

**FEATURES**
**Excellent water immersion resistance**

- Primer and Intermediate coating, contains Zinc Phosphate.

**Excellent chemical resistance**

- Alkali, dilute acids, sewage

**Durable hi build film properties**

- Abrasion resistant
- Good aged flexibility
- Cures down to 5 ° C
- Fast dry-to-recoat

**Excellent package stability**

- Good Cure response
- Self priming
- Only RedBrown and buff colors.

**RECOMMENDED USES**

Navipox 402, is high performance, versatile coating which can be used in high performance coating systems.

**Water Immersion**

- Ships, barges, docks, offshore structures
- Pipes, concrete structures, flumes

**Chemical resistance**

- Sewage and waste plants
- Fertilizer plants
- Phenolic modified polyamide cure
- Refineries

**Chemical Resistance**

- Impress current systems
- Underground pipes

**SPECIFICATION DATA**

|                                  |                                                                                                            |
|----------------------------------|------------------------------------------------------------------------------------------------------------|
| Coating Type                     | : Advance technology Epoxy                                                                                 |
| Color                            | : Red-Brown 221-K-7821, Desert Sand<br>223-K-1046, Light Gray 2301                                         |
| Density ( at 20°C )              | : 1,45±0,1 Kg/Lt.                                                                                          |
| Packaging Mixing ratio by volume | : Base 12,5 Lt. (20 Kg.)/ Hardener 3,70 Lt.(4 Kg.) ( Two Component.)                                       |
| Gloss                            | : Semi-Gloss-Matt                                                                                          |
| Pot Life ( at 25°C )             | : 6-7 Hours.                                                                                               |
| Flash Point                      | : 27° C. Setaflash mixed                                                                                   |
| Thinner                          | : T-10 Thinner                                                                                             |
| Shelf life                       | : More than 1 year , Keep it in dry cool area.                                                             |
| Temp resistance                  | : 121 °C Dry.                                                                                              |
| VOC                              | : 252 gr/Lt.                                                                                               |
| Volume Solid                     | : % 65 +-2 ASTM D2697 ( 7Days)                                                                             |
| Theoretical spreading rate       | : 4,33 m²/Lt/150 mic.DFT 230 mic. WFT<br>3,25 m²/Lt/200 mic. DFT 310 mic WFT Allow for Application losses. |
| Application                      | : Air spray, Airless spray                                                                                 |
| Drying time                      | : 20 °C , %50 RH de. 50 mic. DFT.<br>Recoatable 6 Hours to handle 8 Hours<br>Immersion Service 7 Days.     |

## Application Properties

### Surface preparation

All direct to metal coatings provide the maximum performance over near white blasted surfaces. There are, however, situations and cost limitations, where grit blasting to near white metal is not possible. **Navipox 402** were designed to provide excellent protection over less than ideal surface preparation. Recommended surface preparation for **Navipox 402** is to include removal of water, salt, dirt, oil, loose rust and all rust scale. For maximum performance treat all surfaces with water dispersible industrial oil remover cleaner ( **Naviprep 88**) followed by high pressure fresh water wash (200 bar). Minimum standard for non-immersion service is Steel Structures Painting Council Standard SSPC-SP-2 or Swedish standard DSt-2; for immersion service, the minimum standard is SSPC-SP-3 or Swedish standard DSt-3. Where very rusty surfaces still remain after cleaning for non-immersion service, use **NaviPreprime 177** sealer before application of **Navipox 402** coating. Most Epoxies have an aged recoat ability limitations. Contact SAFİR EPOKSi representative for recommendation.

### Priming, mixing, thinning

This product supplied in two parts in two different containers with their proper mixing ratio . Add the entire contents converter to the base portion. Power mix the base portion first to obtain a smooth, homogenous condition. After mixing the base portion, add the converter slowly with continued agitation. After the converter addition is complete, rinse the container with small amount proper T-10 thinner and add this rinsing solution into the mix, then continue mixing slowly. Thinning is not normally required or desired, however, at extreme environmental conditions, small amounts ( %5 or less by volume) of the solvents on the reverse page can be added depending on local VOC and air quality regulations. Any solvent addition should be made after the two components are thoroughly mixed. The pot life of mixed material is 6 hours at 25 °C. Higher temperatures will reduce working life of the coating, lower temperatures will increase it.

### Application

**Navipox 402** can be applied by both conventional air spray and airless spray equipment.

For air spray application, use a Graco 800 gun with fluid tip of 0.07" or larger, and air cap with good break-up qualities. Fluid pressure should be kept low, about 1 Bar ( 15 PSI) with just enough air pressure to get good break-up of coating. Excessive air pressure can cause overspray problems.

Where airless spray equipment is used, - Graco 30/1 Bulldog or 35/1 Senator or larger pump is recommended .

- Recommended tip size is A 0.021 "-0.025" and provide good spray pattern. Liquid pressure on tip is about 180-250 Kg/cm<sup>2</sup>.

- For optimum results fluid hoses should be 3/8" ID or larger with a maximum length of 15 m. except short whip end before the gun. Longer hose length or cold temperatures may require an increase in pump ratio and/or thinning.

**Navipox 402** may also be applied by brush or roller. Care should be taken that proper and uniform thicknesses are obtained. Antifouling paints should be applied over **Navipox 402**, when the **Navipox 402** becomes tack free but still soft to finger pressure. Epoxy paints may change color and chalk when exposed to direct sunlight.

Tank coating system: 2 F/C of 100-200 mic DFT per coat plus 2 Stripe coats over sharp edges, cut-outs and welds. Use contrasting colors for each coat and stripe coat.

#### Ventilation

It is very important for the safety of the applicator and the proper performance of the **NAVIPOX 402** coating that good ventilation be provided to all portions of the enclosed area. It is equally important to bring into the enclosed area dry, fresh air to remove all solvent vapors. Since all solvent vapors are heavier than air, ventilation ducts should reach to the lowest portion of the enclosed areas as well as into any structural pockets. Ventilation should be provided throughout the cure period to insure all the solvents are removed from the coating. For potable water tanks, it is essential that full ventilation be maintained for seven days.

### Precaution

Refer to material safety data sheet of the Product. Additional safety information is available up on request. Minimum safety precautions in dealing with the paints are;

- Take precaution to avoid skin and eye contact (i.e. gloves, goggles, face mask, barrier creams, etc.)
- Provide adequate ventilation
- If the products come in contact with the skin, wash thoroughly with lukewarm water and soap or suitable industrial cleaner. If the eyes are contaminated flush with water (minimum 10 minutes) and obtain medical attention at once.
- Since these products contain flammable materials, keep away from sparks and open flames. No smoking should be permitted in the area.
- Observe all precautionary notices on containers.

Xn: Harmful for human health F : Flammable. Warning signs: R11, R20/21/22, R36/38

Safety signs: S2, S3/7/9, S16, S20/21, S24/25, S38

### Note

To the best of our knowledge, the information contained herein is accurate. However, **SAFİR** Epoxy paint company, assumes no liability whatsoever for the accuracy or completeness of the information contained herein. Final determination of the suitability of any information or material for the use contemplated, the manner of use and weather there is any infringement of patents is sole responsibility of the user. Additional information may be obtained through your local sales representative, or the **Navimare-px**.

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