

# HEGSEL® Flake 730

Anti-Corrosion Glass Flake Epoxy Coating

*You Build, We Protect!*

**Description:**

**HEGSEL Flake 730** is a high solids two-component epoxy containing micronized glass flake and anti-corrosive pigments.

**Applications:**

Corrosion protection of blast cleaned steel and cathodically protected steel.  
**HEGSEL Flake 730** Possesses excellent abrasion resistance and has excellent resistance to immersion in sea water and a range of chemicals also compatible with cathodic protection.  
 Aluminium **HEGSEL Flake 730** mastic version available for high build brushing maintenance specifications.

**Application Data:**

|                                       |                  |   |             |             |
|---------------------------------------|------------------|---|-------------|-------------|
| <b>Mixing Ratio (Parts by Volume)</b> |                  | A : B = 3 : 1   |             |             |
| <b>Consumption</b>                    | @DFT 400 microns | 0.760 kg/m <sup>2</sup>   |             |             |
|                                       | @WFT 482 microns | <b>Note:</b> This figure makes no allowance for surface profile, uneven application, overspray or losses in containers and equipment. Film thickness will vary depending on actual use and specification.   |             |             |
| <b>Recommended Primers</b>            |                  | <b>HEGSEL POX 401</b> Blast Primer<br><b>HEGSEL POX 402</b> Blast Primer<br><b>HEGSEL POX 403</b> Wet Blast Primer<br><b>Note:</b> Primers are optional. <b>HEGSEL Flake 730</b> can be applied directly onto steel. Please consult HEGSEL for guidance on alternative primers. |             |             |
| <b>@Temperature</b>                   |                  | <b>5°C</b>  | <b>15°C</b> | <b>23°C</b> |
| <b>Average Drying Time</b>            | <b>To recoat</b> | 12 hrs  | 6 hrs       | 4 hrs       |
|                                       | <b>To handle</b> | 6 hrs   | 4 hrs       | 3 hrs       |
|                                       | <b>To handle</b> | 30 hrs  | 16 hrs      | 8 hrs       |
| <b>Pot Life</b>                       |                  | 3 hrs   | 1.5 hrs     | 1 hr        |

**Note:** These figures are given as a guide only. Factors such as air movement and humidity must also be considered.

**Technical Data:**

| <b>Title</b>                                 |   | <b>Value</b> | <b>Unit</b> |
|--|---|--------------|-------------|
| <b>Density</b>                               |   | 1.59         | kg/litre    |
| <b>Flash Point</b>                           |   | Base: 9      | °C          |
|  |   | Additive: 23 |             |
| <b>Volume Solids</b><br>ASTM-D2697-03 (2014) |   | 83 ± 4       | %           |
| <b>VOC</b>                                   | Determined practically in accordance with UK Regulations PG/23                | 143          | g/L         |
|  | Calculated from formulation to satisfy EC Solvent Emissions Directive         | 167          | g/L         |
|  | Content by weight from formulation, to satisfy EC Solvent Emissions Directive | 107          | g/kilo      |

**Packaging:**

20 L and 4 L kits

**Storage:**

2 years from date of batch manufacture in sealed original containers under dry and cool conditions between 10 - 20°C. Bring to a suitable working temperature before application. Tightly re-seal opened containers and use the content as soon as possible.  
 Protect from heat and freeze!

## 1. Surface Preparation

Blast clean to Sa2½ ISO 8501-1:2007 using angular grit. Average surface profile in the range 50-100 microns.

For agreed maintenance specifications, **HEGGEL Flake 730** may be applied onto manually prepared surfaces to a minimum standard of St3 ISO8501-1:2007 Part A1. Please consult HEGGEL to confirm specification.

Ensure surfaces to be coated are clean, dry and free from all surface contamination.

**HEGGEL POX 401** should be specified where there is a requirement for a blast primer. Other blast primers should not be used without reference to HEGGEL.

## 2. Application Conditions and Overcoating

In conditions of high relative humidity, i.e., 80 - 85% good ventilation conditions are essential. Substrate temperature shall be at least 3°C above the dew point and always above 0°C.

At application temperatures below 10°C, drying and curing times will be significantly extended, and spraying characteristics may be impaired.

Application at ambient air temperatures below 5°C is not recommended.

If it is desired to overcoat outside the times stated on the data sheet, please seek advice of HEGGEL.

## 3. Application Equipment

### Airless spray

Nozzle size: 0.38 - 0.53mm (15 - 21 thou)

Fan Angle: 65°

Operating Pressure: 210 kg/cm<sup>2</sup> (3000 psi)

The airless spray details given above are intended as a guide only. Details such as fluid hose length and diameter, paint temperature and job shape and size all have an effect on the spray tip and operating pressure chosen. However, the operating pressure should be the lowest

possible consistent with satisfactory atomisation. As conditions will vary from job to job, it is the applicators' responsibility to ensure that the equipment in use has been set up to give the best results. If in doubt HEGGEL should be consulted.

### Brush

**HEGGEL Flake 730** is capable of being applied by brush at 250 microns DFT.

It is possible to apply **HEGGEL Flake 730** onto a damp substrate (no running or pooled water) by brush application. Ensure that the paint fully displaces any water on the substrate.

| Practical Application Rates-Microns Per Coat |               |       |
|--|---------------|-------|
|  | Airless spray | Brush |
| Dry  | 400*          | 250   |
| Wet  | 482           | 302   |

**Note:** Maximum sag tolerance typically 1200µm wet (1000µm dry) by airless spray.

**HEGGEL Flake 730** may be applied by brush onto hot surfaces up to 120°C. Multiple coats will be necessary to achieve required film build. Ensure good ventilation and adequate PPE due to rapid vaporisation of solvent from the film at high temperatures.

The coating can be self-overcoated indefinitely after proper cleaning. For best adhesion with other epoxy topcoats, overcoat within 14 days. For atmospheric exposure, consult HEGGEL for a recommended topcoat.

## 4. Additional Notes

Drying times, curing times and pot life should be considered as a guide only.

The curing reaction of epoxies commences immediately the two components are mixed, and since the reaction is dependent on temperature, the curing time and pot life will be approximately halved by a 10°C increase in temperature and doubled by a 10°C decrease in temperature.

Material is not suitable for force drying above 50°C.

### Epoxy Coatings - Colour Stability:

Variable colour stability is a feature of epoxy materials which tend to yellow and darken with age. Therefore, any areas touched-up and repaired with the same colour at a later date may be obvious due to this colour change.

When epoxy materials are exposed to ultra-violet light a surface chalking effect will develop. This phenomenon results in loss of gloss and a fine powder coating at the surface which may give rise to colour variation depending on the aspect of the steelwork. This effect in no way detracts from the performance of the system.

### Epoxy Coatings - Tropical Use:

Epoxy paints at the time of mixing should not exceed a temperature of 35°C. At this temperature the pot life will be approximately halved. Use of these products outside of the pot life may result in inferior adhesion properties even if the materials appear fit for application. Thinning the mixed product will not alleviate this problem.

The maximum air and substrate temperature for application is 50°C providing conditions allow satisfactory application and film formation. If the air and substrate temperatures exceed 50°C and epoxy coatings are applied under these conditions, paint film defects such as dry spray, bubbling and pinholing etc. can occur within the coating.

Numerical values quoted for physical data may vary slightly from batch to batch.

## 5. Safety Measures

The material safety data sheets of the individual components, the safety instructions on the packing (label) as well as the legal requirements for handling hazardous materials must be observed.

**HEGGEL Flake 730**; Revision No: 1.10 / Last Revision Date: 11.10.2023

All information contained herein is based on the current state of our knowledge and practical experience at the time of release. Therefore, please make sure that this is the latest edition of the Technical Data Sheet. All data are only intended as a guideline for informational purposes and do not constitute a legally-binding warranty of the suitability for a certain purpose of use, due to its dependence on site conditions and possible processing, use and applications. All information contained in this technical datasheet is subject to change without notice.

**HEGGEL GmbH**

Huttropstr. 60  
45138 Essen  
Germany

Tel: +49 201 17003 270

Fax: +49 201 17003 277

E-Mail: [info@heggel.de](mailto:info@heggel.de)

Web: [www.heggel.de](http://www.heggel.de)