

## TECHNICAL DATA SHEET

# PERMALINE T 925

## SOLVENT FREE EPOXY FOR PORTABLE WATER TANKS

**DESCRIPTION:** A solvent free epoxy coating designed as a protective coating for metals in immersion service. It produces a tough, chemical resistant, flexible coating that is ideally suited for aggressive water service.

**RECOMMENDED USE:** It is recommended for steel tank internals to provide corrosion resistance to a range of products including crude oil, white oils and potable water.

**RESISTANCE TO:** Fresh water – Excellent      Crude Oil - Excellent  
Potable water - Excellent

### PRODUCT INFORMATION:

Colour: White and grey  
Finish: Semi-gloss  
Volume solids %: 100%  
V.O.C.: 0 g/l (NB. – Thinning will affect VOC compliance and volume solids)  
Typical thickness: 250-500 microns dry film thickness (250μ/coat)  
Theoretical coverage: 4 m<sup>2</sup>/ltr. @ 250 microns dft  
Density: 1.45 ± 0.1 g/cc (mixed)  
Mixing ratio: 2 : 1 by volume  
Shelf life: 12 months from the date of manufacture  
Pot life: 2 hours @ 30°C  
Pack size: Comp. A - 11 liters + Comp. B - 4 liters = 15 liters

FILM THICKNESS AND SPREADING RATE:	MIN.	MAX.	UNIT
Wet film thickness	250	500	μm
Dry film thickness	250	500	μm
Spreading rate	4	2	m <sup>2</sup> /l (theoretical)

This figure makes no allowance for surface profile, uneven application, overspray or losses in containers and equipment. Film thickness will vary depending on actual use and specification.

**SERVICE TEMPERATURE:** 120°C maximum dry

**RECOMMENDED THINNER:** Thinning is not recommended.

### DRYING & CURING TIME:

SUBSTRATE TEMPRATURE	15°C	23°C	40°C
Touch dry	15 hours	6 hours	1.5 hours
Dried to over coat (minimum)	30 hours	12 hours	4 hours
Walk-on-dry	24 hours	18 hours	12 hours
Dried/cured for service	15 days	7 days	4 days

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### SURFACE PREPARATION:

Steel: Remove all oil and grease in accordance with SSPC-SP1. Manually prepared surfaces should be prepared in accordance with SSPC-SP2 or SSPC-SP3. For more severe exposure, conditions blast cleaning to SSPC-SP 7 may be required. Abrasive blast clean to Sa 2 ½ BS7079:Part A1:1989. Average surface Profile 35 - 75 microns.

### RECOMMENDED COATING SYSTEM:

Primer for steel – Permagard P 270 ( If required )

### LAMINATE SYSTEM:

Blast primer:–	PERMAGARD P 270	25 to 50 microns DFT
Resin Compound:–	PERMALINE T 900	1500 to 2500 microns DFT
Glass mat 450 gms/sqm:	Powder bonded M3A	
Surface Veil 20gms/sqm:–	M524-C64 grade	One layer
Epoxy top/Gel coat:–	PERMALINE T 925	250 to 300 microns DFT

**RECOMMENDED APPLICATION METHODS:** Airless spray      Roller

### APPLICATION EQUIPMENT DETAILS:

AIRLESS SPRAY:	Nozzle Size: 0.92mm (36 thou)
	Fan Angle: 40°
	Operating Pressure: 115kg/cm <sup>2</sup> (3000 psi)

### APPLICATION CONDITIONS AND OVER COATINGS:

This material should preferably be applied at temperatures in excess of 10°C. In conditions of high relative humidity, i.e. 80-85%, good ventilation conditions are essential. Substrate temperature should be at least 3°C above the dew point and always above 0°C. At application temperatures below 10°C, drying and curing times will be significantly extended, and spraying characteristics may be impaired. Application at ambient air temperatures below 5°C is not recommended.

### HEALTH AND SAFETY:

Please observe the precautionary notices displayed on the container. Do not breathe or inhale mist. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water and medical attention sought immediately.

Consult Product Health and Material Safety Data Sheet for information on safe storage, handling and application of this product.

**Disclaimer:** The information in this document is given to the best of KPC Paint's knowledge that based on laboratory testing and practical experience Products are often used under conditions beyond KPC's control and KPC Paints cannot guarantee anything but the quality of the product itself.

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