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INDUSTRIAL COATINGS

Rev. 18.05.2012

EPOXY PAINT VHB ST ALLUMINIUM, reference 7033011

Description and main features

Two pack product very high build Surface Tolerant formulated with special epoxy resins, to reticulate with amino/amine catalyst, and pigments with barrier effect based on micaceous iron oxide and zinc phosphate: Epoxy paint ST aluminum ensured an excellent adhesion on steel, galvanized steel, and after control on most other metals .Its perfect where sand blasting is difficult because of a remarkable wet ability. Can be apply with high thickness with low contain of solvent even with high humidity and low temperature. Can be used as finishing coat when esthetical appearance is not important. Epoxy ST Paint aluminium has high resistance to chemical aggressive, particularly acids and bases, typical of epoxy systems. Resist also, after control, to most part of hydraulic oils, emulsified and for converters till temperature of 120°C.
Can be used for:
with catalyst epoxy 471/hp, reference 701471 or catalyst epoxy 471/hp AS conc., reference 701477 as **primer** for painting new structures on sandblasted steel SA 2½ or hot galvanized steel , showing high resistance to saline fog test and continuous condensation : as **intermediate coat** on zinc primer ,or to **remake** structures almost painted and painting of new structures where painting is difficult , showing always excellent adhesion on most part of supports.

Technical data

Finish	Satin (*)
Color	Aluminum about. RAL 9006. other colors on demand (*) (**)
Specific weight	1,38 ± 0,05 kg/dm^3 at 23°C referring to catalyzed product with 701471 or 701477 according to norm ISO 2811-1 (*)
Solid content	**By weight** 85% ± 3 referring to catalyzed product with 701471 or 701477 (*)
	By volume 76 % ± 3 referring to catalyzed product with 701471 or 701477 (*)
VOC	150 g/kg referring to catalyzed product with 701477 (*)
Viscosity	Brookfield on first component at 23°C (spindle 5, 0.5 RPM) : superior 300.000 mPas according to internal method MS 007 (*) (**)
Drying time	*At 23°C, 50% of relative humidity and good ventilation to thickness of dry film of 150 µm* **With 701471-701477** **Touch dry**: 8 h **Hard dry:** 24 h

	Touch dry: according to internal method *MS 035* based on *ISO 4622* *Hard dry:* according to internal method MS 036 based on ISO 4622 (*)
	Drying times can vary depending on DFT and environmental conditions

Mixing and thinning

Mixing ratio	**By weight:** 100:20 with 701471 100:16 with 701477 **By volume**: 3,2:1 with 701471 4:1 with 701477 *Mix carefully before and after the curing process*
Pot life	8 h at 20°C *Data vary with temperature and thinning.*
Thinning	5-10% with 900033 or 901040 wintry 5-10% with 903015 or 901042 summery 5-10% with 903014 slow or when used as intermediate or on zinc. *Chose the thinner according to the environmental and application conditions in order to allow at least 5-10' drying time.*

Application data

Application	Airless or air mix *for brush or roller application, specific curing agent and thinners must be used.*	
Airless or air-mix	**Pump ration**	45:1
	Nozzle orifice	015-017"
	Nozzle pressure	140-180 atm
	Filters must fit the used nozzle.	
	Indicative data; it is the user's responsibility to chose the right equipment	
Suggested Primers	Auto-primer. Can be applied on inorganic zinc references 706205-760210 or epoxy zinc references 706176 - 706192.	
Suggested Top coats	retron acrilycs series 773.000-777.000-778.000 or epoxy finishing 700.000-702.000	

Application conditions	Application suggested between 0°C and 30°C and at least 3°C above dew point. Substrate perfectly dry and clean, no rain nor fog. A sandblasting to SA 2 ½ according to ISO 8501-1: 1988 ensures the best performance in terms of salt fog resistance. When used on top of old alkyd paints, a mechanical cleaning of the surface (PSt2 according to ISO 8501-2) is recommended. The product can be over coated between 1 and 7 days from the application, at 20°C, 50% RH, and good ventilation. After 7 days and up to 3 months a careful cleaning is needed before over coating. After 3 months a surface roughening is needed before over coating.

Recommended DFT

Recommended DFT	100-200 µm by coat
Theoretical consumption	About 182-363 g/m² catalyzed with 701471 or 701477 (*)
Practical spreading rate	40-50% less according to shape of support , over spray and difficulty to have an homogeneous thickness .
Number of coats	One or two

Specific tests

Salt spray test according to ISO 9227:2006
Steel samples coated by Epox ST 7033011 cured with 701471 showed no defects after > 1000 h.

Continuous condensation test according to ISO 6270
Steel samples coated by Epox ST 7033011 cured with 701471 showed no defects after > 1000 h.

Storage indications

Shelf life: 12 months (base only: 18 months), provided the cans are kept sealed and undamaged, into a **cool and dry place with temperature between 5 and 35°C.**

Usability according to DL 27.03.2006 n°161

No limitations. It belongs to category **j)** Two component, high performance solvent based paints.
2010 limit = 500 g/l
(*) indicative value, depending on the color - (**) parameters subject to testing for each batch

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