

Product Description

A two component, low VOC, high volume solids, surface tolerant epoxy coating.

Recommended Uses

For application to a wide variety of substrates including ballast tank, hull, void spaces. Suitable for using with controlled cathodic protection.

Product Information

Color	EP4001 Red EP4002 Grey EP4008 Aluminium (the first coat for ballast tank)
Part B(Curing Agent)	EPC400
Gloss Level	Semi gloss
Volume Solids	83% ± 3%
Typical Thickness	100–250 microns dry (120–300 microns wet)
Theoretical Coverage	8.30–3.32 m ² /litre at 100–250 microns D.F.T.
Mix Ratio	Part A(Base) to Part B(Curing Agent)= 5.5:1 (by volume)
Flash Point	38°C
VOC	232 g/lit (EPA method 24)

Surface Preparations

All surfaces to be coated must be clean, dry and free from contamination. High pressure fresh water wash or fresh water wash, as appropriate, and remove all oil or grease, soluble contaminants and other foreign matter in accordance with SSPC–SP1 solvent cleaning.

Bare Steel	For immersion service, HilonGuard 2400 must be applied to surfaces blast cleaned to Sa2½(ISO 8501–1:2007) or SSPC–SP10. However, for atmospheric exposure best performance will be achieved when HilonGuard 2400 is applied to surfaces prepared to a minimum of Sa2.5 or Sa2 (ISO 8501–1:2007). A surface profile of 50–75 microns is recommended. Hand or power tool clean to a minimum St2 (ISO 8501–1:2007).
Primed Surfaces	Approved primers must be clean, dry and free from soluble salts and any other surface contaminants. Unapproved primers will require complete removal by blast cleaning to Sa2½(ISO 8501–1: 2007).Consult Hilon representative for specific recommendations.
Aged Coatings	HilonGuard 2400 is suitable for overcoating a limited range of intact, tightly adherent aged coatings. Loose or flaking coatings should be removed back to a firm edge. Glossy finishes may require light abrasion to provide a physical roughness.
Others	Please consult Hilon representative.

Application

Application Condition	Surface temperature must always be a minimum of 3°C above dew point. Good ventilation is required in confined areas to ensure proper drying. During application and the initial drying of the coating, the coating should not be exposed to high humidity.
Mixing	Combine 5.5 parts of Base with 1 part of Curing Agent and mix thoroughly with power agitator.
Pot Life (23°C)	2 hours (Reduced at higher temperature)
Thinner	THR100
Airless Spray	Recommended

	Tip Range 0.45–0.58 mm (18–23 thou)
	Total output fluid pressure at spray tip not less than 170 kg/cm ² (2420 p.s.i.)
Air Spray	Recommended
Brush	Application by brush is recommended for small areas only. Multiple coats may be required to achieve specified film thickness
Roller	Roller Application by roller is recommended for small areas only. Multiple coats may be required to achieve specified film thickness

Drying information

Temperature	10°C	15°C	25°C	40°C
Touch Dry	8 hrs	7 hrs	5 hrs	2 hrs
Hard Dry	30 hrs	24 hrs	16 hrs	6 hrs

Overcoating data

Temperature	10°C		15°C		25°C		40°C	
	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.
HilonGuard 2400 (immersion)	30 hrs	28 days	24 hrs	28 days	16 hrs	21 days	6 hrs	14 days
HilonGuard 2400 (non-immersion)	30 hrs	3 mths	24 hrs	3 mths	16 hrs	28 days	6 hrs	21 mths
HionTie 5310	8 hrs	3 mths	7 hrs	3 mths	5 hrs	28 days	2 hrs	21 days
HilonDeco Cryl 9200	30 hrs	3 mths	24 hrs	3 mths	16 hrs	28 days	6 hrs	21 days
HilonDeco EP 9300	24 hrs	28 days	20 hrs	28 days	14 hrs	21 days	4 hrs	14 days

*The overcoating interval is varies according to different top coating and environment. Consult Hilon representative for specific recommendations.

#For curing at low temperatures, an alternative curing agent is available. Consult Hilon representative for specific recommendations.

Unit Size

20 litres unit: 16.92 litres part A (Base) in a 20 litres container, 3.08 litres part B (Curing Agent) in a 5 litres container

Storage

Must be stored in accordance with national regulations. Store in dry, shaded conditions away from sources of heat and ignition.

Health And Safety

Prior to use, obtain, consult and follow the Material Safety Data Sheet for this product concerning health and safety information, and apply and use the coating according to the national state of health and safety as well as environmental protection standards and regulations.

Important note

The information in this data sheet is not intended to be exhaustive, for your reference only. The information contained in this data sheet is liable to modification from time to time in the light of experience and our policy of continuous development. Please contact us and request the latest version prior to using the product.