ROPOXY COVER FINISH 637

Description

Two component high build poly amine cured epoxy finish.

Principal Characteristics

- Epoxy finish for steel and concrete structures.
- For atmospheric exposure.
- Easy to apply by spray, roller or brush.
- General purpose epoxy finish in protective coating systems for steel metals to be used in immersion and atmospheric exposures.
- Suitable long pot life for tropical conditions
- Good water resistance
- Resistant to splash and spillage of mild chemicals and solvents
- Good adhesion properties on steel and concrete structures.
- Suitable on wet blast cleaned substrates.

Technical data

Color & gloss	As the customer request / semi-gloss.
Flash point (DIN 53213)	Base 27 ºC hardener 28 ºC.
Mass density	Approx. 1.23 gm. / cm3
Solid content	Approx. 88 % ± 2 by volume
Theoretical spreading rate	10.8 m2/ltr for 100 microns D.F.T.
	8.8 m2/ kg for 100 microns D.F.T.
Touch dry after	Approx. 1 - 2 hours
Recommended dry film thickness	50 – 100 um (per one coat)
Over coating interval	Min. 10 hours. (at 25 ºC & 60 % R.H.)
	max. 3 months. (at 25 ºC & 60 % R.H.)

Full cure after 7 days

Shelf life(cool and dry place) At least 12 months in original containers.

Recommended substrate conditions:

- Previous coat of Ropoxy sealer 656 within over coating interval and free from any contamination.
- If the over coating interval has been exceeded, the previous coat should be roughened up.

Instruction for use

Mixing ratio by weight: base to hardener **3 : 1**

- the temperature of the mixed base and hardener should be above 15 ºC other wise.
- Extra solvent may be required to obtain application viscosity.
- Too much solvent results in lower sag resistance and slower cure.
- Thinner should be only added after proper mixing of the base and hardener.

Recommended thinner Roots thinner No. RO10455 (flash point 26 °C)

Airless spray

Volume of thinner 0 - 5 % depending on required D.F.T.

Nozzle orifice approx. 0.48 mm (= 0.019 inch)

Nozzle pressure 0.5 MPa (= Approx. 150 at; 2100 p.s.i)

Air spray

Volume of thinner 5-10 % depending on required D.F.T.

Nozzle orifice 1.5 – 3 mm

Nozzle pressure 0.3 – 0.4 MPa (= Approx. 3-4 at; 43-57 p.s.i)

Brush / Roller

Volume of thinner 0-5 %

Cleaning solvent Roots thinner No. RO1003 (flash point 26 °C)

Additional data

Film thickness and spreading rate

theoretical spreading rate m2/ltr	10.6	7	5.3
dft in um	50	75	100

Max. dft without sagging with airless spray : 150 um

Min. dft for closed film with airless spray : 50 um

Max. dft when brushing : 50 um

Over coating table with Epoxy paint

Substrate temperature	20 ºC	30 ºC	40 ºC
min interval	10 hrs.	8 hrs.	6 hrs.
max interval	3 months	2 months	1 month

Curing table

Substrate temperature	**Dry to handle**	**Full cured**
20 ºC	10 hrs.	4 days
30 ºC	7 hrs.	3 days
40 ºC	5 hrs.	2 days

Pot life (at application viscosity)

20 ºC	8 hrs.	The figures are valid for quantities of 5 liters approx.
30 ºC	6 hrs.	
40 ºC	4 hrs.	