



TRIOCOR ABRASIV 4400 Modified epoxy material

DESCRIPTION: A two-pack epoxy material cured by polyamine.

TYPE AND RECOMMENDED USE: For offshore zones, refineries, power plants, bridges, buildings, mining equipment and general purpose construction steel, external surface of ship hulls, internal surface of ships.
Material can be applied as primer, intermediate or finish coat, and as single coat.
Surface tolerant product. Material can be applied at sub zero surface temperatures.

PHYSICAL CONSTANTS:

Colour: Grey.

Volume solids: 80±2 % - standard version;
72±2 % - low temperature version.

Film thicknesses and theoretical spreading rate:

Table of wet and dry film thicknesses

Standard version			
Film thickness	WFT, microns	DFT, microns	Theoretical spreading rate, ltr/m ²
Minimum	95	75	0,094
Maximum	250	200	0,250
Low temperature version			
Film thickness	WFT, microns	DFT, microns	Theoretical spreading rate, ltr/m ²
Minimum	105	75	0,104
Maximum	280	200	0,278

Drying times:

Drying time of TRIOCOR ABRASIV 4400:								
Surface temperature	Standard version			Low temperature version				
	10 °C	23 °C	40 °C	-5 °C	0 °C	5 °C	10 °C	23 °C
To touch	8 h	4 h	2 h	24 h	18 h	12 h	6 h	2,5 h
To recoat, minimum	24 h	10 h	4 h	48 h	26 h	18 h	12 h	5 h
Full cure	14 days	7 days	2 days	21 day	14 days	7 days	3 days	2 days

Drying time is presented on average DFT from recommended ranges of thicknesses for each version of the product. Drying times presented in this section have recommendatory character. It is necessary to take into account the presence of air flows and relative humidity when assessing actual drying time.

SURFACE PREPARATION:

The product is applied to a prepared metal surface. Required grade of preparation of surface depends on projected conditions and exploration period, project requirements.
Typical process includes the following stages: remedy imperfections to P2 (in operating conditions from C1 to C4 according to ISO 12944-2) or C3 (in operating conditions C5 according to ISO 12944-2) in

Technical Data Sheet



accordance with ISO 8501-3; remove oil and grease (if necessary); blast clean to Sa 2 in accordance with ISO 8501-1 with average surface profile in the range 40-70 microns, using hand and mechanized cleaning method to St 2 in accordance with ISO 8501-1; remove salt (if necessary); dust, blast abrasives shall be removed from the surface after blast cleaning such that the particle quantity and particle size do not exceed rating 2 of ISO 8502-3. Prepared surface should be dry, its temperature should be at least 3°C above the dew point.

APPLICATION DETAILS:

- Material preparation:** TRIOCOR ABRASIV 4400 is a two-component material. Before mixing stir separately Base and Additive. Mixing Ratio:
- 7 parts Base to 1 part Additive by volume for standard version;
- 4 parts Base to 1 part Additive by volume for low-temperature version.
Induction time after mixing is 10 min at 23 °C for standard version.
- Pot life:** 2 h at 23°C - for standard version;
1 h at 23°C - for low-temperature version.
- Application method:** Airless spraying / Manual application.
- Thinner:** For detailed information, contact «O3-Coatings».
- Nozzle size (recommended):** .019" – .025"
- Operating pressure (recommended):** No less than 150 bar.
- Cleaning of tools:** TRIOSOLV 0002. Contact your «O3-Coatings» representative for additional data.

Application conditions:

Recommended application conditions	Standard version	Low temperature version
Air temperature	From plus 10 °C to plus 40 °C	From minus 5 °C to plus 40 °C
Surface temperature	From plus 10 °C to plus 40 °C (at least 3 °C above the dew point)	From minus 5 °C to plus 40 °C (at least 3 °C above the dew point)
(In closed rooms it is necessary to provide supply-and-exhaust ventilation during application and drying to the extent necessary).		

- STORAGE:** 48 months for Base and Additive of standard version;
36 months for Additive of low temperature version.
Product should be stored in dry, dark space at temperatures between +5°C to + 30°C in the original sealed packaging, avoiding direct exposure to UV-rays and other sources of heat.
- PACKAGE:** Base – 20 L container;
Additive for standard version – 3 L container;
Additive for low temperature version – 5 L container.
- HEALTH AND SAFETY:** Refer to the Safety Data Sheet before use.