

ARMATEC Environmental Ltd

Air Pollution Control

Chemical Containment

Industrial Fibreglass

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APPLICATION INSTRUCTIONS FOR ARMALINE® 1730

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1. Armaline® 1730

Armaline® 1730 is a two component, high build epoxy coating generally applied in 2 coats. A primer may be used first. It is a flake filled epoxy system with a very low permeability for long life in wet conditions. It is amine adduct cured and bonds to damp substrates, cures at low temperatures and cures under water.

2. Application to Concrete

Surface Preparation.

A good water blast should provide a clean surface with concrete aggregate showing. Sometimes a high pressure water blasting is needed to remove concrete laitance. It is important to remove all unsound concrete, coatings, dirt and bacteria. If Armaline® 1730 is applied to a surface where there is running water it is possible it may be washed away, and falling water such as rain will mark the coating while it is curing so surfaces need to be protected from running and falling water.

Priming

Armaline® 1730 can be applied direct to concrete without a primer. ARMATEC EP7 Primer can be used on concrete substrates where the job supervisor wants to fill deep holes before the Armaline® 1730 is applied. EP7 Primer is applied by brush, roller or spray. EP7 bonds to damp concrete but the drier the concrete the better the bond.

Patching Holes Before Coating

Cavities and voids in the concrete surface can cause pinholes in the coating. Patch these cavities and voids after priming the concrete and after allowing the primer to cure. To patch, mix EP7 primer (Parts A and B mixed) with filler material available from ARMATEC and trowel apply to fill holes. Allow to cure before applying Armaline® 1730.

Armaline® 1730 and Primer Mixing

Take one tin of Part A and the corresponding tin of Part B (check mixing quantities on label) and simply mix together in the Part A tin or a separate container. It is important that the mixture be stirred thoroughly for 1 to 2 minutes until a uniform colour is obtained. The material is now ready to apply.

NO THINNERS TO BE ADDED.

For cleanup, use ARMATEC Clean-up Solvent or Methyl Ethyl Ketone (MEK).

Armaline® 1730 Application to Concrete

Armaline® 1730 is applied to concrete by brush, roller or spray. For wet or damp concrete it is best applied with a roller using good pressure to the roller to try to squeeze the coating into the concrete as much as possible. A coating thickness of 0.2 to 1.0 mm can be achieved in a single coat - the applicator needs to vary this to suit the application. Too thick a coating may drain on a vertical surface and may waste materials. Time between any recoats should be minimised with a maximum of 4 days. Refer to section 4 for usage rates to achieve various coating thicknesses.

3. Armaline® 1730 On Steel

Surface Preparation.

For an application to steel the surface needs to be grit blasted with steel grit or garnet to remove all loose material and achieve a profile of at least 50 microns. Note that the profile must be across the entire area and not in isolated patches. All sharp protrusions need to be removed, and sharp edges should be radiused.

Priming

Armaline® 1730 can be applied direct to steel surface without a primer. ARMATEC EP7 Primer can be used on steel substrate where the job supervisor wants to hold the blast profile before the Armaline® 1730 is applied. EP7 Primer can be applied by brush, roller or spray and the steel should preferably be as dry as possible.

Armaline® 1730 and Primer Mixing

Take one tin of Part A and the corresponding tin of Part B (check mixing quantities on label) and simply mix together in the Part A tin or a separate container. It is important that the mixture be stirred thoroughly for 1 to 2 minutes until a uniform colour is obtained. The material is now ready to apply.

NO THINNERS TO BE ADDED.

For cleanup, use ARMATEC Clean-up Solvent or Methyl Ethyl Ketone (MEK).

Armaline® 1730 Application

Armaline® 1730 is applied to steel by brush, roller or spray. A coating thickness of 0.25 to 1.00 mm can be achieved in a single coat - the applicator needs to vary this to suit the application. Too thick a coating may drain on a vertical surface and may waste materials. Time between any recoats should be minimised with a maximum of 4 days. Refer to section 4 for usage rates to achieve various coating thicknesses.

4. Curing and Materials Usage

Curing of Resin

Armaline® 1730 will set in approximately 4 to 6 hours and will take 2 to 4 days under normal temperature conditions to reach full cure. ARMATEC EP7 primer will set in approximately 4 to 6 hours and can then be overcoated. After applying each batch the residual product should be kept and its cure monitored for quality assurance purposes.

Usage of materials:

Armaline® 1730: Apply in 1 or 2 coats to achieve desired thickness for service.

- For light duty service 0.4 to 0.6 mm thick: Allow total material of 1 kg per square metre.
- For medium duty service 0.6 to 0.8 mm thick: Allow total material of 1.5 kg per square metre.
- For heavy duty service 0.8 to 1.0 mm thick: Allow total material of 2 kg per square metre.

Heavy duty service includes full immersion service, whereas light duty refers to non-immersion service.

ARMATEC EP7 Primer: Allow 0.25 kg per square metre where needed.

5. Safety

Armaline® 1730 and ARMATEC EP7 primer contain epoxy resins and amine adduct catalysts. Product Material Safety Data Sheets (MSDS) are available and should be consulted when handling products. Always wear gloves and appropriate work clothing to minimise contact. Use ventilation especially in enclosed spaces.

If additional information is required, please contact ARMATEC.