

**TDS 0526**

REVIEW: 02/2016

Standards: USIMINAS NCU-0199 D

**Oxibar DST 535**

Component A: 535.0149 (White)

and 535.0499 (Red Oxide)

Component B: 832.3600



Oxibar DST 535 uses specially selected raw materials, showing a high build, a good resistance to splatters of acid and alkaline solutions and a high anticorrosive performance. This product provides excellent adhesion to steel, high abrasion resistance and excellent throwing power. It is suitable for aged systems that are still in good condition and its main property: it can be applied over hand and power cleaned surfaces as primer and topcoat simultaneously, where abrasive blasting is impractical. It upgrades conventional systems to high performance ones without being necessary to promote abrasive blasting. Also, this is an ecological product with high solids and low volatile organic compounds (low VOC).

**TECHNICAL CHARACTERISTICS****TYPE**

High build epoxy coating , two pack system .

**USAGE**

As coating for carbon steel surfaces, such as large industrial and marine structures (offshore), exterior of industrial tanks, equipment, piping, etc. It is also indicated for broadside, boottop, deck, superstructure, hatchway lids, coaming and bottom boats (permanent immersion).

**TECHNICAL INFORMATIONS**

<b>COLOR</b>	White and Red Oxide	Other colors, please consult.	
<b>FINISH</b>	Semiglossy		
<b>VOLUME SOLIDS</b>	80% ± 2	According to ISO 3233	
<b>WEIGHT PER LITER</b>	1,450 ± 0,05 g/ml	According to ASTM D 1475	
<b>VOC</b>	145 g/l	This value may vary to each color	
<b>FLASH POINT</b>	35°C		
<b>MIXING RATIO</b>		Weight	Volume
	<b>Comp. A</b>	100,0	1,0
	<b>Comp. B</b>	90,0	1,0
<b>POT LIFE (25°C)</b>	4 h		
<b>INDUCTION TIME</b>	15 to 30 min		
<b>THEORETICAL SPREADING RATE</b>	10,7 m <sup>2</sup> /l - 75 µm		
	4,0 m <sup>2</sup> /l - 200 µm		
<b>WET THICKNESS</b>	94 to 250 µm		
<b>DRY THICKNESS</b>	75 to 200 µm		

	Oxibar DST 535	One component painting systems		epoxy and polyurethane painting systems	
		Minimum	Maximum	Minimum	Maximum
<b>DRYING TIME, for 75 µm</b>					
	<b>25°C</b>				
	<b>Touch</b>		3 h		
	<b>Handle</b>		10 h		
	<b>Recoat</b>	24 h	48h	24 h	72 h
				24 h	48h

<b>ENVIROMENTAL CONDITIONS</b>	<b>Temperature</b>	Should be between 0 to 40°C. For temperatures below 10°C, add 1,4% in volume of curing agent 870.0576.
	<b>Relative Humidity</b>	Between 30 to 85%
	<b>Dew Point</b>	Surface temperature is at least 3°C above dew point
	<b>Thinner</b>	420.0000

<b>APPLICATION</b>	<b>Brush</b>	It is not necessary dilution. This method must be used only for retouch and backing of welding cords and corners.
	<b>Roller</b>	Dilute up to 20% (vol.) with recommended thinner. Must be used solvent resistant roller (sheep wool). The wool must be cutted (small size) to avoid blistering during the application.
	<b>Conventional Spray Gun</b>	Dilute up to 20% (vol.) with recommended thinner. Conventional DeVilbiss JGA 502 FX 704 spray gun or similar. Spray pressure between 2,5 to 3,0 kgf/cm <sup>2</sup> (35 to 43 psi). Tank pressure between 1,5 to 2,5 kgf/cm <sup>2</sup> (21 to 35 psi).
	<b>AirLess Spray Gun</b>	Dilute up to 20% (vol.) with recommended thinner. Use nozzles between 23 to 29 and pump pressure between 175 to 210 kgf/cm <sup>2</sup> (2500 to 3000 psi).



<b>SURFACE PREPARATION</b>	<b>Direct over carbon steel</b>	Blast cleaning ISO 8501-1 St 3 (minimum) recommended. Applicable over flash rusting stains after wet blasting the surface with or without inhibitor. The surface must be dry, free of contaminants such as salt deposits, oil, grease, fat, dust and other kind of contaminants.
	<b>Recommended Primers</b>	Over aged systems, please contact our Consultants.
	<b>Coated Surfaces</b>	The surface must be clean and free of contaminants as oils, fat, grease and dust. Must not present peeling's areas. Proceed light sanding (220) to break the gloss.
	<b>Recommended TopCoat</b>	Not applicable

<b>SHELF LIFE</b>	12 months
<b>UN NUMBER</b>	<b>1263</b>
<b>HAZARD NUMBER</b>	<b>33</b>

**IMPORTANT RECOMMENDATIONS**

1. The practical spreading rate of the product varies according to the applied thickness, application
2. The weight/l, viscosity and drying values were obtained in laboratory at a temperature of 25°C. At an altered temperature, the results might be different from the specified ones.
3. Low temperatures increase curing time. For temperatures below 10°C, contact our Consultants.
4. Pot life is shortened by higher temperature and by the increase of catalyzed volume.
5. For upgrading it the paint shall not be thinned, or be thinned up to 5% of volume with thinner 487.0000, or else the one component coat will roughen. Do not thin more than recommended.
6. Dockage recoat dry time, lower recoat intervals: minimum 16 hr, maximum 48 hr.
7. If the recoat interval exceeds, sand the surface lightly. If temperature is higher than established the recoat drying time will be reduced. If the surface presents chalking, wash and sand it lightly and remove all contaminants.
8. The color of organic coatings may change when submitted to temperatures over 60°C.
9. Important: add curing agent to component B and homogenize, then mix components A and B for 5 minutes using mechanical agitator. Additivition is not recommended for immersion products. Additivition reduces pot life.

**SAFETY PRECAUTIONS**

1. Improper use and handling of this product can be hazardous to health and cause fire or explosion. Do not use it without first taking all appropriate measures to prevent property damage and injuries.
2. Storage: keep the product in sheltered, well-ventilated areas. Maximum temperature: 40° C. Must not be directly exposed to the sun.
3. Flammable: flammable product, which must be kept distant from ignition sources, and do not smoke nearby.
4. Inhalation: Avoid breathing vapors, keeping proper ventilation during application and drying.
5. Handling: wear proper protective clothing and masks, goggles, etc. Do not eat or drink nor allow children and animals to be near the application area.



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**HEALTH HAZARDS**

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1. Skin contact: wash affected area thoroughly with neutral soap.
2. Clothing contact: remove clothing and wash it.
3. Leakage: Isolate the area, and do not smoke nearby. If large quantity leaked in confined area, wear protective masks. Do not inhale vapors. Stop leakage with sand, sawdust or soil, and transfer liquid and solid to separated recipients for disposal.
4. Fire: protect non-affected recipients with water spray. Extinguish fire using carbon dioxide, foam or dry chemical.
5. Eyes contact: flush eyes with large amounts of clean water for at least 10 minutes, and get medical attention immediately.

IMPORTANT: For further information consult the product MSDS (Material Safety Data Sheet).

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