

## TECHNICAL DATA SHEET

## P504HD

V2-17/05/2024

### HEAVY DUTY SURFACE TOLERANT EPOXY MASTIC

#### DESCRIPTION

P504HD is a heavy-duty surface tolerant epoxy coating, filled with a far higher percentage of glass flakes. The heavy-duty version is required when needing superior permeation resistance. Designed to protect steel and concrete surfaces with minimum preparation, it is a primer and topcoat in one.

#### PROPERTIES

- Able to withstand harsher environments.
- Excellent Corrosion Resistance
- Good Chemical Resistance
- Very Low Permeability
- Minimum Surface Preparation to St2
- Grit blasting not essential.
- Very Good Application Properties.
- Good Abrasion Resistance
- Great Adhesion to:
  - o Old Paint
  - o Light Rust
  - o Galvanised Steel
  - o Damp Surfaces
  - o Slightly Oily Surfaces

<b>COLOUR</b>	: See Colour Chart
<b>Nº. OF COMPONENTS</b>	: 2
<b>MIXING RATIO (VOL)</b>	: 4 : 1
<b>CONSISTENCY</b>	: Thick Liquid
<b>VOLUME SOLIDS</b>	: 75%
<b>MIXED DENSITY</b>	: 1.4
<b>FLASH POINT</b>	: 35°C
<b>INDUCTION TIME</b>	: 10 min
<b>PRACTICAL SPREAD RATES</b>	: 2.5 - 5m <sup>2</sup> /ℓ
<b>DRY FILM THICKNESS (PER COAT)</b>	: 150 - 300µm
<b>POT LIFE @ 25°C</b>	: 2 hrs
<b>TOUCH DRY @ 25°C</b>	: 4 hrs
<b>HARD DRY @ 25°C</b>	: 16 hrs
<b>FULL CURE</b>	: 7 days
<b>OVERCOATING TIMES</b>	: 15°C: 16 hrs min : 30°C: 6 hrs min
<b>SUBSTRATE TEMPERATURE</b>	: Min: 10°C : 3°C above dew point
<b>RELATIVE HUMIDITY</b>	: Max: 85%
<b>APPLICATION TEMPERATURE</b>	: 10 to 40°C
<b>OPERATING TEMPERATURE</b>	: -20°C to +60°C
<b>RECOMMENDED NO. OF COATS</b>	: 2
<b>STORAGE TEMPERATURE</b>	: 10 to 40°C
<b>CLEANING SOLVENT</b>	: Epoxy Thinners
<b>SHELF LIFE</b>	: 12 months
<b>PACK SIZE</b>	: 5 & 20 litres

#### CHEMICAL RESISTANCE

Resistant to most dilute acids & alkalis, petroleum products & salt water.

#### SURFACE PREPARATION

##### Concrete

All surfaces must be clean, structurally sound and free of dust, oil and dirt. Concrete surfaces should be abrasive blasted or acid etched to remove laitance. Moisture content should be below 10%. Wash with plenty of water and allow to dry.

Prime with P101.

##### Steel

Mechanically clean to St2. Sound old coatings may be left on.  
Ensure soluble salts are removed by high pressure washing with Holdtight 102 or equivalent.

#### APPLICATION

Application by airless spray, brush or roller. Apply 2 coats of P504 @ 150 - 300µm DFT/coat.

Abrade between coats with medium grit sandpaper if overcoating times are exceeded.

Nozzle Pressure:	15 – 20 Mpa
Tip Size:	0,8mm – 1,1mm
Spray Angle:	40 – 80°C
Filter:	Remove all filters

*The technical data furnished is obtained from controlled laboratory tests under ideal application conditions. No guarantee of any performance characteristic is therefore given or implied and we do not hold ourselves responsible for any consequential damage of whatsoever nature that may arise from use of our products. In the event of a proven fault our liability will be limited to the replacement of the product only. It is the user's responsibility to confirm the currency of product data sheets.*



#### **TOXICITY**

Please read instructions on container.

Avoid Skin  
contact.

Do not inhale  
vapours.

SKIN: Wash well with soap & water.

EYES: Flush with water & immediately seek medical attention.

Read 16-point Safety Data Sheet.

#### **HOW TO SPECIFY**

All surfaces to be prepared and coated with P504 in accordance with the manufacturer's instructions.

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