



A two-component, polyamide cured epoxy resin based high-build coating for heavy steel structures. It provides good resistance to water and excellent anti-corrosive property.

Recommended use	As a high-build primer or intermediate coat for use on the bridge or general steel structures. For structures exposed to outdoor, urethane topcoat is recommended to use.
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Physical Properties

Finish and Color	Flat. Grey, etc
Specific gravity	Approx. 1.4 ~ 1.7 for Mixture of Base and Curing agent.
Solids by volume	Approx. 80%(Determined by ISO3233)
Spreading rate (Theoretical)	5.33 m ² /L in 150 μm dry film thickness on a smooth surface.
Flash point	Base (EH6280(HS)-A) : 23 °C / 73 °F (Closed cup) Curing Agent (EH6280(HS)-B) : 27 °C / 81 °F (Closed cup)
Volatile Organic Compounds(VOC)	Korea Clean Air Conservation Act (including maximum dilution ratio) : 336 g/L (Determined by KS M ISO 3251)

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.
Preceding coat	Galvany IZ180N or according to specification. When apply over inorganic zinc, a mist coat is required to reduce the bubbling. * Method of Mist Coat 1) The Mist Coat proceed to less than 30% thinning ratio and need to proceed by minimized overlap ratio. Also when proceed main coat, preferentially confirm the appearance. 2) In the case of the bubble phenomenon(Popping phenomenon) that occurs during the subsequent coating of inorganic zinc, may vary depending on the painting conditions and the site conditions. Please contact TSD and the technical department when checking the problem.
Method of application	Spray (Airless or Air), Roller or Brush application. For airless spray application ; Nozzle orifice : 432 μm ~ 635 μm (0.017" ~ 0.025") 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) = 9.4 : 5.6 (by volume) Mix thoroughly together prior to application in the proportions with power agitator as delivered.
Thinning	Thinner No. 024 Do not dilute components separately, only the mixture.
Application	Apply only where application and curing can proceed at temperatures above 5 °C/41°F. The surface

conditions	should be completely cleaned and dried. Do not apply when relative humidity is above 85 %. The surface temperatures 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	150 μm dry. May be specified in another film thickness than indicated depending on purpose and area of use.																													
Drying time	<table><tr><td>Substrate temperature</td><td>5°C/41°F</td><td>10°C/50°F</td><td>20°C/68°F</td><td>30°C/86°F</td></tr><tr><td>Set to touch</td><td>24 h</td><td>18 h</td><td>12 h</td><td>8 h</td></tr><tr><td>Dry through</td><td>36 h</td><td>24 h</td><td>18 h</td><td>12 h</td></tr><tr><td>Recoating Interval (Min)</td><td>36 h</td><td>24 h</td><td>18 h</td><td>12 h</td></tr><tr><td>Recoating Interval (Max)</td><td>30 days</td><td>30 days</td><td>30 days</td><td>30 days</td></tr></table> * 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. * Before overcoating, remove the oil, salt, chalking material and any other contaminants on aged coating film completely by proper cleaning method such as solvent cleaning and / or fresh water washing. * In case of EH6280(HS) product, we are operating the EH6280(HS)–B(W) of winter curing agent during between November to March per years.					Substrate temperature	5°C/41°F	10°C/50°F	20°C/68°F	30°C/86°F	Set to touch	24 h	18 h	12 h	8 h	Dry through	36 h	24 h	18 h	12 h	Recoating Interval (Min)	36 h	24 h	18 h	12 h	Recoating Interval (Max)	30 days	30 days	30 days	30 days
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Subsequent Coat	Korethan Topcoat UT6581 or according to specification.																													
Pot life	4h at 20°C / 68°F																													
Heat resistance temperature	Continuous : 120°C/248 °F (Non-immersion service) Non-continuous : 140 °C/284 °F (Non-immersion service) – Peak temperature duration max. 1hour. – The temperatures listed relate to retention of protective properties. – Long-term exposure to these temperatures can cause aesthetic properties may suffer.																													
Storage and package																														
Shelf life	12 months (77°F / 25°C)																													
Storage	Do avoid humidity and direct light																													
Packing Unit	15 L (EH6280(HS)–A : 9.4 L, EH6280(HS)–B : 5.6 L)																													
Remarks																														
Handling Precautions	* 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 during application in confined spaces or stagnant air. * Note that the storage period may be changed when exposed to high temperature.																													
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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.

