



AMERLUX



Protective Coatings

Product Data / Application Instructions

Permapox OA 5500

Epoxy Mastic

- High performance self-priming universal epoxy
- High solids, low VOC
- Surface tolerant and abrasion resistant
- Compatible with prepared damp surfaces
- Adheres to most types of existing coating systems
- Available in a wide colour range
- can be overcoated with a wide range of topcoats
- Also available with MIO pigmentation
- Can withstand forklift and other rubber tyred vehicles

Permapox OA 5500 is used as a high-performance maintenance coating with excellent adhesion to a wide range of existing coatings. Permapox OA 5500 can be applied to mechanically cleaned surfaces. Adhesion is excellent to a wide variety of substrates, including concrete, aluminium, and galvanizing. Permapox OA 5500 has excellent application characteristics. It can be applied by conventional and airless spray equipment, brush, or roller. For immersion service in water, abrasive blasting to Sa 2½ is required. However, for enhanced UV resistance it may be top coated with a wide range of different topcoats.

Contact your OAL representative for specific recommendations.

Typical Uses

As a high-performance coating on steel and concrete floors of warehouses, plants, car parking, showrooms, hospitals, food plants, concrete structures in industrial facilities, bridges, tank exteriors, containers, oil tanks, piping, roofs and other areas subject to moisture, high humidity, marine weathering, and other exposure. It can withstand splash and spillage of mild chemicals, acid fumes alkalis, and petrochemical products.

Permapox OA has good resistance to splash, spillage and fumes of acids, alkalis, and solvents. Permapox OA 5500 can be used on Steel concrete and cementitious floors.

Application data summary

For complete information on procedures, equipment and safety precautions, see the application instruction as accompanying shipment. Like all high-performance coatings Permapox OA 5500 must be applied as recommend to obtain the maximum performance.

Physical Data

Finish	Semi-Gloss
Colour	See colour card
Substrate	Steel, Concrete & Other surfaces
Components	2
Curing Mechanism	By solvent release and chemical reaction between component
Dry Film thickness	100 - 250 microns
Number of Coats	2

Theoretical coverage	m ² /L
at 100 microns dft	8.8

Volume solids..... 88 ± 3% (ASTM-D2697)

Density..... 1.50 Kg / Lt

Allow for application losses, surface irregularities, etc.

Application methods.....Airless spray, or roller

Pot life at 30°C 1 Hour

Drying time at 30°C

Touch dry 3 hours

Hard dry..... 6 hours

Fully Cured..... 4 days

Pot life ,drying time and curing times are dependent on temperature and quantities mixed.

Mixing ratio(by weight)..... 1 : 1

Thinner..... OA 55

Cleaner OA 12

Flash points(Closed cup)

Hardner 26°C

Base..... 43°C

* Note volume solids may vary according to colour

OA 5500 Permapox Epoxy Mastic

Surface Preparation

Coatings performance in general, is proportional to the degree of surface preparation. Abrasive blasting is usually the most effective and economical method. For circumstances where this is impossible or impractical, Permpox OA 5500 has been developed.

STEEL- Blast clean to Sa 2½ (ISO-8501-1) or SSPC-SP-10 Permpox OA 5500 can also be applied over mechanically cleaned surfaces. Remove all loose rust, dirt, oil and grease or other contaminants from the surface. Power tool clean in accordance with St 3 or SSPC-SP3 or hand tool clean in accordance with St 2 or SSPC-SP2, Permpox OA 5500 can be applied over damp substrates.

For immersion in water abrasive blasting to SA 2 ½ is required.

CONCRETE - Surfaces must be cured, clean, dry and free of non-adherent coatings and disintegrated or chalky materials.

EXISTING AGED COATINGS - Permpox OA 5500 may be used over most types of properly cleaned, tightly adhering aged 2 pack coatings. For single pack coatings, extra precautions are necessary. It is always recommended a test patch is applied to ensure long-term capability, as performance will depend on condition of the existing coating such as age, adhesion, and film thickness

Can be applied on suitable epoxy primers
Can be overcoated with itself.

Application Equipment

The following equipment is listed as a partial guide and suitable equipment from other manufacturers may be used. Adjustments of pressure and change of tip size may be needed to achieve the proper spray characteristics.

AIRLESS SPRAY - Standard airless spray equipment, with a 0.48 mm (0.019 inch) fluid tip or larger.

CONVENTIONAL SPRAY - Industrial equipment, having separate air and fluid pressure regulators, mechanical pot agitator and a moisture and oil trap in the main air supply line are recommended.

BRUSH/ROLLER - Apply evenly, using a clean well-loaded brush or roller. Ensure the coating is not brushed or rolled-out too far. Application by brush or roller will provide approx. 80 microns dft. in a single coat application.

MIXER - Use power mixer powered by an air motor or an explosion proof electric motor.

Application Data

Substrate..... Steel, concrete and cementitious floors

Application methods... Airless Spray or Roller

Environmental Conditions (during application and drying)

- Air and substrate temperature 4°C up to 40°C
- Maximum environmental humidity 85°.
- Concrete to be cured for min 28 days(Prior to painting)

- Depending on ambient temperature & surface conditions.

Surface temperature must be at least 3°C/5°F above dew point to prevent moisture condensation on the surface. Never apply coatings under adverse environmental conditions. Ensure good ventilation when applied in confined areas to assist evaporation and elimination of solvents.

NOTE: drying times are dependent on air and surface temperature, applied film thickness, ventilation and other environmental conditions. Times are proportionally shorter at higher temperature and longer at lower temperatures. Prior to recoating ensure the surface is clean.

Maximum recoating time intervals are dependent on temperature, degree of weathering and service conditions of the complete coating system. Consult your OAL representative for specific recommendations.

OA 5500 Permapox Epoxy Mastic

Application Procedure

Permpox OA 5500 is packaged in two components in the proper proportions which must be mixed before use (20 litre unit):

1. Flush equipment with recommended cleaner before use.
2. Stir both resin component and cure component to an even consistency with a power mixer.
Add cure to resin and continue stirring until homogeneous.
3. For conventional spray, thin only as needed for workability with no more than 10 vol % of recommended thinner.
Thinning is normally not needed for airless spray.
4. Apply a wet coat in even parallel passes. Overlap each pass 50% to avoid bare areas, pinholes or holidays. Give special attention to corners, welds, rough areas, edges.
5. Normal recommended dry film thickness per coat is 125 µm (5 mil). Maximum dft per coat should not exceed 250 µm (10 mil) per coat.
6. The application of a wet film thickness of 150 µm (6 mil) will normally provide 125 µm (5 mil) of dry film.
7. Check thickness of dry coating with a non destructive dry film thickness gauge such as Mikrotest or Elcometer. If less than specified thickness, apply additional material as needed.
8. Small damaged or bare areas and random pinholes or holidays can be touched up by brush.
9. Clean all equipment with recommended cleaner immediately after use or at least at the end of each working day or shift. When left in spray equipment, Permpox OA 5500 will cure and cause clogging.

Shipping Data

Packaging

Permpox OA 5500 resin 10 L in 20 L can

Permpox OA 5500 cure 10 L in 10 L can

Shipping weight kg

Permpox OA 5500 resin..... approx. 17

Permpox OA 5500 cure..... approx 15

Minimum shelf life

Resin and cure 1 year from shipment date

Storage out of sun light.

Shelf life 1 year from shipment date when stored indoors in unopened, original containers at 5 to 40°C.

Safety Instructions

1. Ventilate work area.
2. Check to ensure that fire or explosion risks are eliminated.
3. Cover all cuts or wounds.
4. Avoid inhaling or ingesting product. (Use mask and goggles for all spray applications).
5. Cover skin as much as possible.
6. Wash hands regularly. Use suitable soft soap.
7. Protect eyes. If product gets into eyes wash out with water until clear. Seek medical assistance.
8. In the event of accidental ingestion seek immediate medical assistance.
9. Take extra care when using airless spray equipment to avoid accidental injury.

OA 5500 Permapox Epoxy Mastic

Caution

This product is flammable. Keep container closed. Use with adequate ventilation. Avoid prolonged and repeated contact with skin. If used in confined areas, observe the following precautions to prevent hazards of fire or explosion or damage to health:

1. circulate adequate fresh air continuously during application and drying;
2. use fresh air masks and explosion proof equipment;
3. prohibit all flames, sparks, welding and smoking.

Do not empty into drains. Take precautionary measures against static discharges. For specific information on hazardous ingredients, required ventilation, possible consequences of contact, exposure and safety measures see Safety Data Sheet.

Safety

Since improper use and handling can be hazardous to health and cause of fire or explosion, safety precautions included with Product Data/Application Instruction and Material Safety Data Sheet must be observed during all storage, handling, use and drying periods.

Warranty

OAL warrants its products to be free from defects in material and workmanship. OAL's sole obligations and Buyer's exclusive remedy in connection with the products shall be limited, at OAL's option, to either replacement of products not conforming this warranty or credit to Buyer's account in the invoiced amount of the non-conforming products. Any claim under this warranty must be made by Buyer to OAL in writing within five (5) days of Buyer's discovery of the claimed defect, but in no event later than the expiration of the applicable shelf life, or one year from the delivery date, whichever is earlier. Buyer's failure to notify OAL of such non-conformance as required herein shall bar Buyer from recovery under this

warranty.

OAL makes no other warranties concerning the product. No other warranties, whether express, implied or statutory, such as warranties of merchantability or fitness particular purpose, shall apply. In no event shall OAL be liable for consequential or incidental damages.

Any recommendations or suggestion relating to the use of the products made by OAL, whether in its technical literature, or response to specific enquiry, or otherwise, is based on data believed to be reliable; however, the products and information are intended for use by Buyer's having requisite skill and know-how in the industry, and therefore it is Buyer to satisfy itself of the suitability of the products for its own particular use and it shall be deemed that Buyer has done so, as its sole discretion and risk. Variation in environment, changes in procedures of use, or extrapolation of data may cause unsatisfactory results.

Limitation of Liability

OAL's liability on any claim of any kind, including claims based upon OAL's negligence or strict liability, for any loss or damage arising out of, connected with, or resulting from the use of the products, shall in no case exceed the purchase price allocable to the products or part thereof which give rise to the claim. In no event shall OAL be liable for consequential or incidental damages.

Due to OAL's policy of continuous product improvement, the information contained in this Product Data/Application Instructions sheet is subject to change without notice. It is the Buyer's responsibility to check that this issue is current prior to using the product. For the most up-to-date Product Data/Application Instructions always refer to the website at www.oasisameron.com

To avoid any confusion that may arise through translation into other languages, the English version of the Product Data/Application Instructions will be the governing literature and must be referred to in case of deviations with product literature in other languages.

Condition of Sale

All our transactions are subject to our Terms and Conditions of Sale.

Oasis Ameron Company Ltd

Dammam 2nd Industrial City
P.O.Box 4926 | Al Khobar 31952
Saudi Arabia
Tel: +966 3 812 1300 | Fax : +966 3 812 1128
Email: sales@oasisameronpaints.com
www.oasisameron.com