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INDUSTRIAL COATINGS

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Semi-gloss Epoxy Enamel, series 702.000

Description and main features

Two pack polyamide epoxy enamel.

Good wetting properties, high chemical and physical strength. Abrasion resistant and very high adhesion on concrete as well. Suitable to contact with most of the hydraulic oils. The application on wet surfaces or in cold environment is not recommended.

Recommended use: as a finish coat on top of an epoxy primer; it can be also applied on bare steel and, further to testing to ensure adhesion, on other metals. Indoor use is suggested to avoid chalking.

Technical data

Finish	Semi-gloss, 40-50 gloss, according to ISO 2813 (*) (**)
Color	RAL shades - Other shades on request (*) (**)
Specific gravity	1,49 ± 0,05 kg/dm ³ at 23°C, referring to 702020 RAL 7035 cured with 701455- according to ISO 2811-1 (*)
Solid content	By weight 72 ± 3% referring to 702020 RAL 7035 cured with 701455 (*)
	By volume 54 ± 3% referring to 702020 RAL 7035 cured with 701455 (*)
VOC	280 g/kg referring to 702020 RAL 7035 cured with 701455 (*)
Viscosity	Brookfield on the base at 23°C (spindle 4, 0.5 RPM) : 80.000-150.000 mPas according to internal method MS 007 (*) (**)
Drying time	At 23°C ,50% RH, good ventilation, DFT 70 µm, referring to 702020 RAL 7035 cured with 701455 (*)
	Touch dry: 10 h according to internal method MS 035 based on ISO 4622 Hard dry: 48 h according to internal method MS 036 based on ISO 4622 (*)
	<i>Drying times can vary depending on DFT and environmental conditions</i>

Mixing and thinning

Mixing Ratio	By weight: 100:20 with 701455 By volume: 2,7:1 with 701455 <i>Mix carefully before and after the curing process</i>
Pot life	> 8 h at 20°C - <i>Data vary with temperature and thinning.</i>
Thinning	10-15% by Thinner 900033 or 901040 winter type 10-15% by Thinner 903015 or 901042 summer type 10-15% by Thinner 903014 slow <i>Chose the thinner according to the environmental and application conditions in order to allow at least 5-10' drying time.</i>



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Application data

Method	Airless or air mix <i>Roller or brush application not recommended for metallic shades; for other shades specific curing agent and thinners must be used.</i>	
Airless or air mix	Pump ratio	30:1
	Nozzle orifice	013-015"
	Nozzle pressure	140-180 atm
	<i>Filters must fit the used nozzle.</i>	
<i>Indicative data; it is the user's responsibility to choose the right equipment.</i>		
Suggested Primers	Epoxy series 706.000, series 703.000 or series 7073.000, Vinyl Epoxy series 704.000, Intermediate Epoxy series 706.250,706.300 AR, 703.000 or 7073.000, Intermediate Vinyl Epoxy series 706800 .	
Application conditions	Application suggested between 5°C and 30°C and at least 3°C above dew point. Substrate perfectly dry and clean, no rain nor fog. Temperatures below 5°C and high RH can impair the film formation. The product can be over coated by itself between 12 and 72 h from the application, at 20°C, 50% RH, and good ventilation. After 72 h a surface roughening and a careful cleaning are needed before over coating. Data vary with DFT and environmental conditions	

Recommended DFT

Recommended DFT	60-80 µm
Theoretical consumption	approx. 165-220 g/m ² referring to 702020 RAL 7035 cured with 701455 (*)
Practical spreading rate	30-40% lower than the theoretical, by airless application.
Number of coats	ONE <i>Some very clear shades such as RAL 1021-2004-3020 etc. may require two coats to achieve an even coverage, mostly on dark primers and uneven surfaces.</i>

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



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(*) indicative value, depending on the color - (**) parameters subject to testing for each batch

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