Quick application guide

Resichem 530 HA100

Single component solvent free epoxy novolac
Activated at temperatures above 100°C
Surface tolerant

Cure Times

Touch dry
100°C 50 minutes
150°C 3 minutes
200°C 20-30 seconds
240˚C 10-15 seconds

Maximum overcoating time
100°C 3 hours
150°C 1 hours
200°C 15 minutes
240˚C 7 minutes

Fully cured
100°C 24 hours
150°C 4 hours
200°C 30 minutes
240˚C 15 minutes

Coverage Rates

4ltrs (1.1 US gallon) of product will give the following coverage rates –
10m² at 400 microns
108ft² at 16mil

Typical applications

Suitable for coating the following surfaces -
Hot process pipes
External tank and process equipment surfaces
Field joints
External pipeline surfaces
Corrosion under insulation protection

Colour

Single Component-
Red

Technical specifications and characteristics

Mixing ratio	Single component
Density	1.40

Surface Preparation

Surfaces operating at 100˚C to 240˚C

Metallic Substrates – Mechanical abrasion

1. All surfaces must be mechanically abraded using handheld grinders to ***ISO 8501/4 ST3 (SSPC SP3 ST3)***.

Metallic Substrates – Hydro-blasting

1. All surfaces must be hydro-blasted using clean water at 12,000 psi (850bar) to ***NACE 5 (SSPC SP13 WJ3-WJ1)***.

Metallic Substrates – Abrasive blast cleaning

1. All surfaces must be abrasive blasted to ***ISO 8501/4 Standard SA2.5 (SSPC SP10/ NACE 2)*** minimum blast profile of 75 microns (3mil) using an angular abrasive.

The coating can be applied to cold surfaces, however after application the coated surface must be heated to 100˚C+ in order for the coating to cure. Heat must be applied until the coating has cured hard, please see the cure times overleaf. If applying to cold surfaces the following procedures must be followed.

1. All oil and grease must be removed from the surface using an appropriate cleaner such as MEK.
2. All surfaces must be mechanically abraded, hydro-blasted or abrasive blast cleaned to the appropriate standard.
3. Once abraded, the surface must be degreased and cleaned using MEK or similar type material.
4. All surfaces must be coated before gingering or oxidation occurs.

Mixing and Application

530 HA100 is a single Component solvent free epoxy Novolac coating. Prior to Application ensure the product Is heated to 40°C.
DO NOT OVERHEAT

Brush & Roller application

Apply the coating to the Prepared surface at a minimum Wet film thickness of 400 micron (16mil).

Dependent on the surface Temperature, apply a 2nd coat Of material at 400 microns WFT As soon as the 1st coat has Cured sufficiently hard enough. (Please see the cure time guide)

Spray application

Recommended spray set up-

- 60:1 minimum ratio pump.
- 19-23 Thou tip
- 3500+ psi spray pressure
- Pre-heat the product to 40°C

Apply the coating to the Prepared surface at a minimum Wet film thickness of 400 micron (16mil).

Dependent on the surface Temperature, apply a 2nd coat Of material at 400 microns WFT As soon as the 1st coat has Cured sufficiently hard enough. (Please see the cure time guide)

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