



## FEATURES

- : TOA EPOXY PUTTY is a epoxy 2-pack chemically cured. It can be used for filling of holes and treatment surface smoothen in steel, wood and concrete. Non shrinking epoxy filler and the chemical resistance is exceptional when cured.
- : Surface should be clean, dry, free from oil grease and other deleterious substances. It is used as a putty filler on steel, wood and concrete, precast for surface smooth improvement. Voiding the dilution with thinner as it cause un-dry film or shrinkage film.

## TECHNICAL INFORMATION

Type	: Epoxy / Polyamide Putty
Color	: Grey
Film appearance	: Semi-Gloss
Specific gravity	: 1.18 ± 0.02
Solid by volume	: 100%
Flash point	: 35°C
Wet film thickness	(Microns) : depend on surface condition
Dry film thickness	(Microns) : depend on surface condition
Practical coverage.	m <sup>2</sup> / Liter : depend on surface condition
	m <sup>2</sup> / Gallon : depend on surface condition

Remark : Actual Surface coverage will depend on surface irregularities, Mixing, Application Condition method and technique; as well as the structure and dimensions of the object to be coated.

	Temperature	25 °C	30 °C	35 °C
Touch dry	Surface dry	2 hrs.	1.5 hrs.	1 hrs.
Full cure	Hard dry	6 hrs.	4 hrs.	3 hrs.
Recoat dry	Minimum	6 hrs.	4 hrs.	3 hrs.
	Maximum	-	-	-
Potlife		50 mins.	30 mins.	25 mins.

Remark : Drying times are generally related to air circulation, temperature, film thickness and number of coats, and will be affected correspondingly.

## APPLICATION

Mixing Ratio	Part A	Part B
By Volume	2	1
By Weight	2	1
Application Method	Trowel	
Diluted by	No Diluted	
Applicator	Steel bladed trowel, Pin rake or Serrated hand trowel	

Mix Part A and Part B, strictly follow mix ratio recommendations before dilute by Thinner mixing and stir for 2-3 minutes until the mixture is homogeneous after leave 5 minutes before application.



## APPLICATION SYSTEM

### Surface Preparation

#### Steel

: Should be blast cleaned in accordance with NACE No.2 / SSPC-SP10 / ISO 8501:1 / SIS Sa 2.5 to a near-white finish using a suitable abrasive. And/or by use the surface preparation with requirements. of the primer and/or as the Spec of the project.

**Remark** : The surface must be thoroughly dry and apply the protective coating within 4 hours to cleaned surface.

#### Wall

: For New concrete - The concrete prior to laying plastic sheets to block moisture from underground. Then it should be left for curing concrete to solid and dry for about 3-4 weeks. Then, clean the surface free from dust, dirt, grease and most importantly, the surface is completely dry.

(Check moisture content must be less than 14%)

: For Old concrete - To remove the old paint film which loosely adhesion to as much as possible by Scraping with a shovel or Grinding machine to enhance adhesion. Then, clean the surface free from grease and oil with suitable solvent. Before primer coating should clean all surfaces free from dust, dirt, grease and most importantly, the surface is completely dry. (Check moisture content must be less than 14%).

#### Before Recoat by Topcoat

: Remover all oil, grease, dirt, oxide and other foreign material by cleaning per SSPC-SP1, Solvent Cleaning before coating.

: If over 7 days gives cleaning surface by sand paper no. 320-400 and cleaning surface per SSPC-SP1, Solvent Cleaning before coating.

: Surface repaire (cracks, pores, holes) done with TOA Epoxy putty and polishing of surface with moltoprene disk.

### Coating System

#### Protective protective Coating

: Primer	Rusttech	100 microns x 1 coat
: Undercoat	TOA Epoxy Putty	
: Topcoat	Epoguard Enamel (for inside area)	60 microns x 2 coats or
	Topguard (for outside area)	60 microns x 2 coats

#### and

#### Concrete protective Coating

: Primer	Epoguard Varnish	50 microns x 1 coat
: Undercoat	TOA Epoxy Putty	
: Topcoat	Epoguard Enamel (for inside area)	60 microns x 2 coats or
	Topguard (for outside area)	60 microns x 2 coats

### Recommendation

: The proper relative humidity in the work shall not exceed 85% RH.

: The temperature of the substrate should be minimum 10°C and at least 3°C above the dew point of the air, temperature and relative humidity measured in the vicinity of the substrate for prevent moisture and water drop on substrate effective adhesion and drying time.

## HANDLING AND STORAGE

### Storage condition

: The product must be stored in accordance with national regulations. Storage conditions are to keep the containers in a dry, cool, well ventilated space and away from source of heat and ignition.

### Shelf life

: 24 months at 30-35 °C

: The product must be stored in accordance with national regulations. Storage conditions are to keep the containers in a dry, cool, well ventilated space and away from source of heat and ignition.

Containers must be kept tightly closed.

### Package

Packaging size	Part A :	Part B :
1 Gallon Set	1 Gallon	1/4 Gallon



## HEALTH AND SAFETY

: Please observe the precautionary notices displayed on the container. Use under well ventilated conditions. Do not breathe or inhale mist. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water and medical attention sought immediately.

: For detailed information on the health and safety hazards and precautions for use of this product, we refer to the Safety Data Sheet.

## DISCLAIMER

: The information in this data sheet is given to the best of our knowledge based on laboratory testing and practical experience. However, as the product is often used under conditions beyond our control, we cannot guarantee anything only the quality of the product itself. We reserve the right to change the given data without notice.