



CL 9400 HIGH PERFORMANCE EPOXY COATING

CL 9400 High Performance Epoxy Coating is a two component high build epoxy zinc phosphate anti-corrosive primer.

CL 9400 designed to be an anti-corrosive protection of steel structures surfaces prepared by abrasive blast cleaning.

CL 9400 suitable for use under appropriate coating systems for exposed or immersed conditions. Patch primer for the repair of damaged surfaces. Tolerant to application over manually prepared surfaces.

Surface Preparation

Steel

Abrasive blast clean to a minimum standard of Sa2.5 (ISO8501-1:1988) or SSPC-SP10.

Average surface profile of 50-75 microns is required.

The surface to be coated must be clean and dry and free from all visible traces of surface contaminants.

Manually prepared surfaces should be prepared to a minimum standard of St3 (ISO8501-1:1988) at the time of coating.

Performance

- Excellent anti-corrosive performance
- Excellent resistance to moisture
- Excellent resistance to petroleum solvents and aliphatic solvents
- Good resistance to corrosive chemicals
- Excellent resistance to abrasion
- Excellent resistance to weather

Physical Properties

Volume Solids	63%
Theoretical Coverage	8.4 m ² /litre @ 75 microns DFT
Type	Two components
Packing Ratio	4 litres Base : 1 litres Hardener
Colour Availability	Selected colour range.
Flash point	25°C (mixed)
Recommended Thickness	75 microns DFT

Average Drying Time

Ambient Temperature	Touch Dry	Hard Dry	Overcoating Interval		PotLife
			Minimum	Maximum	
15°C	2 hours	6 hours	24 hours	Indefinite	8 hours
25°C	1.5 hours	4 hours	16 hours	Indefinite	6 hours
35°C	1 hours	3 hours	12 hours	Indefinite	3 hours

Application Data

Application Methods Brush/Roller, Airless Spray and Conventional Spray.

Mixing ratio (by volume) 4 parts Base to 1 part Hardener

Thinner Standard Thinner (Maximum 5% addition)

Airless Spray Nozzle Size : 0.46mm (18 thou)
Fan Angle : 65°
Operating Pressure : 155 kg/cm² (2200 psi)

Conventional Spray Nozzle Size : 1.27mm (50 thou)
Atomising Pressure : 2.8 kg/cm² (40 psi)
Fluid Pressure : 0.4 kg/cm² (6 psi)

Brush / Roller This product is suitable for brush application. Application of more than one coat may be necessary to give equivalent dry film thickness to a single spray applied coat.



Application method



65° spraying tip



Practice proper cleaning

Practical Application

	Airless Spray	Conventional Spray	Brush	Roller
Dry	75	75	50	65
Wet	119	119	79	103

HEALTH AND SAFETY

Consult Chemical Safety Data Sheet for information on safe handling and application of this product.



Keep seal tight



Secure upright



Wear proper protection



Practice proper disposal

Application Conditions and Overcoating

This product should preferably be applied at temperature in excess of 10°C. In conditions of high relative humidity i.e. 80-85%, good ventilation conditions are essential. Substrate temperature should be at least 3°C above the dew point.

At application temperature below 10°C, drying and curing time will be significantly impaired.

Application at temperature below 5°C is not recommended.

In order to achieve optimum water and chemical resistance, temperature needs to be maintained above 10°C during curing.