

**PRODUCT NAME**

**Synergy® PPE18 2 Pk Epoxy**  
TECHNICAL DATASHEET



**HMG Coatings (South) Ltd**  
Faraday Park  
West Portway Ind Est  
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**Tel:** 01264 356296  
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**PRODUCT DESCRIPTION**

A two-pack polyamide cured epoxy resin system containing anticorrosive and other carefully selected pigments and extenders. This product has been specially formulated as a compliant coating conforming to Department of Environment PG623(04) table 6, having a solvent content of less than 0.6 times the total mass of solids.

**INTENDED USES**

Combining an epoxy resin system with excellent anti-corrosive properties, 100:006 is designed to be a relatively quick drying two-component primer for various paint systems over shot blasted steel.

**Technical Information****COLOUR**

Lt Grey, plus a limited colour range (subject to commercially viable order quantities).

**GLOSS LEVEL**

Matt

**SOLIDS CONTENT**

69% by weight

**FILM THICKNESS**

A minimum dry film thickness of 50 microns per coat is recommended, which is equivalent to a wet film thickness of 100 microns. If more than one coat is required, allow at least 3 hours between coats. On blast-cleaned surfaces, a minimum of 2 coats is recommended to give a dry film thickness of 50 microns above the peaks of the blast profile.

**THEORETICAL COVERAGE**

10 square metres per litre per coat, when sprayed at a wet film thickness of 100 microns.  
NB. The practical coverage rate depends on many factors and will be less than the theoretical figure.

**METHOD OF APPLICATION**

Apply by convention or airless spray to suitably prepared substrates  
Airless tip size 13-15 thou

**DRYING TIME**

Touch Dry	45mins
Handle	6 hours
Full Cure	7-10 days dependent on temperature

Drying times are quoted at 20°C and will vary actual conditions such as: film thickness, air movement, temperature and humidity

**Technical Data Sheets are also available on our website at [www.hmgcoatings.co.uk](http://www.hmgcoatings.co.uk)**

ALL MATERIALS SHOULD BE STIRRED AND CHECKED FOR COLOUR AND SHEEN BEFORE USE. NO CLAIMS FOR DISCREPANCY OF COLOUR OR GLOSS CAN BE ACCEPTED AFTER USE. INFORMATION CONTAINED ON THIS DATA SHEET IS TO THE BEST OF OUR KNOWLEDGE TRUE AND ACCURATE AND IS GIVEN IN GOOD FAITH, BUT WITHOUT WARRANTY, SINCE THE APPLICATION, USE AND PROCESSING OF THE PRODUCT IS BEYOND OUR CONTROL.

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**FLASH POINT**

Below 32 °C

**SHELF LIFE**

6 months when stored indoors in original unopened containers, dependent on temperature and conditions. Mix through before use.

**PACKAGING**

The two components are supplied in proportion to make 5 or 20 litres of mixed products

**HEALTH AND SAFETY**

Familiarise yourself with this products MSDS before use. if you need to obtain a copy telephone us on: 01264 356296

**Application****SURFACE PREPARATION**

Shot blasting is preferred method of surface preparation for steel. Painting should then be carried out within four hours. If oxidisation has occurred before painting the surface should be re-blasted. if shot not practical, clean and degreased the steel substrate and completely remove rust, burns and oily residues. Sharp edges at welded seams should be dry and free from lamination or dust

**APPLICATION CONDITIONS**

Do not apply or dry when air or surface temperature is below 10°C or in high humidity or where condensation is likely to occur (i.e. Surface temperature must always be a minimum of 3 °C above dew point). Painting should only be carried about under good atmospheric conditions and clement weather. Preparation, painting and drying shout never be undertaken: when the air temperature falls below minimum temperature for the coating, or during fog, mist, snow, or when rain is imminent or when the surface to be painted is wet with condensation or when condensation may occur during the drying period.

**MIXING RATIO**

4 Base to 1 Activator by volume. Allow to stand for 15-20mins when mixed before applying

**POT LIFE**

Up to 16 hours in closed container, dependent on the ambient temperature.

**OVERCOATING**

3-12 hours or overnight  
**CAUTION:** The thicker the coating the longer the curing cycle will take

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**Thinning and Cleaning**

**THINNING**

2 Pack Epoxy Thinners

**CLEANING**

Clean all equipment using Synergy® Gunwash immediately. Ensure all lines, tips, etc. are thoroughly flushed out. It is not sufficient to leave equipment filled up with solvent

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