

ADVAMASTIC 1280 HB

(High Build Surface Tolerant Epoxy)

GENERAL DESCRIPTION

It is a self-priming surface tolerant high solid polyamide cured epoxy coating with excellent wetting properties. It has excellent property of adhesion on old aged coating and provide high corrosion resistance property.

RECOMMENDED USE

For protection of new as well as old rusty structures and equipment in marine and other severe corrosive conditions. It can be applied even on manually cleaned surfaces where surface preparation by abrasive/hydro blasting is not feasible.

Physical Data

Colour	Aluminum, Grey
Finish	Smooth, Matt - Egg-shell
Volume Solids (by ASTM D 2697)	80 ± 2%
Mixing Ratio – Base: Hardener (by Volume)	4: 1
Wet Film Thickness	125 – 250 µm per coat
Recommended Dry Film Thickness	100 – 200 µm per coat
Theoretical Spreading Rate	7.2 m ² per litre @ 100 µm DFT 3.6 m ² per litre @ 200 µm DFT
Flash Point	>36°C
Continuous service temperature	0°C - 90°C

DRYING TIME:

Drying times are generally depend on air circulation, ambient temperature, film thickness and number of coats, and will be affected accordingly. The figures given in table below are indicative only.

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TEMPERATURE		15°C	25°C	35°C
INDUCTION TIME		20 minutes	15 minutes	10 minutes
TOUCH DRY		7 hours	5 hours	3 hours
HARD DRY		16 hours	10 hours	8 hours
OVERCOATING INTERVAL	MINIMUM	12 hours	10 hours	8 hours
	MAXIMUM	7 days	7 days	7 days
POT LIFE		5 hours	4 hours	3 hours

THINNER RECOMMENDED	Advoguard Thinner
SHELF LIFE	12 months @25°C

LIMITATION	
POT LIFE	If viscosity of mixed paints reaches more than double of initial viscosity do not apply the mixed paint anymore.
BLASTING OR APPLICATION	Do not carry out an application in the following conditions: When relative humidity > 95 % When ambient temperature < 10°C and ≥40°C When Substrate temperature is less than 3°C about the dew point.

SURFACE PREPARATION	Accumulated dirt and solvent salts must be removed by brush followed by fresh water cleaning. Repeat the process still the surface is free from chloride & dry it. Oil and grease should be removed following SSPC-SPI solvent cleaning. Clean the steel surface with potable water repeatedly till the surface is free from soluble chloride.
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ABRASION BLAST CLEANING	Abrasion blast clean to minimum Sa 2½ (ISO 8501-1:2007) or SSPC-SP10. Surface profile would be sharp and angular to 50 – 60 micrometres. Surface defects like weld spatters, holes etc. must be taken care. Ensure there is no oil and grease on the metal surface. Remove them by Advoguard Thinner. Remove soluble salts with potable water and dry the surface prior to painting.
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**MIXING METHOD**

Material is supplied in two containers as a unit. Always mix a complete unit in the proportions supplied. Agitate Base (Part A) with pneumatic stirrer and add Part B slowly and continue stirring 3-5 minutes till the mixture becomes homogeneous. Do not add thinner. If ambient temperature $>35^{\circ}\text{C}$, add 2-6% thinner to control the DFT.

AIRLESS APPLICATION

Pump Ratio : 60:1
Tip size : 0.48 – 0.68 mm
Air pressure : 4 – 5 Kg/cm²

BRUSH APPLICATION

For small area or to touch up, apply Advamastic 1280 HB by brush.

Do not apply when humidity is very high ($>95\%$) or the ambient temperature is below 3°C of dew point.

STORAGE

The product must be store below 25°C and in accordance with national regulations. Keep the containers in a dry, cool, well ventilated space, and away from source of heat and ignition. Containers must be kept tightly closed.

SAFETY PRECAUTIONS

Keep the material away from heat, spark, and direct flame. In case of contamination, rinse with fresh running water and seek medical help at once.

Provide sufficient ventilation when working with solvent based coatings in confined spaces and stagnant air. Follow Local and National Safety Rules.

WORK STOPPAGE

Clean the hoses, gun or spray equipment immediate after application. Do not allow material to remain in the equipment system.

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CLEAN UP	Clean all equipment thoroughly with Advoguard Thinner immediately after use. As part of good working practices, spray equipment should also be flushed periodically during the working day. The frequency of cleaning depends on factors such as the volume of material sprayed, ambient temperature, and the duration of any delays or downtime. Dispose of all surplus materials and empty containers responsibly, in compliance with applicable regional regulations and legislation.
NOTE	Thinner consumption and loss factor in practical coverage of paint depends upon the site condition. Avoid inhalation of solvent vapour or paint mist by using facial mask. Also use gloves and goggles to protect against direct contact of paint with skin and eyes. This cancels all previous information sheets for this Product. Information given here is in good faith without warranty.
DISCLAIMER	The information provided in this document is based on Advance Paints best knowledge, derived from laboratory testing and practical experience. As Advance Paints products are considered semi-finished goods, they are often used under conditions beyond the company's control. Therefore, Advance Paints can only guarantee the quality of the product itself and cannot assume responsibility for its performance under all circumstances. Minor variations in the product may occur to meet local requirements. Advance Paints reserves the right to amend the provided data without prior notice. Users should always consult Advance Paints for specific guidance on the suitability of this product for their particular needs and application practices.

Issue date: 1st August, 2023

This data list is not exhaustive. For further information or additional details, please reach out to our Technical Service Team.

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