

KARPOX ARMORA HB

PRODUCT CODE: KBK 03014
EPOXY HIGH BUILD PRIMER

**1. DESCRIPTION OF PRODUCT AND THE PRODUCER**

GENERIC TYPE	High build epoxy primer/intermediate coat
DESCRIPTION, AREAS OF USE	Epoxy-polyamide based paint for heavy duty multilayer applications where higher film thicknesses are critical. Resistant against oils, light concentration acids, alkalis and non-reactive solvents. It is an easy to apply paint both for hot and cold climates. Main applications are steel construction projects, machinery and casted part coating jobs.
PRODUCER INFORMATION	Kartallar Boya ve Kimya Sanayi Ticaret Limited Sirketi Kosklucesme Mahallesi, Yeni Bagdat Caddesi, No:136, 41400 Gebze / KOCAELI / TURKIYE
PRODUCT HOTLINE	Monday-Saturday (08:30 - 18:00) Tel: 0262 641 49 67 Fax : 0262 641 49 68
EMERGENCY LINE	Uludag University Poison Research Center (7/24) - +90 224 442 82 93

2. PRODUCT'S TECHNICAL & APPLICATION PARAMETERS

COLOUR(S) / TEXTURE	Grey, Oxide Red
APPEARANCE	Matte (ASTM D 523)
SPECIFIC GRAVITY	1,55±0,05 g/cm ³ (ASTM D 1475)
SOLID BY VOLUME	%62±2 (ASTM D 2697)
THINNER CODE	K- Solv 300
THINNING RATE	%5-15
VOC CONTENT	225 g/L (ASTM D 3960)
SPREADING RATE	9 sqm per liter when applied as single coat (100 microns DFT)
SURFACE DRY TIME	2 hours @20 °C
THROUGH DRY	8 hours @20 °C
COMPLETELY CURED	7 days @20 °C
HARDENER TYPE - COMP. MIXING RATIO	K-Cure 1000 , 7:1 by Weight
METHOD OF APPLICATION	Airless Spray, HVLP Spray, lint free roller, brush
NOZZLE INFO	0,019" - 0,023"
PRESSURE INFO	150-200 bars
RECOMMENDED WET THICKNESS	170 microns
DRY FILM THICKNESS	100 microns
MINIMUM RECOATING INTERVAL	6 hours @20 °C
MAXIMUM RECOATING INTERVAL	30 days @20 °C
PDT LIFE	6 hours @20 °C
SHELF LIFE	2 years for Component A and 2 year for Component B from the date of manufacture, as long as stored at proper conditions and unopened

3. SURFACE PREPARATION & ENVIRONMENTAL CONDITIONS DURING APPLICATION

NEW APPLICATION	Oil and grease should be removed by solvent cleaning according to SSPC-SPI. Steel surfaces should be abrasive blasted to Sa2 ^{1/2} as per ISO 8501-1:2007) If a suitable temporary protecting primer was applied, loose debris and any type of contamination should be cleaned thoroughly prior to the final application.
REPAIRS	Corroded areas should be blast cleaned to Sa2 ^{1/2} or SSPC SP10. Existing systems should be dry and free from loose paint, salt, grease and other contaminants prior to the overcoating.

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**KARTALLAR BOYA VE KIMYA SANAYI TICARET LIMITED SIRKETI**

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3. SURFACE PREPARATION & ENVIRONMENTAL CONDITIONS DURING APPLICATION (CONTINUED)

ENVIRONMENT CONDITIONS

The temperature of the surface should be at least 3°C higher than the DewPoint of the air. Temperature and relative humidity should be measured in the vicinity of the substrate. The maximum recommended surface temperature is 40°C. In extreme cases, it may be necessary to reduce film thickness in order to avoid sagging. When applying the paint in confined spaces, provide adequate ventilation during application and drying. The temperature of the mixed paint should be at least 15°C. Otherwise extra solvent may be needed to obtain a proper application viscosity. Relative humidity must not be over %80

4. PACKING & STORAGE CONDITIONS

PACKING DETAILS

5 Kg Part A + 0.715 Kg Part B or 21 Kg Part A + 3 Kg Part B in steel gallons or pails

STORAGE CONDITIONS

Storing areas should be dry and well ventilated where the temperature is always between 5-30°C. These areas should be separated from the manufacturing fields to eliminate the risks of fire.

5. ENVIRONMENTAL RESPONSIBILITY, HEALTH & SAFETY

GENERAL RULES

Observe the precautionary notices on the label of the container. A material safety data sheet is available upon request and national or local safety regulations should be followed. This product is intended for use by professional applicators.

HEALTH

Avoid skin- and eye contact by wearing overalls, gloves, goggles, mask, etc. Spillage on the skin should immediately be removed by thorough washing with lukewarm water and soap or a suitable industrial cleaner. Eyes should be flushed with fresh water and medical attention sought immediately. Spraying should be carried out under well-ventilated conditions. Avoid inhalation of solvent vapors and paint mist by wearing an air mask.

SAFETY

This product contains flammable materials and should be kept away from sparks and open flames. Smoking in the area should not be permitted.

6. DISCLAIMER

DISCLAIMER

The information in this data sheet is provided to the best of our knowledge. However, we have no control over either quality or condition of the substrate and other factors affecting the use and application of this product. Therefore, we cannot accept any liability whatsoever or howsoever arising from the performance of the product or for any loss or damage arising from the use of this product. We reserve the right to change the product without notice.

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