



Anti Corrosion Technology For Future

Data Sheet
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NAKI 15 XFTM Surface Tolerant Epoxy

Charateristics	: is a two packs, low VOC, Surface tolerance, high solids epoxy which can be applied in low film thickness. It contains MIO.
Recommended	: Designed for use for heavy duty interior and exterior at marine and offshore structure, where blast cleaning may not be possible. As a heavy duty maintenance for use in areas of exterior surfaces of steel tanks, structural steel, and aggressive atmospheric condition.
Health & Safety	: Read and observe health & safety datasheet prior to application
Colour	: Standard Colour (Colours are available upon requests), with 50 - 60% Gloss
Mixing Ratio	: 7 : 1 by Weight (Base : Activator) Add all the activator to the base and mix thoroughly, ensuring no unmixed materials remain. Remove all the mixed material from the base tin and remix in another container. Mix only as much material as may be used during the limited pot life.
Surface Preparation	: Bare Steel: Power tool cleaning, Min.St 2, mill scale free. Blast cleaning to Sa 2½ will greatly improve the coating performance. XF 15 will tolerate damp surfaces but excess moisture must be removed, dry is the best. Most existing firmly bonded coatings can be tolerated and overcoated by XF 15.
Application Equipment	: Brush, Roller, Airless spray, Conventional spray. For airless spray recommended tip size 0.32-0.48mm (13-19 thou).
Application Method	: This material is intended for application in one coat of between 150 - 300 micron DFT.
Pot Life	: Approximately 6 Hours 25°C. This time will vary significantly with temperature.
Specific Gravity	: 1.0 - 1.25 kg/l
Volume Solids	: 80 -82%
Theoretical Spreading Rate	: 5.5 m ² /Liter at 150 Micron dft.



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Recommended DFT	: Depent upon service duty, but generally 150 Microns in light atmospheric duty, 300 Microns in aggressive atmospheric condition. XF 15 may be used at 150 Microns as primer for other top coat.	
Cure Time	: Tack Free Full Cure	: Approximately 3 Hours at 30°C : Approximately 5 days at 30°C (Will vary significantly with temperature)
OverCoating Time	: Minimum Maximum	: 10 Hours at 25°C : 24 Hours (These times may be substantially shorter at high ambient temperature)
Storage & Handling	: The product must be ideally stored in a cool and well ventilated place, protected from heat and direct sunlight. Containers must be kept tightly closed before and after use.	
Flash Point	: 75°C	
Temperature Limit	: Non-Immersed: 100°C, Immersed: 90°C	
Pull off adhesion (ISO 4624)	: > 10 MPa on blasted carbon steel	
Packaging	: 18 Litre & 5 Litre Composite Kit	
Shelf Life	: A minimum of 1 year in unopened tins stored below 30°C	
Cleaning Solvent	: NAKI Thinner Epoxy	

Disclaimer

The information in this data sheet is given to the best of our knowledge based on laboratory testing and practical experience. However, product is often used under condition beyond our control; we cannot guarantee anything but the quality of product itself. We reserve the right to modify from time to time according to manufacturer experience and continuous development program.