



AMERLUX

Protective Coatings

Permapox OA 5540 Polyamide Epoxy

Product Data/ Application Instructions

- **High build application in one coat**
- **Can be applied on a variety of substrates**
- **Has good chemical resistance**
- **Fast curing**
- **zinc phosphate epoxy primer / coating**
- **Can be top coated with Polyurethane.**
- **Quick drying**
- **Available in MIO or conventional pigmented grade**

OA 5540 Permapox is a high build Polyamide Epoxy Intermediate or Topcoat. It can be used in very aggressive environments and can be exposed to the splash & spillage of mild chemicals, oils and food products. It can withstand severe acidic, alkaline fumes and salt solutions. It will provide protection to a wide range of substrates in marine or industrial areas.

Typical Uses

OA 5540 Permapox can be used as an economical floor coating. It can be used for protecting structural steel, tanks, pipes in chemical plants, refineries etc.

Application data summary

For complete information on procedures, equipment and safety precautions, see the application instruction as accompanying shipment. Like all high-performance coatings OA 5540 Permapox must be applied as recommend to obtain the maximum performance.

Physical Data

Finish.....	Matt to Silk
Colour	See colour card
Substrate	Steel or concrete
Components.....	2
Curing Mechanism	By solvent release and chemical reaction between components.
Volume Solids	83% (ASTM D 2697)
Dry Film thickness	75-200 microns/per coat
Number of Coat.....	1
Calculated coverage.....	8.00 m ² /L at 100 micron
Allow for application losses, surface irregularities, etc.	
Application methods	Airless or conventional spray, brush or roller
Pot life at 20°C.....	8 hours at 21°C
Drying time at 20°C	
dry to touch	1 hour
dry through.....	3 hours
Pot life ,drying time and curing times are depending on temperature and quantities mixed.	
Mixing ration(by volume):	
Resin	4 parts
Cure.....	1 part
Thinner.....	OA 55 or OA 60
Cleaner	OA 55 or OA 60
Flash points(Closed cup)	
Resin.....	32°C
Cure	25°C
Thinner	27°C
Cleaner	27°C

**Volume solids is measured in accordance with ASTM-D-2697.
Variations may occur due to colour and testing variance

OA 5540 Permapox Epoxy

Surface Preparation

Clean off all surface dirt. Use detergent and water to Existing coats or the Primer surface must be cleaned and all pollutants removed prior to coating with OA 5540.

Greasy deposits must be removed using solvents or water and detergent.

Can be applied over primers such as
OA 5560 Permapox Primer

Can be top coated with itself or OA 2600 Permatop.

Application Equipment

AIRLESS SPRAY - Standard airless spray equipment
Dilute with OA 55 Thinner only as required to achieve an even spray pattern (5-10% max)

CONVENTIONAL SPRAY – Standard Industrial equipment. Separate air and fluid pressure regulators. Mechanical pot agitator and a moisture and oil trap in the main air supply line are recommended. Dilute with OA 55 Thinner only as required to achieve an even pattern (5-10% max)

ROLLER - Soft & Smooth roller is recommended.

BRUSH - For hard-to-reach areas, corner & edges.

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

Application Data

Substrate Suitable for Concrete and Steel

Application methods Roller, Airless or conventional spray

Environmental Conditions (during application and drying)

Air temperature:..... 0 to 50°C 32 - 122°F

Surface temperature:..... 0 to 60°C 32 - 140°F

Drying time at 20°C

dry to touch 1 hour

dry through 3 hours

- 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 steel 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.

Thinners OA 55

Cleaner OA 55

OA 5540 Permapox Epoxy

Application Procedure

OA 5540 Permapox is packed in the proper mixing proportions of resin base and curing solution which must be mixed together.

16 ltr resin in 20 ltr can

4 ltr cure in 5 ltr can

1. Flush equipment with OA 55 before use.
2. Stir both resin base and curing solution to an even consistency with a Power mixer.
3. Add curing solution to resin solution and continue stirring for 5 minutes.
Note : do not mix more material than will be used with 20 hours at 21°C. Pot life is shortened by higher temperatures.
4. Dilute with OA 55 thinner only as required to achieve an even spray pattern.
5. For conventional spray, thin only as needed for workability within not more than 10 vol% of OA 55. Thinning is normally not required.
6. Application 75-200 microns dry film thickness per coat is to be advised.
7. Ventilation with air is required during application and drying
8. Clean all equipment after application with OA 55 Thinner.

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.

Shipping Data

Packing:

Resin 14.4 L
Cure 3.6 L
Product 18 L

Shipping weight:

Resin Approx 23.63 kg
Cure..... Approx 3.27 Kg

Storage out of sun light.

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

OA 5540 Permapox Epoxy

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

<http://www.oasisameron.com>