

## RESICHEM 530 HA100

**Resichem 530 HA100** is a single component solvent free heat activated epoxy novalac coating. The product has been designed for use on a wide range of metallic surfaces and once cured provides excellent corrosion protection.

### Typical Applications

**Application to hot pipework, process vessels and tanks, etc., particularly to overcome problems of corrosion under insulation (CUI).**

### Surface Preparation

All oil and grease must be removed from the surface of the repair using an appropriate cleaner such as MEK.

For optimum performance, the surface should be abrasive blasted to **ISO 8501/4 Standard SA2.5 (SSPC SP10/ NACE 2)** and a minimum blast profile of 75 microns (3mil) using an angular abrasive. Once blast cleaned, the surface must be degreased and cleaned using MEK or similar type material. All surfaces must be coated before gingering or oxidation occurs.

**PLEASE NOTE:** For salt contaminated surfaces the area must be abrasive blast cleaned as mentioned above and left for 24 hours to allow any ingrained salts to come to the surface. After this 24 hour period the surface must be washed with MEK prior to brush blasting to remove the surface salts. This process must be repeated until all ingrained contaminants have been sweated out of the surface.

Where abrasive blast cleaning is not possible (excluding salt contaminated surfaces) the surface should be roughened by MBX, needle gun or grinding. Under these conditions adhesion levels will not be optimal although still satisfactory for most applications.

### Application

***Do not heat this material in bulk.***

***The material is supplied ready to use and requires no mixing. Do not apply when the ambient or substrate temperature is below 5°C or the relative humidity is above 90%.***

Apply the material onto the prepared surface by brush or roller. In normal circumstances this should be in two coats at a target thickness of 250 microns (10mil) per coat.

The coating will remain in an unsolidified state until it has been heated to at least 90°C (195°F) and should ideally be heated to at least 100°C (212°F). The second coat should be applied as soon as the first coat has become dimensionally stable and not more than 2 hours after it has reached this state. Where the maximum over coating time is exceeded the surface of material should allowed to fully harden before being abraded, ideally by sweep blasting, and then cleaned and coated.

Alternatively the material can be applied by heated airless spray in as a single coat in multiple passes. The material should be heated to 50-60°C (120°F-140°F) using heated lines to facilitate spraying.

### Coverage Rates

4ltrs (1.25 US gallons) of fully mixed product will give the following coverage rates –  
16m<sup>2</sup> at 250 microns                      172ft<sup>2</sup> at 10mil

***Please note that the coverage rates quoted are theoretical and do not take into consideration the profile or condition of the surface being repaired.***

## Cure Times

Cure times are dependent on the cure temperature as indicated in the table below.

Temp	Touch dry	Light loading	Full Loading
100°C (212°)	50 mins	2 hours	24 hours
110°C (230°F)	35 mins	70 mins	16 hours
120°C (248°F)	25 mins	50 mins	12hours
130°C (266°F)	15 mins	30 mins	8 hours
140°C (284°F)	7 mins	15 mins	6 hours
150°C (302°F)	3 mins	7 mins	4 hours

## Pack Sizes

This product is available in the following pack sizes –  
4ltrs (1.25 US gallon)

## Colour

Mixed material – Red

## Over-coating times

Minimum - the applied material can be over-coated as soon as it is touch dry.

Maximum - the over-coating time should not exceed 6 hours.

Where the maximum over-coating time is exceeded, the material should be allowed to harden before being abraded or flash blasted to remove surface contamination.

## Storage Life

5 years if unopened and store in normal dry conditions (15-30°C/ 60-86°F)

## Technical data and Performance

<b>Volume Capacity</b>	<b>714cc/Kg</b>								
<b>Tensile Shear Adhesion ASTM D1002</b>	<b>197kg/cm<sup>2</sup> (2800psi)</b>								
<b>Shore D ASTM D2240</b>	<table border="1"> <tbody> <tr> <td>20°C</td> <td>90</td> </tr> <tr> <td>100°C</td> <td>86</td> </tr> <tr> <td>150°C</td> <td>80</td> </tr> <tr> <td>200°C</td> <td>72</td> </tr> </tbody> </table>	20°C	90	100°C	86	150°C	80	200°C	72
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<b>Corrosion Resistance (ASTM B117)</b>	<b>1000 hours+</b>								

Please see Resichem 530 HA100 Specification Sheet for further technical and performance data.

### Health and Safety

Please ensure good practice is observed at all times during the mixing and application of this product. Protective gloves must be worn during the mixing and application of this product. Before mixing and applying the material please ensure you have read the fully detailed Material Safety Data Sheet.

**Legal Notice:** The data contained within this Technical Data Sheet is furnished for information only and is believed to be reliable at the time of issue. We cannot assume responsibility for results obtained by others over whose methods we have no control. It is the responsibility of the customer to determine the products suitability for use. Resimac accepts no liability arising out of the use of this information or the product described herein.