



# High Performance Paint Product Data Sheet



## TUFF COTE 2K EPOXY

49-130X JUN 09



**DESCRIPTION:** Environmentally friendly high-build 2-pack water based anti-corrosive epoxy for direct to metal applications which protects against weak acids, alkalis and solvents.

**TYPICAL USES:** Excellent adhesion to well prepared substrates. Specially designed to protect metallic surfaces. The applications include truck chassis, trailers, beams, poles, roofs, fences and other medium to heavy industrial steel structures. For other surfaces, such as concrete, wood and plastic, please use alternative products such as EPOTEC HIGH BUILD EPOXY or TUFF FLOOR WB EPOXY. Does not require a topcoat in interior or unexposed environments.

**PERFORMANCE:** This is a premium epoxy coating with superior adhesion to ferrous and non-ferrous metals, abrasion resistance, flash-rust resistance, chemical resistance and anti-corrosive properties. Easy to apply. Water clean up.

**LIMITATIONS:** Do not apply where temperatures are below 10°C. Always ensure the product has covered all of the substrate, re-coat or touch-up if necessary, before topcoats are applied. Epoxies could take several hours to reach initial hardness, avoid rain or water splashing onto the uncured surfaces. Mix product well before use as heavy anti-corrosive pigments can settle.

### TECHNICAL DATA:

Resin:	Two component epoxy
Solvent:	Water
Finish:	Satin (30-40% @ 60°)
Colour:	Limited Colours
Touch Dry (minimum):	30 minutes @ 20°C
Recoat Time (minimum):	2 hours
Primer:	Not Required
Number of Coats:	2
Dry Film Thickness:	75 microns (max. 125 microns)
Wet Film Thickness:	150 microns (max. 250 microns)
Durability:	Very good
Thinning and Clean Up:	Water
VOC:	
Pot Life:	120-135 minutes @20°C
Mixing Ratio:	5:1 by weight
Pack Size:	5, 20 Kg

### SPREAD RATE:

As a primer: 7 - 8 m<sup>2</sup>/litre/coat or 4 - 5 m<sup>2</sup>/litre for high build. Actual coverage may reduce by up to 20% on porous or textured surfaces. Coverage depends on surface profile and porosity.

### COMPUTER CODES:

Tuff Cote 2K Epoxy Accent	49-1305
Tuff Cote 2K Epoxy Part B	49-0000

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# TUFF COTE 2K EPOXY

## **SURFACE PREPARATION:**

(Refer to "Surface Preparation and Paint Systems" for full details). To ensure a successful application all surfaces to be coated must be clean, dry and stable.

Note: Commencement of work on a surface means in general you accept that surface. If any doubt about condition etc, seek advice.

TUFF COTE 2K EPOXY can be used as a topcoat in interior or unexposed applications. 2 – 3 coats of TUFF COTE 2K EPOXY are recommended to achieve desired protection against corrosion, abrasion and chemicals.

## **STEEL/IRON:**

Remove all rust, grease and oil. Apply 1 coat TUFF COTE 2K EPOXY, after 2 hours drying at 20°C; recoat with TUFF COTE 2K EPOXY, or for a decorative finish, apply 2 coats of AQUATEC LP or TUFF COTE FINISH.

## **ALUMINIUM/BRONZE:**

Remove all rust, grease and oil. Apply 1 coat TUFF COTE 2K EPOXY, after 2 hours drying at 20°C; for a decorative finish, apply 2 coats of AQUATEC LP or TUFF COTE FINISH.

## **GALVANISED IRON:**

Galvanised iron sheets that are lapped must be coated in the lap areas to stop corrosion.

**NEW:** All new galvanised iron has an oil/grease coating from roll forming and it must be removed before coating. This can be done by leaving the roof exposed to the elements for 3 months, before painting or by using a suitable roof wash solution.

**OLD:** Apply 1 coat TUFF COTE 2K EPOXY, after 2 hours drying at 20°C; apply 2 coats of ACRYLIC ROOF PAINT or AQUATEC LP. Wash all areas with a suitable roof wash solution. Areas of rust must be wire-brushed, to remove loose rust etc. Apply RUST KILL to convert any remaining rust. Wash area thoroughly and allow to dry.

Apply 1 coat TUFF COTE 2K EPOXY, after 2 hours drying at 20°C; apply 2 coats of ACRYLIC ROOF PAINT or AQUATEC LP. If roofs are being used for collection of drinking water, it is strongly recommended that roof down pipes are disconnected until after the first major rainfall event (≥10mm).

## **NON-METALLIC SURFACES:**

For surfaces such as concrete, wood or plastic, please use alternative water based epoxy products, such as TUFF FLOOR WB EPOXY or EPOTEC HIGH BUILD EPOXY.

## **APPLICATION:**

Mix Part A well, ensuring the product is free-flowing before adding Part B. Mix Part B into Part A with a broad paddle for 2-3 minutes, ensuring that sides and bottom of the pot have been completely mixed in. Allow to stand for further 10 minutes. Stir for a further minute before application.

**BRUSH AND ROLLER:** Use product as is or add up to 5% potable water if high temperatures or windy conditions. This will ease roller/ brush drag and assist in keeping a wet edge.

**ROLLER:** Use an 8-12mm nap dacron roller.

**SPRAY:** Airless spraying is recommended. Pressure 2,500psi max and a 209 tip for detailed work and 413 tip for general application. Add up to 5% potable water if necessary. Airless spray will deliver a higher film build, about 275 microns per coat. Best performance is achieved by an initial low-build pass (tack coat), followed by a full spray of finish coat.

End of pot-life is observed when stirring does not return the product to a free flowing state. Prior to re-coating, test the coating by pressing your thumb into the coating for 2 seconds. Re-coat only if no impression is made in the coating. Generally it takes around 2 hours in summer and longer in winter.

## **THINNING & CLEAN UP:**

Maximum thinning is 5%. Only thin after parts A and B have been thoroughly mixed. Rinse Part B into Part A with water to ensure optimal curing. Clean up with water and detergent.

## **ENVIRONMENTAL:**

This formulation uses the latest technology with low toxicity, ensuring environmental issues are not compromised. DO NOT POUR paint or wash down storm water or water courses. ALWAYS dispose of in accordance with local Government regulations. Soak up spills with absorbent material and dispose of properly. If spraying use suitable respiratory protection. Refer to the MATERIAL SAFETY DATA SHEET.