

ADVOGUARD 3360 HB PDE (High Build Epoxy Coating)

GENERAL DESCRIPTION

Two component polyamide cured Epoxy Finish containing epoxy resin and selected inert pigments and extenders. It has excellent chemicals and solvent resistance in severe chemical and marine environments.

RECOMMENDED USE

For protection of steel structures, pipes, oil, rigs, etc. in highly corrosive and marine conditions.

PHYSICAL DATA

Colour	Light Grey, Dark Grey & other shades
Finish	Smooth and Eggshell
Volume Solids	62 ± 2%
Mixing Ratio (By Volume)	4 : 1 (PART A : PART B)
Dry Film Thickness	100 -125 µm per coat
Wet Film Thickness	160 -200 µm per coat
Spreading Rate	4.96 m ² per litre @125 µm DFT
Flash Point	> 30°C
Adhesion (By ASTM D 4541)	Passes 8 MPa

DRYING TIME:

Drying times are generally depending 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		15 Minutes	10 Minutes	5 Minutes
TOUCH DRY		3 hours	2 hours	75 Minutes
HARD DRY		12 hours	10 hours	8 hours
OVERCOATING INTERVAL	MINIMUM	20 hours	16 hours	12 hours
	MAXIMUM	Infinite	Infinite	Infinite
POT LIFE		10 hours	8 hours	6 hours

THINNER RECOMMENDED	Advoguard Epoxy 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. Pot life can be increased, if the containers are stored in A/C room @20°C or below prior to mixing & application.
BLASTING OR APPLICATION	Do not carry out an application in the following conditions: When relative humidity > 95% When ambient temperature < 10°C and ≥ 45°C When substrate temperature is less than 3°C above 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. Advoguard 3360 PDE should be always applied on suitable and compatible primer, eg. Advoguard 1250, Advoguard 1242, Galozinc 1180.
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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 40 – 60 micron. Coating should be applied prior to surface oxidation. If surface oxidation has occurred, reblast to visual standard. Surface defects like weld spatters, holes etc. must be taken care.
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 add slowly hardener (Part B) for 3-5 minutes till the mixture becomes homogeneous. If ambient temperature >40°C, add 3-6% thinner to avoid dry spray and to control the DFT.
AIRLESS APPLICATION	Pump Ratio: 60: 1 Tip size : 0.46 – 0.68 mm Air pressure: 4 – 5 Bar
CONVENTIONAL AIR SPRAY	Air Spray Gun (Pilot Type 59) Pressure – 3 – 4 Kg/sq cm Nozzle size – 1.2 – 1.8 mm
BRUSH APPLICATION	For small area or to touch up, apply by brush. Do not apply when humidity is very high (>95°C) 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 with suitable epoxy thinner or solvent immediate after application. Do not allow material to remain in the equipment system.

CLEAN UP

Clean all equipment thoroughly with Advoguard Epoxy 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.

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

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