



A two component, high solids, high build, polyamide cured epoxy resin based self priming coating with excellent resistance to corrosion and abrasion. Also, it provides a hard and tough film with long term durability. It can be applied over new or old steel, requiring only the removal of loose rust and scale, and applied over most existing coatings.

Recommended use	Recommended as a primer or middle coating for long-life protection of steel structures in severely corrosive environment such as plant, fences, piping, high way bridges, exposed area of chemical tanks and structural steel.
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Physical Properties

Finish and Color	Off-White, Grey (1128), Aluminum etc
Specific gravity	Approx. 1.3 – 1.5 for Mixture of Base and Curing agent.
Solids by volume	Approx. 80 % (Determined by ISO 3233)
Spreading rate (Theoretical)	6.0 m ² /L in 125 μm dry film thickness on a smooth surface.
Flash point	Base (EH4158HM-A) : 25 °C / 77 °F (Closed cup) Curing Agent (EH4158HM-B) : 25 °C / 77 °F (Closed cup)

Application details

Surface preparation	Remove any oil, grease, dirt and any other contaminants from the surface before painting by proper method such as solvent cleaning and fresh water washing, etc. * Steel : Blast cleaning to Sa2.5 or Power tool cleaning to St3, etc.			
Method of application	Spray (Airless or Air), Roller or Brush application. For airless spray application ; Nozzle orifice : 483 μm ~ 584 μm (0.019" ~ 0.027") Output pressure : 11.7 MPa ~ 15.2 MPa Fan : 40 ° ~ 60 ° (Airless spray data are indicative and subject to adjustment)			
Mixing	Base (Part A) : Curing Agent (Part B) = 1 : 1 (by volume) Mix thoroughly together prior to application in the proportions with power agitator as delivered.			
Thinning	Thinner No. 024, 002 or Other thinner approved by KCC For repairs with loose paint film such as alkyd, use Thinner No. 002. Do not dilute each components separately, only the mixture.			
Application conditions	The surface should be completely cleaned and dried. Do not apply when relative humidity is above 85 %. The surface temperature should be at least 2.7 °C (5 °F) above dew point to prevent condensation. In confined areas, ventilate with clean air during application to assist solvent evaporation			
Film thickness	125 μm dry. May be specified in another film thickness than indicated depending on purpose and area of use.			
Drying time	Substrate temperature	5 °C / 41 °F	20 °C / 68 °F	30 °C / 86 °F
	Set to touch	16 h	3 h	2 h

	Dry through	72 h	24 h	12 h
	* The actual drying time is subject to the film thickness, ventilation, humidity etc., and drying time under other temperature conditions should be checked and informed by KCC.			
Subsequent Coat	Korepox H.S. EH4158HM, Korepox Topcoat H.B. ET5740, Korepox Topcoat H.B. ET5745, Korethan Topcoat UT6581, or according to specification.			
Pot life	5 h at 20 °C / 68 °F			
Recoating interval	At 20 °C / 68 °F, Minimum : 12 h Maximum : – Immersion : 10 d – Non-immersion : 30 d with itself 7 d with urethane topcoat Prior to overcoating, remove the oil, salts, chalking materials and any other contaminants on aged coating film completely by proper cleaning method such as solvent cleaning and/or fresh water washing.			
Heat resistance temperature	Continuous : 93 °C / 200 °F (Non-immersion service) Non-continuous : 121 °C / 250 °F (Non-immersion service)			
Storage and package				
Shelf life	12 months			
Packing Unit	16 L (EH4158HM-A : 8 L, EH4158HM-B : 8 L)			
Remarks				
Note	Do not store at temperature below 5 °C / 41 °F or above 40 °C / 104 °F. Protect skin and eyes from direct contact with liquid paint, and avoid prolonged breathing of solvent vapors. Use with adequate ventilation. Respiratory protection is recommended when applying this product in confined spaces or stagnant air. If you apply metallic colour(9181) as T/UP, colour difference could occur. So please contact technical department before the application.			
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Revision				

Disclaimer : The information in this data sheet is believed to the best of our knowledge based on laboratory test and practical experience. However, there are many factors affecting the performance of product and the product quality itself, so we are not able to guarantee without the confirmation of the purpose of using the product from us in writing. We reserve the right to change the data without notice and you should check that this data sheet is current prior to using the product.

