TECHNICAL DATA SHEET

PERMAGRIP MIO 80

Surface Tolerant Polyamide cured Epoxy Intermediate

DESCRIPTION: PERMAGRIP MIO 80 – A two component, high build, surface tolerant modified polyamide cured epoxy pigmented with micaceous iron oxide (MIO) and inert extenders.

RECOMMENDED USE: Recommended to use for offshore environments, refineries, power plants, bridges, steel structures, pipes, etc. It is designed to be used as primer or mid-coat in a suitable coating system for highly corrosive environments. Can also be used as a finish coat or single coat system in atmospheric environments where chalking is not a concern.

RESISTANCE TO: Moisture – Excellent; Weather – Excellent; Abrasion – Excellent; Petroleum Solvents – Excellent; Aliphatic Solvents – Excellent

PRODUCT INFORMATION:

Color:	Grey & Reddish grey
Finish:	Matt
Volume solids %:	82 ± 2 % (ASTM-D2697-86)
V.O.C.:	180 g/l (NB. – Thinning will affect VOC compliance and volume solids)
Typical thickness:	100 - 250 microns dry film thickness
Theoretical coverage:	8.2 m²/ltr. @ 100 microns dft
Density:	1.60 ± 0.1 g/cc (mixed)
Flash point:	Base: 46°C C/A: 25°C
Mixing ratio:	4 : 1 by volume
Shelf life:	12 months from the date of manufacture
Pot life:	2 hours @ 35°C
Pack size:	Comp. A – 16 liters + Comp. B – 4 liters = 20 liters

FILM THICKNESS AND SPREADING RATE:	**MIN.**	**MAX.**	**UNIT**
Dry film thickness	100	250	µm
Wet film thickness	122	304	µm
Spreading rate	8.2	3.3	m^2/l (theoretical)

This figure makes no allowance for surface profile, uneven application, overspray or losses in containers and equipment. Film thickness will vary depending on actual use and specification.

SERVICE TEMPERATURE: 120°C maximum dry

RECOMMENDED THINNER: Thinner No.5 (5-10% as required based on application)

DRYING & CURING TIME:

SUBSTRATE TEMPRATURE	**15°C**	**23°C**	**35°C**
Touch dry	6 hours	4 hours	2 hours
Dried to over coat (minimum)	16 hours	12 hours	8 hours
Hard dry	48 hours	36 hours	24 hours

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SURFACE PREPARATION:

Remove all oil and grease in accordance with SSPC-SP1. Manually prepared surfaces should be prepared in accordance with SSPC-SP2 or SSPC-SP3. For more severe exposure, conditions blast cleaning to SSPC-SP 7 may be required. Abrasive blast cleans to Sa 2 ½ BS7079: Part A1:1989. Average surface Profile 35 - 75 microns.

RECOMMENDED COATING SYSTEM:

Primer coat:	PERMAZINC 90, PERMAZINC IO 90
Intermediate coat:	PERMAGRIP MIO 80
Topcoat:	PERMATHANE T 137

Note: The above mentioned is a generally used system for steel structures, and if any alternative systems are required, please contact the KPC's technical team.

RECOMMENDED APPLICATION METHODS: Airless spray, conventional spray, roller (short pile only), brush

APPLICATION EQUIPMENT DETAILS:

AIRLESS SPRAY:
Nozzle Tip Size: 0.017 - 0.023"
Fan Angle: 40°
Operating Pressure: 150 bar (2200 psi)

CONVENTIONAL SPRAY:
Nozzle Size: 1.27mm
Atomizing pressure: 2.8kg/cm² (40 psi)
Fluid Pressure: 0.7kg/cm² (10 psi)

APPLICATION CONDITIONS AND OVER COATINGS:

This material should preferably be applied at temperatures more than 10°C. In conditions of high relative humidity, i.e. 80-85%, good ventilation conditions are essential. Substrate temperature should be at least 3°C above the dew point and always above 0°C. At application temperatures below 10°C, drying and curing times will be significantly extended, and spraying characteristics may be impaired. Application at ambient air temperatures below 5°C is not recommended.

HEALTH AND SAFETY:

Please observe the precautionary notices displayed on the container. Do not breathe or inhale mist. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water and medical attention sought immediately. Consult Product Health and Material Safety Data Sheet for information on safe storage, handling and application of this product.

Disclaimer: The information in this document is given to the best of KPC Paint's knowledge that based on laboratory testing and practical experience Products are often used under conditions beyond KPC's control and KPC Paints cannot guarantee anything but the quality of the product itself.

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