

FERROCOTE

High Solids Modified Epoxy

DEFINITION

Two components, high solids, primer or intermediate epoxy paint, with fast drying properties; pigmented with zinc phosphate.

TECHNICAL DATA

NUMBER OF COMPONENTS	2
GLOSS LEVEL	Satin
COLOURS	Grey, red-brown; please contact us for other colours
MIXING RATIO	weight : 89,7/10,3 volume : 85/15
SPECIFIC GRAVITY	1,57 +/- 0,05 g/cm ³
SOLIDS CONTENT	weight : 88,0 +/- 2% volume : 80,0 +/- 3%
TYPICAL THICKNESS (DRY)	140 µm
RECOMMENDED WET FILM THICKNESS	175 µm
THEORETICAL SPREADING RATE	5,7 m ² /l for 140 µm dry
AFNOR RATING NFT 36 005	Family I Class 6b
VOC (Directive 2004/42/EC)	Cat. A/j : 500 g/L (2010) 320 g/L VOC
PACKAGING	15L

Specific gravity, solid content by volume and by weight are given for mix A+B, without thinner and on the white base for all topcoat. Liquid characteristics of products are given at 20°C.

COMPATIBILITY

PREVIOUS COAT(S)*	SUBSEQUENT(S) COAT(S)*
Itself EPODUX PRIMER 61-134 v01 range of EPODUX ZINC PRIMODUX H v01 EPODUX BR 100 ...	Itself POLYSTRIA v01 POLYSTRIA HES FERROTHANE ...

*For any product not mentioned in compatibility lists, contact our technical support.

DRYING TIME - OVERCOATING INTERVAL

FILM THICKNESS 140 µm dry	POT LIFE	DRYING TIME		OVERCOATING INTERVAL	
		Touch dry	Hard dry	Minimum	Maximum
10°C	3 hours	12 hours	24 hours	36 hours	12 months
20°C	1 hour 30	6 hours	12 hours	24 hours	12 months
30°C	1 hour	3 hours	8 hours	12 hours	12 months

Introduce thinner may affect pot life. Dilution, relative humidity and aeration could affect drying time.

FERROCOTE

INSTRUCTIONS

All surfaces must be clean, dry and contamination-free before painting.

SURFACE PREPARATION

SUBSTRATE(S) :	MINIMUM	RECOMMENDED
Carbon steel	Degreasing + St 2 (ISO 8501-1)	Sa 2½ (ISO 8501-1); Medium Grit (ISO 8503-2; Ra 10-12,5µm)
Old paint*	Compatible coating intact and adherent. Washing High Pressure + Pst 2 (ISO 8501-1)	Compatible coating intact and adherent. PSa 2½ (ISO 8501-1)

*An appropriate test (application and adhesion test after drying) is recommended to ensure product compatibility.

APPLICATION CONDITIONS

MIXING	The product is supplied in pre-measured kit form. Pour the hardener part into the base tub and mix, taking care not to incorporate air. The mixing temperature should be at least 10°C. If not, it is necessary to add thinner to get the application viscosity. N.B. excess thinner increases the risk of sagging.				
INDUCTION TIME	None				
WEATHER CONDITIONS	Room temperature : The temperature should be between 5°C and 40°C Relative humidity : 85% maximum				
TEMPERATURE	Of substrate : Between and +5°C and +40°C and must be at least 3°C higher than the dew point in order to eliminate any risk of condensation. Of product : Between and 10°C and 35°C				
TECHNICAL NOTE	Do not leave paint in spray equipment for longer than the pot life. Rinse equipment with 67-232 v02 thinner then clean it carefully with cleaning solvent. Prepared mix that is not used should not be sealed hermetically. For an extended stop, it is better to prepare a new kit.				

Early exposure to condensation or rain could provide a change of gloss and/or shade.

APPLICATION

APPLICATION EQUIPMENT	DILUTION*	NOZZLE	PRESSURE AT NOZZLE	MINIMUM PUMP RATIO	REMARKS
AIRLESS SPRAY	5 to 10 %	0.019 -0.021 (inches)	250-300 bars	60 : 1	-
AIR SPRAY CONVENTIONAL	-	-	-	-	Not advised.
BRUSH	0 to 10 %	-	-	-	-
ROLLER	0 to 10 %	-	-	-	-
THINNER	67-232 v02		CLEANING SOLVENT	67-232 v02	-

* Dilution rate % are indicative and should be adapted to atmospheric conditions and site specific conditions. Excess of thinner could involve sagging effect and lost of opacity.

Remark(s)

(1) The properties of the coating, apart from its appearance, are not affected by exposure to actinic radiation.

HEALTH AND SAFETY

Flash point	: BASE between 23°C and 55°C : HARDENER greater than 61°C
Shelf life	: DLUO : 3 years minimum in original full, sealed packaging . Store in a cool, ventilated place.
Precautions	: Refer to the current material safety data sheet(SDS).
Transport and labelling	: Refer to SDS according to European directives.
Waste Management	: Soiled Industrial wastes. For more information, please refer to SDS.