml) 1,54 ± 0,1
Colour: Wide range of colours available	Spreading Rate (m <sup>2</sup> /l) 9,04 (100 mikron KFK)
Thinner: Kanat Thinner 0620 (Low Temp.) Kanat Thinner 0625 (High Temp.)	Flash Point 25°C
Mixing Ratio (by volume) 4 Birim A Komp. + 1 Birim B Komp.	VOC ( Volatile Organic Content) 139 g/ltr
Mixed Product; Volume Solids (%) 83±2	Application Methods Airless Spray, Roller
	Pot Life (20°C) 1 hours

### DRYING SCHEDULE(\*)

(100 microns film thickness)

	Dry to Touch	Hard Dry	Dry to Over Coat Minimum
10°C	13 hours	29 hours	29 hours
15°C	7,5 hours	16 hours	16 hours
25°C	5 hours	10 hours	10 hours
30°C	3 hour	7 hours	7 hours

Fully Cured: 7 days (20°C)

(\*) Drying time depends on temperature, humidity and film thickness.

Drying values are valid for defined dry film thickness and below 80% relative humidity.

### PACKAGING

One kit of **15510 KANEPOX TOL** is 20 liters.

One pail of **15510 KANEPOX TOL** component A is 16 liters.

One can of **KANEPOX HARDENER 0309** component B is 4 liters.

### SHELF LIFE

Part A–1 year, Part B–1 year 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.

**New Steel Surfaces:** Surfaces should be blasted to near-white metal surface cleanliness according to SSPC-SP10 or ISO 8501-1 Sa 2 1/2. Blast profile on steel should be 40-70 microns in depth. Surface cleanliness of St 2-St 3 according to ISO 8501-1 is sometimes allowed depending upon the conditions. Depending on ambient conditions, blasted surfaces must be primed in maximum 5 hours with **15510 KANEPOX TOL**.

**Previously Painted Surfaces:** If the aged coating is in a good condition, it is slightly sanded and cleaned by pressurized fresh water cleaning to remove the dust and other contaminations. Otherwise remove all the cracked and peeling paint by using hand tools to a cleanliness of St 2-St 3 according to ISO 8501-1. If applicable blast cleaning to Sa 2-Sa 2 1/2 according to ISO 8501-1 level to get better results. Water jetting to a minimum degree of Wa 2 1/2 (ISO 8501-4:2006) is also applicable as an alternative to abrasive blasting. A flash rust degree of maximum M (ISO 8501-4:2006) is acceptable before application.

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

**The Surfaces Other Than Steel:** Contact KANAT Project Group for the galvanized, aluminium, plastic surfaces. **Touch-up:** Remove all dust, dirt and other foreign material and keep dry. Clean the surface to St 2-St 3 level mechanically according to ISO 8501-1 and complete the touch-up application as soon as possible. **15510 KANEPOX TOL** can be safely used for touch-up.

### APPLICATION PROCEDURES (Mixing 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. **DO NOT MIX PARTIAL QUANTITIES FROM CONTAINERS OR PROPER COMPONENT RATIOS MAY NOT BE OBTAINED.** Prior to mixing, components A Base and B Hardener should be at room temperature. Combine 1 part by weight of Part B Hardener with 8 parts by weight of Part A Base. Homogenize the mixture with a power mixer, add thinner if necessary and wait 10-15 minutes for induction before use. Mixed product must be used within 2 hours (20°C).

### MIXING RATIO

4 Parts A Comp. + 1 Part B Comp.

### APPLICATION CONDITIONS

For the best results;

**Air Temperature:** 10°C minimum, 35°C maximum

**Surface Temperature:** At least 3°C above dew point, 10°C minimum and 45°C maximum. Relative Humidity: 80% maximum.

Good ventilation is required during application.

### 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. Maximum coating interval is 1 month. Do not apply more than 275 microns (11 mils) WFT to prevent sagging. When using spray application, use a 50% overlap with each pass of the gun to avoid holidays, bare areas and pinholes. If necessary, cross spray at a right angle.

### CLEAN UP

**KANAT THINNER 0644, KANAT THINNER 0620,  
KANAT THINNER 0625**

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## APPLICATION EQUIPMENT

(The table is a guide for 20°C)

Application Equipment	Airless Spray	Roller
Thinner maximum	%10	%55
Pressure minimum (bar)	200	–
Nozzle(inch)	0,017-0,023	–

## PRECAUTIONS

- Recoating period is minimum 6-8 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.
- Use only **KANAT THINNER 0625** for thinning paint to be applied on previously painted surfaces.

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