



AMERLUX

Protective Coatings

Permapox OA 8400 Coaltar Epoxy

Product Data / Application Instructions

- **Low-temperature curing**
- **Can be applied in one coat or more**
- **Superior application by airless and conventional spray**
- **For tank lining, immersion, or non-immersion service**
- **Anti Corrosion properties**
- **Suitable for waste treatment plant**

Typical Uses

Permapox OA 8400 coal tar epoxy is used in Marine structures, piling, bilges, ballast tanks, crude oil and cargo/ballast tanks, ships bottoms; pipe coating and lining, industrial coating in power plants, oil production and refining plants, sewage treatment plants, buried steel or concrete structure. Lining for immersion in crude oil, salt solutions, and fresh or brackish water or seawater.

Contact your OAL representative for specific requirement.

Characteristics

Permapox OA 8400 is a coaltar epoxy that displays exceptional application versatility, for use varying from cold to hot climates. It can be easily applied in one coat at a thickness of 400 µm or more. Alternatively, two coats at 200 µm or three at 125 µm may be applied, if required by specification. These features, combined with its high solids content and broad spectrum of water and chemical resistance, Permapox OA 8400 is a durable, high-performance, and economical coating. Permapox OA 8400 is suitable for use over both steel and concrete

Application data summary

Normally, Permapox OA 8400 does not require primer, but in the event a primer is called for, OA 5560 Primer or similar may be used. For complete information on procedures, equipment and safety precautions, see the application instruction as accompanying shipment. Like all high-performance coatings OA 8400 Permapox must be applied as recommend to obtain the maximum performance.

Physical Data

Finish.....Gloss

Colour Black

Substrate Steel, Concrete & Other surfaces

Components..... 2

Curing Mechanism By solvent release and chemical reaction between components

Dry Film thickness..... 150 - 400 microns

Number of Coats 1 or more

Theoretical coverage 2.60 m²/L
at 300 microns dft

Volume solids..... 78 ± 3% (ASTM-D2697)

Specific Gravity 1.60 Kg / Lt (mixed product)

Allow for application losses, surface irregularities, etc.

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

Pot life at 20°C..... 6 hours

Drying time at 30°C

Touch dry 2 hours

Hard dry 4 hours

To overcoat..... 4 hours

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

Mixing ratio(by Volume) 4 : 1

Thinner..... OA 55

Cleaner OA 12

Flash points(Closed cup)

Hardner 22°C

Base..... 30°C

* Note volume solids may vary according to colour

OA 8400 Permapox CoalTar Epoxy

Surface Preparation

STEEL - Blast in accordance with Sa 2½, ISO 8501-1 or Steel Structures Painting Council SP-10. NOTE: blast to achieve a 25 to 50 µm profile as determined with *Testex* Tape or similar instrument. Remove abrasive residues and dust from surface.

GALVANISED SURFACES - Remove any oil or soap film with Neutral oil cleaner, treat surface by a lightly blast with fine abrasive. Apply suitable primer OA 5560 or similar.

CONCRETE

Surfaces must be cured, moisture of concrete should be less than 6%, remove surface laitance by appropriate means, de dust, dry and surface to be free of any contamination, disintegrated particles or chalky materials.

IMPORTANT - Apply OA 8400 as soon as possible after surface preparation to prevent any contamination. Do not leave blasted steel uncoated overnight. In case of contamination remove contaminants. Spot blast steel if needed.

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 0.017-inch orifice or larger.

CONVENTIONAL SPRAY - Industrial equipment such as DeVilbiss MBC or JGA or Binks No. 18 or 62 gun. Separate air and fluid pressure regulators and a mechanical pot agitator are recommended. A moisture and oil trap in the main air supply line is essential.

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. 100 microns dft. in a single coat application.

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

Application Data

Substrate Steel, concrete,

Application methods.... Airless Spray or Roller

Environmental Conditions (during application and drying)

- a. Air and substrate temperature 4°C up to 40°C
 - b. Maximum environmental humidity 85°.
 - c. 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 8400 Permapox Coaltar Epoxy

Application Procedure

Permpox OA 8400 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 nondestructive 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.

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

Packaging

Resin.....16 L in 20 L can
Cure..... 4 L in 5 L can

Shipping weight

Resin.....approx. 26 kg
Cure..... approx 4 kg

Minimum shelf life

Resin and cure 1 year from shipment date

Storage out of sunlight.

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

OA 8400 Permapox Coaltar 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

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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.

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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