

# MEP 6020

## Intermediate Epoxy Polyamide

MAHLA MEP6020 is a two-component, polyamide cured epoxy resin based 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.

### Physical Data

Finish .....	Semi gloss
Color .....	Light gray
Substrate .....	Primed steel
Components .....	2
Solid Weight .....	80±2
Volume Solids .....	60±2%
DFT .....	100/coat
WFT .....	180µ
TSR .....	10.4m <sup>2</sup> /lit/50µ
Pot life (at 25°c) .....	8 hours

Specific Gravity.....	1.55±0.05 kg/lit
Viscosity (at 25°c)...	80-90 KU (mixed product)
Thinner .....	MS605
Shelf life .....	9 month

### Drying times (at25°c)

Surface dry .....	Max.2 hours
Thorough dry .....	Min. 16 hours
Full cure .....	7 Days

### Mixing Ratio (by w)

Base .....	7 part
Cure .....	1 part

Note : This product also can be supplied in other colors.

### APPLICATION DETAILS

- a. Surface Preparation: Remove any oil and grease from the surface to be coated.  
(When used as intermediate coating)

b. Application Condition : The surface must be completely clean and dry and its temperature must be at least 3.5c above the dew point and the relative humidity below 85% (preferably 40- 60%), In confined spaces, circulate an adequate supply of fresh air during application and drying to assist solvent evaporation.

Air temp ..... 10-50°c

Surface temp..... 10-60°c

c. Mixing: PTA (Base) : PTB (Curing Agent) = 4:1(by volume).

Mix separately, then combine and mix thoroughly together prior to application in proportions as delivered.

d. Method of Application: Spray (air or airless) application.

For airless spray application:

Nozzle orifice: 0.017 inch, 0.021 inch

Output pressure: 2.20 psi / 150atm

Thinning: Max 20 %( by volume)

\* Brush or roller : Use a medium bristle brush with full strokes for small areas or touch-up only.

\* Clean tools thoroughly before and immediately after use with MAHLA TOOL CLEANER or THINNER MS603.

e. Film Thickness: Recommended per coat 100 microns dry.

May be specified in another film thickness then indicated depending on purpose and area of use.

f. Recoating Interval : At 20°c , Minimum : 18 hours (itself)

Maximum : 30 days (itself)

Before over coating, clean surfaces thoroughly to remove the all of contamination by high pressure fresh water hosing and allow to dry.

g. Subsequent Coat : Urethane topcoat or according to specification.

h. Heat Resistance: Continuous: 83 °c

Non – Continuous: 117 °c

i. Remarks: Protect skin and eyes, and avoid prolonged breathing of solvent vapors.

Use with adequate ventilation.

Respiratory protection is recommended when applying this material in confined spaces or stagnant air.

### **Application procedure**

1. Flush equipment with recommended cleaner.
2. Stir base to an even consistency with a power mixer.
3. Add cure to base & continue Stirring up to uniformity. Induction time before use is 10 min.

Note: since the pot life is limited & shortened by high temperatures, do not mix more material than

will be used.

4. For conventional spray thin only as needed for workability.
5. Stir during application to maintain uniformity of material.
6. Apply 100 $\mu$  of the wet film thickness to reach 50 $\mu$  dry film thickness.