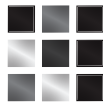


EP-GUARD™ 1600 series

**FAST DRY / HIGH BUILD
EPOXY PRIMER**



PRODUCT FEATURES

- Excellent adhesion, hardness and abrasion resistance
- High build capabilities
- Low V.O.C.
- Easy to apply with any traditional painting equipment
- Excellent intercoat adhesion with subsequent coatings
- Very good recoatability (up to 30 days)
- For increased performance and protection topcoat with Glass Shield polyurethanes.



Suggested Use

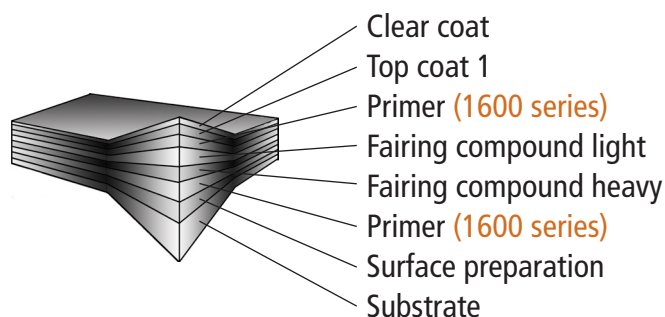
- Steel structures or equipment (various types)
- Aluminum (vinyl wash primer or AGA 2000 required)
- Wood
- Fiberglass
- Concrete

Technical Data

Coating type	Polyamide epoxy Two component
Colour	White (1653) / Grey (1652) / Black (1659) Other colors available upon request
Packaging	3.78 L (1 US Gallon) 15.12 L (4 US Gallon)
Mixing Ratio	4 : 1 per volume
Gloss	Semi gloss
Flashpoint	-4° C (25° F)
Induction time	20 minutes
Thinner	GS 162-11S
Pot life	8 hours
Shelf life	2 years

Temperature resistance	100° C (212° F) in service
Solids (ASTM D1644)	
By weight	76 +/- 2% (depending on colour)
By volume	64 +/- 2% (depending on colour)
Theoretical spreading rate	24 sq.m / lat 25 microns dry
	1021 sq.ft. / US gal at 1 mil
Recommended film thickness	75-100 microns dry (3.0 - 4.0 dry mils) (min. 1.5, max. 5.0 mils)
Application methods	Spray, brush or roller

Typical Sequence (First class finish)



In doubt? Contact technical services at 1-800-361-6652 for proper guidance in preparing substrate

Surface Preparation

All coatings systems provide the maximum performance over adequately prepared surfaces. There are, however, structures where it is not possible to obtain an ideal surface condition. The surface preparation recommended for EP-GUARD™ 1600 series is to include removal of all oil, grease, dirt, dust, mill scale, rust, paint, oxide, corrosion product and other foreign matters. This can be accomplished with hydroblasting, grit sweeping and with a variety of mechanical descaling tools. The minimum standard for steel is Steel Structures Painting Council Standard SSPC-SP-2 or SSPC-SP-3. The recommended surface preparation is SSPC-SP-6. For aluminum, proper etching of substrate and application of a vinyl wash primer is required before applying EP-GUARD™ 1600.

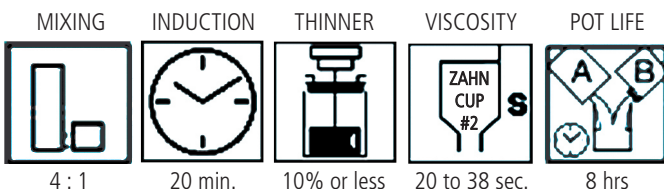
Mixing and Thinning

EP-GUARD™ 1600, is a two component product supplied in a 5 US gallons or 1 US gallon containers which contain the proper ratio of ingredients. The entire contents of each container must be mixed together. Power mix the base portion first to obtain a smooth, homogeneous product.

After mixing the base portion for 5 to 10 minutes, add component "B" (clear catalyst GS 161-49C) slowly with continued agitation. After the component B add is complete, continue to mix slowly until homogeneous. Allow a 20 minutes induction time before using.

Thinning is not normally required or desired; however, at lower temperatures, small amounts (10% or less) of Glass Shield GS 162-11S thinner can be added depending on local VOC and air quality regulations. Any solvent addition should be made after the induction time.

The pot life of the mixed material is 8 hours at 77°F (25°C). Higher temperatures will reduce the pot life of the product; lower temperatures will increase it.



Application Conditions

Industry standards are for the substrate temperatures to be above 10° C of the dew point. Condensation due to substrate temperatures below the dew point can cause flash rusting on prepared steel and interfere with proper adhesion to the substrate.

Special application techniques may be required above or below normal application conditions.

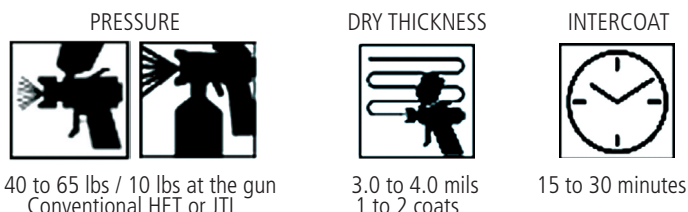
Condition	Material	Surface	Ambient	Humidity
Normal	60 - 85° F (16 - 29° C)	60 - 85° F (16 - 29° C)	60 - 90° F (16 - 32° C)	0 - 65%
Minimum	50° F (10° C)	50° F (10° C)	50° F (10° C)	0%
Maximum	90° F (32° C)	100° F (35.5° C)	100° F (35.5° C)	85%

Application

EP-GUARD™ 1600 can be applied by brush, roller or spray methods. The preferred method of application is with heavy duty airless spray. De Vilbiss or equivalent equipment should be used.

For HVLP applications, please consult and follow with equipment supplier's instructions

Air spray should be: MBC-510 or JGA gun, 704 or 765 air cap and "E" or "EX" tip and needle. For airless application a tip with 0.013" (0.330 mm) to 0.017" (0.431 mm) orifice, 1,500 psi constant pressure at tip.



Airless & Air Spray

Manufacturer	Graco	Devilbiss	SATA
Pump	30 : 1	HET	K3 RP
Fluid hose	3/8" x 100' max	1.1 ff	1.1
Tip size	311, 413, 515, 517	#410 / 414	
PSI	3500 PSI min.	3/8"	3/8"
Pressure pot	15 - 25 psi	40 psi	
Atomizing air	50 - 60 psi	36 psi	

Curing Schedule

These times are based on a 2.0-3.0 mil (50-75 micron) dry film thickness. Higher film thickness, insufficient ventilation or cooler temperatures will require longer cure times and could result in solvent entrapment and premature failure of the film. Maximum recoat time is 30 days without special surface preparation. Consult technical services for recommendations and test results. If the maximum recoat time has been exceeded, the surface must be sanded or prepared with a brush off blast SSPC-SP-7 prior to the application of additional coats. EP-GUARD™ 1600 applied below 40°F (4°C) may temporarily soften for several hours, after temperatures rise to 60°F (16°C). This is a normal condition and will not influence performance.

Catalyst	161-49C
Dry to touch	1 hour
To recoat	60 to 90 minutes (max 30 days)
Hard	12 hours
Full cure	7 days



DISCLAIMER: All information is given in good faith. Since conditions of use are beyond the manufacturer's controls, all information contained herein is without warranty, implied or otherwise. All technical data and specifications are subject to change. Please consult with your Glass Shield representative for more detailed coating recommendations.
Revised 04-01-2007

**EP-GUARD™
1600 series**