

1. OVERVIEW

KOREPOX H.S EH4158(H)GF is a twocomponent, highsolids, highbuild, polyamide cured epoxy resin based coating reinforced with glass flake, and selfpriming coating with excellent resistance to corrosion and abrasion. Also, it provides a hard and tough film with longterm durability. It can be applied over new or old steel, requiring only the removal of loose rust and scale, and applied over most existing coatings.

- a. Recommended Use Recommended for the areas requiring coatings of exceptional abrasion resistance and durability such as ship bottom, fences, high way bridges and exposed structural steel.

2. PHYSICAL PROPERTIES

- a. Finish and Color Flat. Off-white, Gray, Green, Red Brown, Aluminum. Others are available on request except for white.

- b. Drying Time

Substrate temperature	5 °C / 41 °F	20 °C / 68 °F	30 °C / 86 °F
Set to touch	16 h	3 h	2 h
Dry through	72 h	12 h	8 h

* Note : H -> hours

- c. Solids by Volume Approx. 83%
- d. Spreading Rate 4.15 m²/L in 200 microns dry film thickness on a smooth surface.
(Theoretical)
- e. Specific Gravity Mixed : Approx. 1.4 (Kg/L)
- f. Flash Point PTA (Base) : 29°C/84°F(Closed cup)
PTB (Curing Agent) : 9°C/48°F(??)

3. APPLICATION DETAILS

- a. Surface Preparation * Non immersion service : Blast cleaning to Sa 2 'Commercial Blast', and power tool cleaning to St 3 is acceptable.
A brush-off blast is recommended in marine atmospheres.
Water blasting is also acceptable.
* For immersion service : Blast cleaning to Sa 2.5 'Near White Metal' to obtain 25 ~ 75 microns blast profile.
- b. Application conditions To avoid condensation problems, apply only when the substrate temperature is 3°C above the dew point.
- c. Mixing PTA(Base) : PTB(Curing Agent) = 1 : 1 (by volume).
Mix thoroughly together prior to application in the proportions as delivered.

※ This data is believed to be accurate, but without any obligation.

Please consult with our technical department for detail information..

- d. Pot Life At 20°C/68°F, 5 hours
- e. Thinning THINNER No. 024 or No. 002
For repairs with loose paint film such as alkyd, use THINNER No. 002
Do not dilute components separately, only the mixture.
- f. Method of Application Brush, Roller, Airless application.
For airless spray application ;
Nozzle orifice : 0.037" ~ 0.055"
Output pressure : 2,500 ~ 3,000psi / 175 ~ 200atm. Fan : 65°C
(Airless spray data are indicative and subject to adjustment).
- g. Film Thickness Recommended per coat 200 microns dry.
May be specified in another film thickness than indicated depending on
purpose and area of use.

h. Recoating Interval

Substrate temperature	5 °C / 41 °F	20 °C / 68 °F	30 °C / 86 °F
Set to touch	48 h	12 h	8 h
Dry through	72 h	24 h	24 h

* Recoating interval is applied to non-immersion service area.
Before overcoating after exposure in contaminated environment, clean surface thoroughly by high pressure fresh water hosing and allow to dry.
If maximum interval is exceeded, clean and roughen the surface before overcoating.

- i. Subsequent Coat According to specification.
- j. Shelf Life 12 months
- k. Heat Resistance Continuous : 93°C/200°F
Non-Continuous : 121°C/250°F

l. Chemical Resistance

	Acids(*1)	Alkalies(*1)	Solvents	Salts	Water
Splash & Spillage	Good	Good	Good	Excellent	Excellent
Fumes	Good	Good	Good	Excellent	Excellent
Immersion	Fair	Fair	Fair	Excellent	Excellent

(*1) : Except for aluminum color.

- m. Packing Unit 16 (PTA : 8L, PTB : 8L)
- n. Remarks Protect skin and eyes, and avoid prolonged breathing of solvent vapors.
Use with adequate ventilation.
Respiratory protection is recommended when applying this material in confined spaces or stagnant air.
Avoid humidity and direct sunlight during storage.
- o. Issued July, 2000

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