

# PROMASTIC X-FORCE+ EPM-60220

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## PRODUCT DESCRIPTION & USES

**PROMASTIC X-FORCE+ EPM-60220** is a two-components modified epoxy high build surface and flash rust tolerant reinforced with glass flake. As a rust inhibiting tough epoxy coating for offshore structures, floodgates, dam gates, bridges, and high chemical risk environment such for tank externals, petroleum tanks internal, and barge deck.

## FEATURES

- Excellent Abrasion and Impact Resistance
- Excellent Toughness
- Excellent Corrosion Resistance
- As a Primer or Finish Coat
- Pencil Hardness up to 5H
- Fast Dry Version is Available Upon Request.

## PRODUCT SPECIFICATION

Colors : Black, Limited Colors Range Available  
 Finish : Matt  
 Volume Solid :  $75 \pm 2\%$   
 Specific Gravity :  $1.450 \pm 0.05$  g/cc  
 Flash Point :  $27^\circ\text{C}$   
 Packaging : 5 & 20 Liters set  
 Storage Stability : 24 Months. If it is stored in cool and dry place, also in its original not opened package. (Do not store below freezing point)

## APPLICATION

Application Condition :  $25 - 35^\circ\text{C}$ , 60 – 80 % RH  
 Mixing Ratio by Volume :

A Component (EPM - 60220)	:	B Component (EPMH - 60220 PS)	= 4 : 1 (v/v)
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Thinner : THME-90100, THME-90120, etc  
 Application Method : Airless Spray      Air Spray      Brush/Roller  
 Thinning Ratio by Volume : 5 – 10%      15 – 30%      0 – 5%  
 Tip Size for Airless Spray Gun : 0,019 - 0,021 inch      Air Pressure : approx. 160 bar/2300 psi  
 Nozzle Orifice for Air Spray : Approx. 1-1.5 mm      Air Pressure : approx. 3-4 bar/40-60 psi  
 Wet Film Thickness (WFT) : 135 – 200 microns or 5.3 – 8.0 mills  
 Dry Film Thickness (DFT) : 100 – 150 microns or 4.0 – 6.0 mills  
 Theoretical Coverage : 5.6 m<sup>2</sup>/liter set (DFT = 125 microns)  
 Pot Life :

20°C	30°C	40°C
4 - 5 hours	3 - 4 hours	2 – 3 hours

## FILM PROPERTIES

Drying Time (@ DFT = 125 mic) :

20°C	30°C	40°C
30 – 40 minutes	20 – 30 minutes	15 – 25 minutes
4 – 5.5 hours	4 – 5 hours	3 – 4 hours

• Surface Dry :  
 • Hard Dry :  
 • Full Cure : 7 days (30 °C)  
 Re-coating Interval : Minimum 6 hours (30°C)  
 Maximum 6 weeks (30°C)\*

Provide adequate ventilation during application and drying.

Note : Epoxy coatings will characteristically chalk and fade upon exposure to sun light  
\*For more details please contact PROPAN Technical Supervisor

### RECOMMENDED COATING SYSTEM

Primer Coat : **PROMASTIC X-FORCE+ EPM-60220**  
Finish Coat : **According to Specification**  
Recommended Dry Film Thickness : 1 coat (125 microns / coat)

### SURFACE PREPARATION

1. All surfaces should be clean, dry and free from contamination accordance with SSPC-SP 1 solvent cleaning.
2. Oil or grease should be removed by solvent cleaning or industrial detergent.
3. Blast cleaning with suitable blasting material minimum Sa2, hand or power tool cleaning to a minimum standard of St2 in accordance with the ISO 8501-1 : 1988 or SSPC-SP 2.
4. PROMASTIC X-FORCE+ EPM-60220 may be applied to surfaces prepared with Hydroblasting Standard HB2 which have flash rust not worse than HB2M
5. Provide adequate ventilation during application.

### INSTRUCTION FOR USE

Stir well before use, preferable by means use mechanical mixer to ensure good homogeneity  
Prepare one mixture (A+B) as much as needed for application. First, stir well Comp. A **EPM-60220** until homogeneous, add Comp. B **EPMH-60220 PS** and mix thoroughly. Mix ratio **Comp. A : Comp. B = 4 : 1 (by volume)**. Mixed material could apply using airless spray, brush or roller. Use Thinner **THME-90100** or **THME-90120** as solvent cleaner. Do not apply the mixed material after pot life time is over. Provide adequate ventilation during application and drying

### SAFETY PRECAUTION

Avoid contact with the skin and eyes. Wear suitable protective coating, such as overalls, goggles, dust mask, and gloves. Use barrier cream. Provide adequate ventilation during application. Do not breathe vapor of spray. This product is flammable. Do not smoke. Use only explosion proof equipment.

### FIRST AID:

General : In all cases of doubt, or when symptoms persist, seek medical attention. Never give anything by mouth to an unconscious person.  
Eyes : In the case of accidental splashes, flush eyes with clear running water for 5 minutes while holding eyelids open. If irritation persist, seek medical attention.  
Skin : Wash off thoroughly with plenty of water and soap. Do not use solvent or thinner. Removed contaminated clothing. If irritation persist, seek medical attention.  
Inhalation : Remove affected person to fresh air area, loosen collar, provide oxygen if breathing is difficult. If affected person is not breathing, administer CPR and seek emergency medical attention.

### DISCLAIMER

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