



常州东方涂料（尼日利亚）有限公司

CHANGZHOU DONGFANG COATING(NIGERIA)CO.,LTD

产品技术参数 Product Technical Data

H54-32 环氧储罐内壁漆

H54-32 Epoxy Tank Lining Coating

产品说明

Product Description

一种双组份的环氧溶剂型储罐衬里

A two component solvent based epoxy tank lining.

设计用途

Intended Uses

作为一种钢储罐和容器内部的防腐经济型涂料产品。

As an economical coating for the corrosion protection of the internals of steel storage tanks and vessels.

适用于储存广泛的产品，包括溶剂、原油、白成品油、航空燃料、水溶液、淡海水和烧碱。

Suitable for the storage of an extensive range of products including solvents, crude oils, white oil refined products, aviation fuels, aqueous solutions, brackish water and caustic soda.

涂装数据

Coating Data

颜色 Color	白色、灰色等有限范围颜色 white, grey and limited range colors			
光泽 Gloss Level	半光 half matte			
体积固体份 Volume Solids	65±2%			
典型厚度 Typical Thickness	干膜厚 100-150 微米 Dry film thickness of 100-150 microns.			
理论涂布率 Theoretical Coverage	在干膜 100 微米的情况下，6.5 平方米/公升 6.5 m ² /L at the dry film thickness of 100 microns.			
实际涂布率 Practical Coverage	允许适当的损耗系数 Allow proper loss coefficient			
施工方法 Method of Application	空气喷涂，无气喷涂，刷涂，滚涂 Air spraying, airless spraying, brush coating, roller coating			
干燥时间 Drying time	推荐面漆重涂间隔 Overcoating interval with self			
温度 Temperature	表干 Touch Dry	硬干 Hard Dry	最小 Minimum	最大 Maximum
10°C	10 小时/ hours	24 小时/ hours	48 小时/ hours	28 天/days
15°C	7 小时/ hours	16 小时/ hours	36 小时/ hours	28 天/days
25°C	4 小时/ hours	12 小时/ hours	24 小时/ hours	28 天/days
40°C	2 小时/ hours	6 小时/ hours	12 小时/ hours	14 天/days

产品数据

Product Data

产品重量 Product Weight	理论值 Calculated :1.5 kg/L				
包装规格 Pack Size	包装规格 Unit Size	A 组份 Part A		B 组 Part B	
	20 公升 litre	体积 Vol	包装 Pack	体积 Vol	包装 Pack
		16 公升 litre	20 公升 litre	4 公升 litre	4 公升 litre
关于可提供的其它包装规格，请与我们联系。 For availability of other pack sizes, please contact us.					
贮存 Storage	贮存期限 Shelf Life	在 25° C 时，至少为 12 个月。此后应在检查后再使用。贮存于干燥、阴凉的环境之中，远离热源及火源。 12 months minimum at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.			

表面处理

Surface treatment

所有待涂表面应清洁、干燥且无污染物。施工油漆前，所有表面应按照 ISO 8504:2000 标准进行评估和处理。
All surfaces to be coated should be clean, dry and free from contamination. Prior to paint application all surfaces should be assessed and treated in accordance with ISO 8504:2000.

在需要之处，除去焊接飞溅物并磨光焊缝和锐边。

Where necessary, remove weld spatter and smooth weld seams and sharp edges.

油和油脂应按照 SSPC-SP1 溶剂清理标准除去。

Oil or grease should be removed in accordance with SSPC-SP1 solvent cleaning.

喷射处理

Abrasive Blast Cleaning

表面喷砂处理至 Sa2.5 (ISO 8501-1:2007) 或 SSPC-SP10 时，H54-32 可以得到最好的性能。

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本产品说明书取代以前的版本，产品技术说明书应与安全技术说明书及施工指导一起阅读。也可查询我们的网站:www.dongfangcoating.com 或电话联系+234 8142485508,+234 9030009201

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Best performance is achieved when the surface is sandblasted to Sa2.5 (ISO 8501-1:2007) or SSPC-SP10.

建议表面粗糙度为 50-75 微米。

A sharp, angular surface profile of 50-75 microns is recommended.

H54-32 必须在钢表面氧化前涂覆。如果确实发生氧化，则整个氧化区应该重新喷射处理，达到上述标准。

H54-32 must be applied before oxidation of the steel occurs. If oxidation does occur the entire oxidized area should be reblasted to the standard specified above.

H54-32 可在贮罐内壁的半保护环境中，保持喷砂标准达 28 天。如果表面存在潮气，会发生氧化，需要再行喷砂。

H54-32 can hold a blast for up to 28 days in the semi-protected environment of a tank interior. If moisture is present on the surface, oxidation will occur and reblasting will be required.

预涂有车间底漆的钢结构

Shop Primed Steel

焊缝及损坏区域应喷砂清理至 Sa2½ (ISO 8501-1:2007) 或 SSPC-SP10 标准。

Weld seams and damaged areas should be blast cleaned to Sa2½ (ISO 8501-1:2007) or SSPC-SP10.

如果车间底漆出现大面积损坏或大范围的散射状损坏，可能需要进行全面刷除锈级喷砂清理。

If the shop primer shows extensive or widely scattered breakdown overall sweep blasting may be necessary.

施工说明

Construction description

混合 mixing

本产品分两罐装，组成一个单元。使用时应按规定比例成对一次性混合。一经混合，必须在规定的混合寿命内使用。

This product is filled in two cans which form a unit. When being used, they shall be mixed in pairs by the prescribed proportion. Once they are mixed, it must be used within the specified mixing life.

(1) 采用动力搅拌器搅拌基料 (A 组分)。

(1) Stir base materials (component A) with a power stirrer.

(2) 将全部固化剂 (B 组分) 和基料 (A 组分) 混合，并采用动力搅拌器彻底搅拌。

(2) Mix all curing agents (component B) and base materials (component A) and thoroughly stir with a power stirrer.

混合比例 Mixing ratio

16: 4 体积比 by volume

混合使用寿命 Mixing service life

10°C 15°C 25°C 40°C

10 小时/hours 8 小时/hours 2 小时/hours 1 小时/hours

推荐施工方法

无气喷涂 喷嘴直径 0.53-0.68 毫米喷嘴处的油漆总压力不低于 176 千克/平方厘米

Recommended construction method

Airless spraying: nozzle diameter: 0.53-0.68mm; the total paint pressure at the nozzle shall not be less than 176kg/cm².

稀释剂 thinner

环氧专用稀释剂

作业暂停

Epoxy thinner

Operation suspension

勿要让涂料保留在漆管、喷枪或喷涂设备中。采用专用环氧稀释剂彻底冲洗所有设备。油漆混合后不宜重新密封，如果工作中断时间过长，建议重新混合一组新的油漆进行施工。

Do not retain paint in the paint tube, the spray gun or the spraying equipment. Rinse all equipment thoroughly with epoxy thinner. It is not recommended to reseal the paint after mixing. If the work is interrupted for too long time, it is recommended to remix a set of paints for construction.

清洗

所有设备在使用后，应立即采用环氧稀释剂进行清洗。在日常工作过程中定时冲洗喷涂设备，是一个良好的习惯。清洗频率取决于喷涂量、温度、喷涂时间，包括中断的时间等因素。

Cleaning

All equipment shall be cleaned immediately with epoxy thinner after use. It is a good habit to wash the spraying equipment regularly in daily work. The cleaning frequency depends on quantity of spray, temperature and spraying time, including interruption time and other factors.

剩余漆料和空罐均应根据有关的地区法规处理

Residual paint and empty cans shall be disposed in accordance with the relevant regional regulations



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产品特性

Product characteristics

使用前须咨询详细的储罐衬里推荐工艺流程

The detailed Tank Lining Recommended Working Procedures should be consulted prior to use.

H54-32 一般规定为 2 道涂层的漆系，每道涂层的厚度为 125 微米，漆系的干膜总厚度为 250 微米。这一干膜总厚度的确切配套视最终用途的要求而定。

H54-32 is generally defined as a paint system with 2 coats of 125 micron thickness per coat and a total dry film thickness of 250 micron for the paint system. The exact total thickness of this dry film depends on the requirements of the end use.

为使单层漆达到最大膜厚，无气喷涂是最佳手段。采用无气喷涂以外的其它施工方法，不可能达到所要求的涂膜厚度。采用传统型有气喷涂施工，为了达到最高膜厚，需要进行多道交叉喷涂。采用其它方法，刷涂、滚涂建议只用于小范围。

In order to achieve the maximum film thickness of single layer paint, airless spraying is the best method. Using other construction methods other than airless spraying, it is impossible to achieve the required film thickness. Traditional pneumatic spraying is adopted. In order to achieve the highest film thickness, multi-channel cross spraying is needed. Using other methods, brush coating, rolling coating is recommended only for a small range.

被涂表面温度必须至少高于露点 3° C。

The temperature of the coated surface must be at least 3°C above the dew point.

钢材温度低于 10° C 时，不得进行施工。

When the steel temperature is lower than 10°C, the construction shall not be carried out.

施工和固化期间的相对湿度不应高于 80%。

The relative humidity during construction and curing should not be higher than 80%.

若施工期间或施工后立即处于不可接受的低温和/或高湿度环境下，会导致不完全固化和表面污染，继而危及层间附着力。

Exposure to unacceptably low temperatures and/or high humidity during or immediately after construction may result in incomplete curing and surface contamination, thereby endangering interlayer adhesion.

要实现最大的电阻，必须等到漆膜完全固化。固化受到湿度、温度和膜厚的影响。通常，经过 7-10 天，在 25° C 的温度下，50%的湿度下，可以得到 250 微米的完全固化干膜厚度，达到理想的耐化学性。固化时间在较高的温度下将减少，在较低的温度下将增加。

For maximum resistance, wait until the film is fully cured. Curing is affected by humidity, temperature and film thickness. Typically, after 7-10 days, a fully cured dry film thickness of 250 microns is obtained at 25°C and 50% humidity, achieving ideal chemical resistance. Curing time will decrease at higher temperatures and increase at lower temperatures.

系统配套性

System compatibility

H54-32 可直接施工在经过正确处理的裸露钢材上。但也适于施工在下列底漆上：

H53-82 环氧磷酸锌底漆,H06-1 环氧富锌底漆

H54-32 can be constructed directly on exposed steel that has been properly treated. But also suitable for construction on the following primer:H53-82 epoxy zinc phosphate primer, H06-1 epoxy zinc rich primer

H54-32 仅应进行自身复涂，决不应采用其它产品进行复涂。

H54-32 should only be recoated by itself and should never be recoated with other products.

还可提供其他油漆配套使用，请向常州东方涂料尼日利亚有限公司咨询。

Other paints are also provided for compatible application. Please consult with CHANGZHOU DONGFANG COATING (NIGERIA) CO., LTD.

安全注意项

Safety precautions

本产品旨在仅由工业领域中的专业施工人员按照本手册，材料安全数据手册和包装容器上所给定的建议进行施工，未经查阅常州东方涂料尼日利亚有限公司为其客户提供的材料安全数据手册（MSDS），不应使用本产品。

This product shall be used by professional coating workers on the production site in accordance with the recommendations in this manual, the material safety data sheet and the instructions on the packaging containers. This product shall not be used without consulting the material safety data sheet (MSDS) provided by CHANGZHOU DONGFANG COATING(NIGERIA)CO.,LTD. to its customers.

所有于施工和使用本产品有关的工作，都必须根据各种有关的国家卫生、安全和环保标准与法规进行。

All work related to the construction and use of the product must be carried out in accordance with the relevant national health, safety and environmental standards and regulations.

如果需要在涂有本产品的金属上进行焊接或火焰切割，会产生粉尘和烟雾，因此需要用合适的个人防护设备及充分的局部通风措施。

If welding or flame cutting is required on the metal coated with the product, dust and smoke will be generated. Therefore, appropriate personal protective equipment and adequate local ventilation will be required.

如果对本产品的适用性存在疑惑，请向常州东方涂料尼日利亚有限公司咨询。

If there is any doubt about the applicability of this product, please consult with consult with CHANGZHOU DONGFANG COATING (NIGERIA) CO., LTD

重要说明

Important explanation

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