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PRODUCT DATA SHEET

PRODUCT: **EPOPAINT OPACO**
Two-component epoxy polyamide finish

CODE: **COMP. A 302 EPOPAINT OPACO**
COMP. B 9000002 - CAT EPOX STD 02

PRODUCT DESCRIPTION:

Two-component high quality epoxy finish for general use. It has high chemical resistance to saline, acidic or basic solutions (not concentrated), lubricating oils, diesel fuel, detergents, fertilizers. Good mechanical performance, impact resistance, scratch and abrasion. It has excellent adhesion to all metal substrates, hot dip galvanized surfaces, aluminum or other light alloys. The area of application is manifold shipbuilding (topside), chemical and industrial plants, agricultural equipment, concrete plants and chassis. Not suitable for immersion service and/or continuous contact with concentrated acid or basic substances.

SURFACE PREPARATION:

Usually the product is applied on surfaces already primed, rigorously dry, clean, perfectly free of oil, grease, dust, moisture or other contaminants. However, it is possible to apply the product directly on metal. If required the product is suitable for galvanized surfaces after degreasing and removal of any zinc salts.

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 LOW PRESSURE PUMP	AIRLESS AIRMIX	
Nozzle diameter (mm)	1,5÷2,0	Pressure ratio	28:1
Product pressure (Atm)	0,8÷1,7	Nozzle diameter (inch)	0,015÷0,019
Air pressure	2,5÷4,0	Product pressure (Atm)	160,0÷220,0



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TECHNICAL DATA:

	Evaporation of the solvent and chemical reaction
Mechanism of hardening	
Specific weight (kg / l) *	1,3 (±8%)
Volume solids (%) *	51 (±1%)
Medium dry film thickness (microns)	50
Correspondence wet film thickness (microns)	99
Yield to the average or recommended thickness (m ² / kg) *	7,9
Consumption at the average or recommended thickness (Kg / m ²) *	0,1
Touch dry at 25 ° C (min)	60
Recoat time min. recommended 25 ° C (hours)	8
Recoat time max. recommended 25 ° C (days)	2
Hard dry at 25 ° C (days)	8
Recommended application temperature (° C)	+10 ~ +35
Maximum operating temperature (° C)	102
Pot life at 25 ° (hours)	8
Mixing ratio by weight	20%
Thinner	603.0000
Aspect of the film	 matt
Color	On request
Storage in suitable conditions (months)	12

N.B.

* Data referred to colour white. The solid content values, specific weight and yield were calculated with theoretical method. Thickness and performance are only indicative, in fact vary greatly depending condition of substrate, dilution, absorption, porosity, surface irregularities and application method. Data referred to the mixture of component A + 20% by weight of Comp.B



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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 dew point. 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 if not removed causes inhomogeneity of the film.

IMPORTANT NOTE

All information contained in this form are the result of laboratory tests carried out under controlled conditions and well-defined and / or correspond to our most advanced and current technical and practical knowledge. this does not exempt the customer, given the variability of environmental conditions and personal systems of application, from carrying out their own investigations and to make their own eligibility checks. Mondial Color assumes no responsibility for any damage caused by improper use of the product. This sheet supersedes the previous editions.