MONDIAL COLOR

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COMPANY WITH
CERTIFIED MANAGEMENT SYSTEM
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# PRODUCT DATA SHEET

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|---|---|
| **PRODUCT:** | **EPOPAINT 800**<br>**Two-component high build epoxy-amine coating** |
| **CODE:** | **COMP. A 337**<br>**COMP. B 9000080 - CAT PER EPOPAINT 800** |

**PRODUCT DESCRIPTION:**

Anticorrosive mastic with Surface Tolerant properties , self-priming, high solid content and high thickness. It has excellent adhesion to metals, galvanized steel, on old paint and on deteriorated surfaces. The product allows the achievement of any thickness without sagging, up to a maximum of 600 microns wet, smoothly covering edges and corners. These features make it an ideal product for the maintenance of damaged coatings where sandblasting is often not possible. EPOPAINT 800 is a durable primer-topcoat even on new surfaces, has excellent mechanical and chemical properties, impact resistance, abrasion, bending, resists against different chemicals including oils, kerosene, naphtha, both basic and acid solutions.

**SURFACE PREPARATION:**

The better the preparation of the substrate, better and longer lasting will be the result. For particularly harsh operating conditions we recommend a white metal blasting (grade Sa3). For less severe conditions an almost white metal (grade Sa 2.5) is enough. A commercial blasting or alternatively a good quality mechanical cleaning are often acceptable. Completely remove everything that is not tight and compact, such as rust, old paint, contamination from dirt, grease etc. The product must be applied strictly on dry surfaces, clean, perfectly free of oil, grease, dust, moisture or other contaminants.

**APPLICATION METHODS:**

Spray, brush or roll. Preferred application is airless spray. Brush or roller don't grant an uniform coverage, use these techniques only on retouch or small surfaces.

**APPLICATION INSTRUCTIONS:**

| CONVENTIONAL SPRAY<br>LOW PRESSURE PUMP | | AIRLESS<br>AIRMIX | |
|---|---|---|---|
| Nozzle diameter (mm) | -÷- | Pressure ratio | **45:1** |
| Product pressure (Atm) | -÷- | Nozzle diameter (inch) | **0,017÷0,021** |
| Air pressure | -÷- | Product pressure (Atm) | **180,0÷250,0** |

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## TECHNICAL DATA:

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|---|---|
| Mechanism of hardening | **chemical reaction** |
| Specific weight (kg / l) * | **1,49 (±3%)** |
| Volume solids (%) * | **80 (±2%)** |
| Medium dry film thickness (microns) | **200** |
| Correspondence wet film thickness (microns) | **250** |
| Yield to the average or recommended thickness (m2 / kg) * | **4** |
| Consumption at the average or recommended thickness (Kg / m2) * | **0,25** |
| Touch dry at 25 ° C (min) | **120** |
| Recoat time min. recommended 25 ° C (hours) | **6** |
| Recoat time max. recommended 25 ° C (days) | **3** |
| Hard dry at 25 ° C (days) | **5** |
| Recommended application temperature (° C) | **+10 ~ +40** |
| Maximum operating temperature (° C) | **120** |
| Pot life at 25 ° (hours) | **2** |
| Mixing ratio by volume | **83,9%** |
| Mixing ratio by weight | **100%** |
| Thinner | **603.0000 o 606.0001** |
| Aspect of the film | **glossy** |
| Color | **On request** |
| Storage in suitable conditions (months) | **12** |

N.B.
* Data referred to colour ral 7046. The solid content values, specific weight and yield were calculated with theoretical method. Thickness and performance are indicative, in fact vary greatly depending condition of substrate, absorption, porosity, surface irregularities and application method. Data referred to the mixture of component A + 100% by weight of Comp.B

**ADDITIONAL INFORMATION:**

This is a two-component product. Before mixing the two components it is recommended to homogenize the component possibly with agitator and shake vigorously, possibly without opening, the packaging of component b. After mixing and addition of appropriate thinner, agitation should be continued until it became homogeneous. In order to use the correct mix ratio, necessary to obtain the best results, we recommend to catalyse only entire packs. In case you want to use only a portion of the pack, you should equip with adequate precision scale for catalysis by weight and appropriate sized containers for catalysis by volume. The pot life (time of use after catalysis) is significantly reduced by increase of temperature. Ambient temperature has influence on curing time which, under 10° C is extended considerably. Epoxy products are not suitable to use at low temperatures (typically under 5-8° C), except through the use of a specific catalyst (winter grade). The temperature of the surface to be treated must be at least 3° C higher than the ambient temperature. If this condition is not met the resulting condensation, not always visible, may easily lead to phenomena of non-adherence. The coating requires a period of 7-15 days at 25° C for complete curing. The over-coating should be performed preferably within two days. After this time, to ensure a secure adhesion of additional coats is recommended to abrade with steel wool or fine sandpaper. As is widely known, the UV rays are able to cause the surface chalking of epoxy coatings causing an aesthetics alteration, which however does not compromise in any way the performance. Carefully remove any accumulated roughness prior to the application of subsequent coats. It is recommended to implement all necessary measures (development of equipment for painting, using any thinner retardant-wetting thinner, position yourself upwind, proper progression of the surfaces to be painted) to prevent the accumulation of dust coating, which often causes inhomogeneity of the film. This product, when used as a primer can be recoated with acrylic, polyurethane and epoxy products.

**IMPORTANT NOTE**