

# TECHNICAL DATA

## PRODUCT: OASIS 8884 SOLVENT FREE EPOXY PRIMER/BUILD COAT

Description	:	OASIS 8884 SOLVENT FREE EPOXY PRIMER/BUILD COAT.	
Material Type	:	Solvent free polyamide cured two pack epoxy coating.	
Recommended Use	:	Corrosion Protection of carbon steel surfaces prepared by abrasive blast cleaning. Can be applied between 250-500µm dry film thickness, to provide both primer and buildcoat in a single application. To prevent loss of colour and gloss, a UV light stable finish coat may be applied. Particularly suitable where a high degree of abrasion resistance is required. May be applied through standard single leg airless spray equipment.	
Volume Solids (%)	:	100% (ASTM-D2697-91)	
Flash Point	:	Base: Above 55°C	Additive : Above 55°C
Specific Gravity (Kg/Ltr)	:	1.63 (Mixed) may vary with shade.	
V.O.C.	:	None	
Colours	:	Limited range	
Pack Size	:	20 Litre and 5 Litre units when mixed.	
Shelf Life	:	Minimum 2 years	
Mixing Ratio	:	4 parts base to 1 part additive by volume	
Theoretical Spread Rate (m <sup>2</sup> /Ltr)	:	<b>3.30 m<sup>2</sup>/Litre</b>	
		<b>Airless Spray</b>	<b>Brush</b>
@ Dry Film Thickness	:	300 µm	300 µm
@ Wet Film Thickness	:	300 µm	300 µm
		<i>Spreading rates are calculated and due allowance for loss and wastage should be made.</i>	
Drying Time @ temperature	:	<b>23°C</b>	<b>35°C</b>
To Touch	:	<b>8 hours</b>	<b>4 Hours</b>
To Overcoat (Minimum)	:	<b>12 hours</b>	<b>3 hours</b>
To Handle	:	<b>16 hours</b>	<b>10 hours</b>
		These figures are given as a guide only. Factors such as air movement and humidity must also be considered.	
Cleanser or Thinner	:	Oasis Thinner No: 5 may be used for cleaning equipment only.	
Pot Life	:	<b>23°C</b> <b>35 minutes</b>	<b>30°C</b> <b>20 minutes</b>
			<b>35°C</b> <b>15 minutes</b>
Resistance To	:	Moisture – <b>Excellent</b> Abrasion – <b>Excellent</b>	Weather - <b>Excellent</b> (Subject to chalking). Petroleum Solvents - <b>Excellent</b>
Recommended Top Coats	:	Not normally required, However, where high degrees of gloss and colour retention are required called for AGP Technical Centre. To achieved optimum adhesion, overcoating should be undertaken within 7 days at 23°C or within 4 days at 35°C.	
Application Methods	:	Airless spray, Brush ( for Small areas and touch up only.	

## SAFETY, HEALTH & ENVIRONMENTAL INFORMATION (READ THIS SECTION BEFORE USE) SOLVENT BASED PAINT PRODUCT

- Flammable. Keep away from sources of ignition. Do not smoke.
- Work only in areas of good ventilation. When used indoors always keep doors and windows fully open during application and drying. When applying for short periods only, a suitable cartridge mask may be worn provided the filter is changed regularly. All respiratory equipment must be suitable for the purpose and meet an appropriate standard approved by the HSE. Refer to your COSSH Assessment.
- When applying paint it is advisable to wear suitable eye protection. In case of contact with eyes, rinse immediately with plenty of water and seek medical advice.  
Remove splashes from skin : use soap and water or a recognised skin cleaner.
- Keep container tightly closed and keep out of reach of children. Do not use or store by hanging on a hook. Do not empty into wadis, drains or watercourses.
- Contains no added mercury.  
\*This data is subject to change without notice. Please ensure you have the latest copy by checking with our Customer Service Department.

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# APPLICATION DATA

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## SURFACE PREPARATION

For better performance we recommend blast clean to Sa 2½ BS 7079: Part A1: 1989 (ISO 8501-1: 1988). Average surface profile in the range 50 - 75µm. At the time of coating ensure surfaces to be coated are dry and free from all traces of surface contaminants.

## APPLICATION EQUIPMENT

### Airless Spray

Nozzle Size	0.33 -0.38mm (15 thou)
Fan Angle	40°
Operating Pressure	155kg/cm² (3000psi)

The airless spray details given above are intended as a guide only. Fluid hose length and diameter, paint temperature and project complexity all have an effect on the choice of spray tip and operating pressure. The operating pressure should be the lowest possible consistent with satisfactory atomisation. As conditions vary, it is the applicators' responsibility to ensure that the equipment in use has been adjusted to give optimum performance. In case of any difficulties or queries, please contact Al Gurg Paints L.L.C.

### Brush

The material is suitable for brush application to small areas only. Application of more than one coat may be required to give the equivalent dry film thickness to one spray applied coat.

## APPLICATION CONDITIONS AND OVERCOATING:

In conditions of high relative humidity, i.e. 80-85% good ventilation is essential. Substrate temperature should be at least 3°C above the dew point. At application temperatures below 10°C, drying times will be significantly extended and spraying characteristics may be impaired. Application at temperatures below 5°C is not recommended. In order to achieve optimum water and chemical resistance the temperature needs to be maintained above 10°C whilst curing. For application at elevated temperatures, please see the note below.

## ADDITIONAL NOTES

Drying, curing times should be considered as a guide only. For spraying maximum 5 to 10% dilution is recommended.

The curing reaction of epoxies commences immediately the two components are mixed. Due to the reaction being temperature dependant, the curing and potlife will be approximately halved by a 10°C increase in temperature and doubled by a 10°C decrease in temperature.

### Epoxy Coatings – Colour Stability:

Variable colour stability is a feature of all epoxy materials, which tend to yellow and darken with age particularly when used on internal areas. Owing to this colour change, areas subsequently touched up may be obvious.

When epoxy material are exposed to ultraviolet light, a surface chalking effect will develop. The phenomenon results in the formation of fine powder coating at the coating surface, which gives rise to a colour variation as well as a reduced gloss.

This effect is cosmetic only and in no way detracts from the performance of the product. Or Specification.

Should a full colour stable finish be required, Please follow recommendation in the recommended topcoat section.

### Epoxy Coatings - Tropical Use

To ensure a satisfactory working pot life, the temperature of Oasis 8884 Solvent Free Epoxy should not exceed 35°C at the time of mixing. Thinning the mixed product at any stage will not significantly extend the working pot life. Application outside the working pot life, even if the material appears to be fit for use, may result in inferior adhesion properties. The recommended maximum air and substrate temperature for the application of epoxies is 45°C, providing that the conditions allow for satisfactory application and film formation. If the air and substrate temperatures exceed 45°C during application, paint film defects such as dry spray, bubbling and pinholing etc. may occur.

Numerical values quoted for physical data may vary slightly on individual batches.

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further information please contact –

**AL GURG PAINTS L.L.C**

Head Office & Factory – P.O. Box 22334,  
Sharjah, U.A.E

Tel : (+971)6-5343919 Fax : (+971)6 343983

E-mail : [enquiries@agp.ae](mailto:enquiries@agp.ae)

Web : [www.aglpuae.com](http://www.aglpuae.com)