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TECHNICAL INFORMATION SHEET

285 S. T. EPOXY

Surface Tolerant High Build Epoxy

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Description and uses:

285 S.T. Epoxy is an epoxy polyamine primer / topcoat with the following features:

- Requires minimum surface preparation.
- Good surface wetting and anticorrosive properties.
- Can be applied over most aged coatings
- Can be top-coated with a number of industrial coatings
- Good solvent and chemical resistance
- High solids

Typical areas of application are:

- Structural steel and sheet metal used in the construction, transportation, industrial and mining industries.
- Concrete floors, factory, showroom and workshop walls etc.

Note: Some chalking, yellowing and bleaching will occur with exterior exposure and contact with various chemicals i.e. (acids, alkalis and hydrocarbons), if not topcoated. This will not detract from the protective / performance properties of this product.

Technical Specifications:

FINISH: Satin to Semi gloss depending on film thickness.
MIXING RATIO: Part A / Part B 3/1 (Volume).
THINNERS: T180 Epoxy Thinner
POT LIFE: 2 hours @ 25°C.
VOLUME SOLIDS: 80% (White) when mixed.
COVERAGE: 5.0 Square metres per litre.
RECOMMENDED FILM THICKNESS: 200 microns wet / 160 microns dry.
APPLICATION: Brush, Roller and Spray.

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Technical Specifications:

Cure: (25°C & 50% Humidity) at 160 micron DFT.

Touch
5 Hours

Handle
16 Hours

Full Cure
7 Days

Recoat: (25°C & 50% Humidity).

Enamel
Min 16 Hours
Max 36 Hours

2 Pack (A & B)
16 Hours
5 Days

Itself
16 Hours
28 Days

The above recoat times are a guide only as factors such as thinners used, film thickness, ventilation, substrate temperature etc need to be taken into account. Ensure 285 ST Epoxy is free of contaminants before overcoating, clean with T192 (Wax & Grease Remover).

Overcoating after the suggested maximum time could reduce intercoat adhesion between coats. Abrade and clean 285 ST Epoxy surface with T192 (Wax & Grease Remover) before overcoating.

APPLICATION DETAILS – PAINTING SYSTEMS

D.F.T. um			
System 1	1 st Coat	120 - 160	285 ST Epoxy (Thinner T180)
	2 nd Coat	120 - 160	285 ST Epoxy (Thinner T180)
	3 rd Coat		Optional

D.F.T. um			
System 2	1 st Coat	120 - 160	285 ST Epoxy (Thinner T180)
	2 nd Coat	50-75	540, 720 Two-pack topcoat (Thinner T154 or slow T156 or T159)
	3 rd Coat		Optional

D.F.T. um			
System 3	1 st Coat	50-100	605 Zinc Rich Primer (Thinner T180)
	2 nd Coat	120 - 160	285 ST Epoxy (Thinner T180)
	3 rd Coat	50-75	540, 720 Two-pack topcoat (Thinner T154 or slow T156 or T159)

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APPLICATION DETAILS – SURFACE PREPARATION		
SUBSTRATE	DETAILS	RECOMMENDED SYSTEM
Steel	Power tool clean to AS1627.2 class 2 Or abrasive blast clean to AS1627.4 Class 2.5 or treat with 212 Metal Clean	1, 2 or 3
Aluminum, Galvanized Steel or Zinc Anneal	Light abrasive blast or treat with 212 Metal Clean	1 or 2
Concrete and Masonry	New concrete must be fully cured. Light abrasive blast or acid etch Thin first coat 30% with T180	1 or 2
Previously Painted Surfaces	Lightly sand glossy areas, wash down with cleaning solvent	1 or 2

Surface Preparation:

- When overcoating; Aged paint coatings should be tested for adhesion using Crosshatch or Crosscut methods. If aged paint coating lifts remove it.
- Remove all rust, oxides, millscale and loose paint from metal surface.
- Round off all sharp edges, welding joints and weld spatter.
- All surfaces to be painted should be clean and free from dust, dirt, oil, grease and moisture.
- All abrasive blast clean ferrous surfaces should be coated within 4 hours to avoid flash rusting.
- Do not apply at temperatures below 10° Celsius. Do not apply at relative humidity above 85%, or when the substrate surface is less than 3° Celsius above dewpoint.
- Applied 285 ST Epoxy coat subjected to exterior exposure for extended period of time should be accessed for “Chalking” before applying suitable topcoat to achieve optimum intercoat adhesion.

Application:

For use by experienced industrial applicators. For best results mechanical mixing of Part A (base) and Part B (hardener) is recommended.

Mix 285 Part A, 3 parts with 1 Part 285 part B. Allow to stand for 10 minutes, and then stir again before using.

Brush or Roller – Thinning not normally required.

Conventional Spray – Thin approximately 5-10% and apply 2 coats wet on wet.

Airless Spray - Thinning not normally required.

Clean Up – T180 or T134 All Purpose Thinner.

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Equipment Application:

Brush or Roller – Apply evenly over prepared surface, more than one coat may required to achieve desired film thickness.

Conventional Spray – 1.8 -2.8 mm tip (or equivalent). Pressure pot set at 55 -100kpa (8 -15psi) and maintain gun air pressure 275 - 385kpa (40 -55psi).

Airless Spray – Use heavy-duty airless spray with 17 - 21” (0.43 - 0.53mm) plus tip and pump ratio 45:1.

Safety Instructions:

Storage: Store in a cool, dry bunded area out of direct sunlight as required for Flammable liquids DG Class 3, PG II, Hazchem 3(Y)E.

Flammability: Highly flammable, all sources of ignition must be eliminated in or near area of use, on burning fumes emitted are toxic. Do not smoke in immediate area.

Handling: Adopt adequate Occupational Work Practices to avoid personal contamination with product. Always wash hands before smoking, eating, drinking or using toilet. Food and Drink should be to stored and consumed in separate area.

Personal Protection: Avoid contact with skin or eyes; wear suitable clothing such as impervious overalls, PVC or neoprene gloves, safety goggles and face mask.

Using: Avoid inhalation of spray mist and vapours – use with adequate ventilation and suitable Personal Protection Equipment (PPE).

Engineering controls: Ensure ventilation is adequate. When spraying, ensure product is applied in a fully functional spray-booth. Keep containers closed when not in use. Do not use near ignition sources.

REFER MSDS BEFORE USE

(Phone 02 9688 1999 or refer to www.lacnam.com.au for copy MSDS)

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