DEP 530 HA100

DEP 530 HA100 is a single component solvent free heat activated epoxy novolac coating. The product has been designed for use on a wide range of metallic surfaces and once cured provides excellent corrosion protection.

The material is suitable for application to hot pipework, process vessels and tanks, etc., particularly to overcome problems of corrosion under insulation (CUI).

Surface Preparation
All oil and grease must be removed from the substrate using an appropriate cleaner such as MEK.
The material is highly tolerant of less than ideal surface preparation but for optimum performance, the surface should be abrasive blasted to Swedish Standard SA2.5 and a minimum blast profile of 75 microns using an angular abrasive. Once blast cleaned, the surface must be degreased and cleaned using MEK or similar type material. All surfaces must be coated before gingering or oxidiation occur.

NOTE: For salt contaminated surfaces the area must be repeatedly water washed, preferably by power washing, until ingrained salts no longer come to the surface on drying. The surface should then be abrasive blast cleaned as above prior to cleaning and degreasing with MEK.

Where abrasive blast cleaning is not possible (excluding salt contaminated surfaces) the surface should be roughened by bristle blaster, needle gun or grinding.

In areas where the product should not adhere, a thin layer of a suitable release agent should be applied taking care not to contaminate other areas.

Application
Do not heat this material in bulk.
The material is supplied ready to use and requires no mixing. Do not apply when the ambient or substrate temperature is below 12°C or less than 3°C above the dew point. For best results it is recommended that the substrate is warmed to at least 35°C, when application will be enhanced. The material can be applied to substrates at higher temperature taking note of the cure times below.

Apply the material onto the prepared surface by brush or roller. In normal circumstances this should be in two coats at a target thickness of 250 microns per coat using a practical coverage rate of 3.5 sq metres per litre per coat.

The coating will remain in an unsolidified state until it has been heated to at least 90°C and should ideally be heated to at least 100°C. The second coat should be applied as soon as the first coat has become dimensionally stable and not more than 2 hours after it has reached this state. Where the maximum overcoating time is exceeded the surface of the material should be allowed to fully harden before being abraded, ideally by sweep blasting, and then cleaned and coated.

Alternatively the material can be applied by heated airless spray in as a single coat in multiple passes. The material should be heated to 50-60°C using heated lines to facilitate spraying.

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Cure Times
Cure times are dependent on the cure temperature as indicated in the table below.

Temp	Touch dry	Light loading	Full Loading
100°C	50 mins	2 hours	24 hours
110°C	35 mins	70 mins	16 hours
120°C	25 mins	50 mins	12hours
130°C	15 mins	30 mins	8 hours
140°C	7 mins	15 mins	6 hours
150°C	3 mins	7 mins	4 hours

Storage Life
At least 18 months if unopened and stored under normal dry conditions (5-25°C)

Technical data and Performance

Volume Capacity	714cc/Kg
Tensile Shear Adhesion ASTM D1002	197kg/cm² (2800psi)
Shore D ASTM D2240	20°C 90 100°C 86 150°C 80 200°C 72
Corrosion Resistance (ASTM B117)	1000 hours+

Health and Safety
Please ensure good practice is observed at all times during the mixing and application of this product. Protective gloves and other recommended personal protective equipment must be worn during the mixing and application of this product. Before mixing and applying the material please ensure you have read and fully understood the detailed Material Safety Data Sheet.

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