



**ATIYEH PAYESH BARAK CHEMICAL COMPANY  
(OXsos)**

**Marine, Offshore, Industrial & Protective Coatings**

**Data sheet**

# OXSPOXY INTERMEDIATE 319 HB.

## Product Description

A high build two component polyamide cured epoxy coating suitable for atmospheric and immersion conditions. The product is designed as a matt final coat of protective system and as an Intermediate coat between organic and inorganic zinc-rich primers and the final topcoat.

## Physical Properties

<u>Color/Texture</u>	Cream (RAL), Light Gray (RAL) / Matt
<u>Volume Solids</u>	70%
<u>Specific gravity</u>	1.50 ± 0.05 gr/ml
<u>Flashpoint</u>	>27°C

	Dry film thickness per coat (μ)	Wet film thickness per coat (μ)	Theoretical spreading rate (m <sup>2</sup> /l)
Range	75 - 200	110-285	9.3-3.5
Recommended	150	215	4.7

Note: Specific gravity of paint may vary slightly due to shade difference.

## Application Data

<u>Mixing ratio</u>	by wt. base to hardener: 89 to 11
<u>Pot life</u>	10°C: 6 hours    23°C: 4 hours    30°C: 2 hours    40°C: 1 hours
<u>Induction time</u>	20 minutes
<u>Guiding data Airless spray</u>	Pressure at nozzle: 120-180 bar.    Nozzle size: 0.48 – 0.66 mm Spray angle: 40 – 80 degrees.    Volume of thinner: 5-10 %.
<u>Guiding data Air spray</u>	Pressure: 3-5 bar. Nozzle size: 1.5 – 2.0 mm. Volume of thinner: 0 –15%
<u>Brush/Roller</u>	Suitable Multicoat are required to achieve the specified dry film thickness. Volume of thinner: 0 – 5 %
<u>Thinner/ Cleaner</u>	OXSOS epoxy Thinner T-63. If thinner is necessary, this should be added after mixing of the two Components. Avoid excessive thinning as it will result in lower sag resistance and slower cure.

## Drying and Recoating Times<sup>1</sup>

Substrate temperature	Touch dry	Dry to handle	Hard dry	Dry to recoat	Dry to recoat
				Minimum	Maximum
10° C	7 hours	24 hours	12 days	24 hours	10 days
23° C	3 hours	16 hours	8 days	16 hours	8 days
30° C	2 hours	10 hours	6 days	10 hours	5 days
40° C	1 hours	7 hours	4 days	8 hours	3 days

(<sup>1</sup>): The given data must be considered as guidelines only. The actual drying time/times before recoating may be shorter or longer, depending on film thickness, ventilation, humidity, preceding paint system etc.

(<sup>2</sup>): The surface should be dry and free from contaminants prior to over coating. The best intercoat adhesion is achieved when the subsequent coat is applied before the preceding coat is fully cured. After prolonged exposure times it may be necessary to roughen the surface to ensure intercoat adhesion. When recoating with single pack products. maximum recoat interval is limited to 16-24 hours. When in doubt, consult your nearest OXSOS office.

## Surface Preparation

<b>Coated substrates</b>	Oil and grease should be removed by solvent cleaning according to SSPC-SP1. Remove Weld spatter and smooth weld seams and sharp edges as applicable. Remove salts and Dirt by fresh water washing. Corroded and damaged areas should be repaired with an Appropriate primer system.
<b>Inorganic Zinc Silicates</b>	Remove zinc-salts and ensure that the zinc silicate has been fully cured. Apply a mist Coat of <b>OXSOPOXY intermediate 319 HB</b> . first.

## Application Conditions

The temperature of the substrate should be at least 10°C and at least 3°C above the dew point of the air. Temperature and relative humidity should be measured in the vicinity of the substrate. Humidity should be below 80% RH. The maximum recommended surface temperature is approx. 35°C. Higher steel temperature is acceptable provided dry-spray is avoided by proper spray application and extra thinning if required. In extreme cases it may be necessary to reduce film thickness in order to avoid sagging. When applying the paint in confined spaces, provide adequate ventilation during application and drying. The temperature of the mixed paint should be at least 10°C, otherwise extra solvent may be required to obtain a proper application viscosity. The maximum temperature of paint before application should be 40°C.

## Storage and Shelf Life

This product has the shelf life of 12 months in storage temperature of 10 -30°C. The cans are to be kept in a dry, cool, well ventilated space and away from source of heat and ignition. Cans must be kept tightly closed.

## Worldwide Availability

The product is part of the common OXSOS product range but local availability is subject to confirmation. Although we strive to supply the same product through the world, slight modifications of the product in some cases may be necessary in order to comply with local conditions and national regulations. In such cases an alternative datasheet will issued.

## Health and Safety

Observe the precautionary notices on the label of the container. A material safety data sheet is available upon request and national or local safety regulations should be followed. This product is intended for use by professional applicators. As a general rule, avoid skin- and eye contact by wearing overalls, gloves, goggles, mask, etc. Spraying should be carried out under well-ventilated conditions. THIS product contains flammable materials and should be kept away from sparks and open flames. Smoking in the area should not be permitted.

## Disclaimer

The information in this data sheet is provided to the best of our knowledge. However, we have no control over either quality or condition of the substrate and other factors affecting the use and application of this product. Therefore, we cannot accept any liability whatsoever or howsoever arising from the performance of the product or for any loss or damage arising from the use of this product. We reserve the right to change the product without notice.

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