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## MC-ES-2 Epoxy tie coat

### Product description

MC-ES-2 is a two-component epoxy tie coat.

### Recommended use

As a tie coat sprayed on the anticorrosive primer to secure adhesion between the anticorrosive system and the anti-fouling topcoat. Also suitable as sealer for aged anti-fouling coating.

### Recommended film thickness and spreading rate

Film thickness, dry( $\mu\text{m}$ )	50~125
Film thickness, wet( $\mu\text{m}$ )	87.7~219.3
Theoretical spreading rate, $\text{m}^2/\text{l}$	11.4 4.6

### Basic characteristics

Color	White/other
Volume Solids, %	57 $\pm$ 2
Flash Point, $^{\circ}\text{C}$	25 $\pm$ 2
Density (mix), g/ml	1.46 $\pm$ 0.05
VOC, g/l	400 $\pm$ 10

### Surface preparation

Should always be sprayed on the primer and used in the system recommended by our company.

Clean, dry and undamaged compatible primer. Wash the surface by high pressure fresh water or fresh water to remove salt and other contaminants. Remove all the rust and loose material by sandblasting or power tool.

When for maintenance, use high pressure water to remove the precipitated layer on antifouling coating to ensure intercoat adhesion.

### Condition during application

The temperature of the substrate should be at least 3 $^{\circ}\text{C}$  above the dew point of the air, temperature and relative humidity measured in the vicinity of the substrate. Good ventilation is usually required in confined areas to ensure proper drying.

### Application methods

Spray: airless spray or air spray

Brush: recommended for precoating or small area coating only, multiple coats may be required to achieve specified film thickness.

### Application data

Mixing      agitate component A and component B respectively, and then mixed thoroughly

Mixing ratio (weight)      A:B=10:1

Pot life (23 $^{\circ}\text{C}$ )      12 hours (Reduced at higher temperature)

Thinner/Cleaner      MC-EX-1

Recommended airless spray parameters

Usage of thinner      0~10% (weight)

Pressure at nozzle      15~20 MPa (about 150~200  $\text{kg}/\text{cm}^2$ ) .

Nozzle  $\phi$       0.38~0.53 mm.

Spray angle      40~80 $^{\circ}$

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Filter	Check to ensure that filters are clean.		
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### **Drying time**

Drying times are generally related to air circulation, temperature, film thickness and number of coats, and will be affected correspondingly. The figures given in the table are typical with:

Good ventilation (Outdoor exposure or free circulation of air)

Typical film thickness

One coat on top of inert substrate

Substrate temperature, °C	5	10	23
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40	12	8	5
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Surface dry, h	24	20	16
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3	5	3	2
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Through dry, h	24	16	8
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The given data must be considered as guidelines only. The actual drying time/ recoat interval may be shorter or longer, depending on film thickness, ventilation, humidity, underlying paint system, requirement for early handling and mechanical strength etc. .

### **Typical paint system**

Anticorrosive primer	250 µm
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Epoxy top coat	100 µm
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Antifouling topcoat	250 µm
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Other systems may be formulated, depending on specific condition.

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### **Storage**

Storage conditions are to keep the containers in a cool, dry, well ventilated space and away from source of heat and ignition.

Containers must be kept tightly closed.

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### **Handling**

Handle with care.

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### **Note**

According to requirement, this product can be diluted before coating.

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### **Packing size**

Component A in 18 liter container and component B in 4 liter container, or negotiation.

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### **Health and safety**

Before and during use of this product, please observe the precautionary notices displayed on the container. Be careful to avoid inhalation and skin contact of paint. Spillage of paint on the skin should immediately be removed with a suitable cleanser, soap and water. Avoid using organic solvent. Eyes should be well flushed with water and then seek medical attention immediately. The product should be used under well-ventilated condition. If using in stagnant condition and narrow place, forced ventilation must be provided, and applicators should take corresponding measures to strengthen personnel protection.