Korepox EH3400 (Two-Component)

Product Description	A two-component, epoxy resin based coating with excellent anti-corrosion property. It cures to a strong and highly rust preventive coat. Also Korepox EH3400 is suitable for ESS containers and is a coating with excellent adhesion and workability.
Packing	Korepox EH3400 is supplied as two separate packages. - Base (Part A) and Curing agent (Part B) in the correct proportion for the mixture. Do not open package until use. Each package (Base and Curing agent) must be used entirely for mixing to ensure the mixing ratio. Left-over material in the packages cannot be used.
Recommended Use	As a general purpose primer or intermediate coating on all types of steel structures in moderately corrosive environments.

Physical Properties

Finish and Color	1128(French grey), custom colors available
Solids by Volume	Approx. 74% (Determined by ISO 3233)
VOC	260g/L
Specific Gravity	Approx. 1.4~1.6 for Mixture of Base and Curing agent.
Flash Point	Base (EH3400PTA) : 26°C / 79°F (Closed cup) Curing Agent (EH3400PTB) : 26°C / 79°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. - Blast cleaning to Sa2½ or power tool cleaning to St3, etc. - Profile requirements : 30 ~ 75 ㎛ in case of full or partial blast cleaning.
Application Condition	The surface should be adequately clean and dry. Do not apply when relative humidity is above 85 %. The surface temperature should be at least 3°C / 5°F above dew point to prevent condensation. Temperature during application and curing is preferable from -18°C / 0°F to 49°C / 120°F. This temperature condition is for the substrate and surrounding air.
Mixing	EH3400PTA (Part A, Base) : EH3400PTB (Part B, Curing agent) = 4 : 1 (by volume) - Mix with supplied mixing ratio only. Do not vary or subdivide. - Before mixing, shake or stir the Base very thoroughly. - Pour the curing agent into the Base with constant mechanical stirring. Do not mix in reverse order. Continuous stirring until mixture is free of lumps

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Application

Spray : Airless or Air spray
Brush and Roller : Recommended for small area and stripe coating for specified edges, welds, hard to reach areas, etc.
For airless spray application ;
Nozzle orifice : 482 ㎛ ~ 787 ㎛ (0.019″ ~ 0.031″)
Fan : 40˚ ~ 60˚
Output pressure : 11.7 MPa ~ 15.2 MPa
Airless Pump Ratio : 45 : 1 ~ 73 : 1
(Airless spray data are indicative and subject to adjustment)

Recommended Coating System

■ For ESS container
1st Coat : Korepox Zinc primer EZ175(C) (50~75㎛ DFT)
2nd Coat : Korepox EH3400 (90~200㎛ DFT)
3rd Coat : Korethan Top coat UT6581 (50~70㎛ DFT)

-. Depending on the purpose and the area of use, different film thickness may be applied.

Thinning

Product Name : Thinner No. 024 or Other thinner approved by KCC
Thinning Ratio : up to 10% (by volume)
* Do not dilute each component separately

Typical Film Thickness

(Per Coat)	Typical	Minimum	Maximum
Dry Film Thickness (㎛)	150	90	200
Wet Film Thickness (㎛)	203	122	270
Theoretical Spreading Rate (㎡/L)	4.9	8.2	3.7

* For more detailed information, consult with TSD (Technical Service Department) in KCC)

Drying Time & Recoating Interval

Substrate temperature	5°C / 41°F	10°C / 50°F	23°C / 73.4°F	40°C / 104°F
Dry to touch	4 h	2 h	1 h	30 min
Dry to walk on	10 h	6 h	3 h	2 h
Dry to over coat, minimun	8 h	4 h	2 h	1 h
Dried/cured for service	13 d	8 d	4 d	3 d

* d : days, h : hours.
* These are the results from laboratory tests done under standardized conditions. Thus, actual times may be different due to environment situations such as weather, wind and humidity, etc.

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Ventilation	Adequate ventilation with clean air should be maintained during application and curing to assist solvent evaporation.
Cleaner	Thinner No. 024
Pot Life	3 h at 20°C / 68°F Pot life may be shorter under higher temperature and humid conditions.
Preceding Coat	According to specification.
Shelf Life	EH3400PTA (Part A, Base) : 12 months EH3400PTB (Part B, Curing agent) : 24 months
Standard Packing Unit	15 L (EH3400PTA : 12 L, EH3400PTB : 3 L)
Safety 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 when applying this product in confined spaces or stagnant air.
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