ROPOXY FINISH 622

Description

Two component general purpose poly amide 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 structures.
- Suitable on wet blast cleaned flooring substrates**.**

Technical data

Color & gloss	As the customer request / high gloss.
Flash point (DIN 53213)	Base 27 ºC hardener 28 ºC.
Mass density	Approx. 1.12 gm. / cm3
Solid content	Approx. 56 % ± 2 by volume
Theoretical spreading rate	12.5 m2/ltr for 50 microns D.F.T.
	11.2 m2/ kg for 50 microns D.F.T.
Touch dry after	Approx. 3 - 4 hours
D.F.T	50 – 75 ums (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 primer 621 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

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mixing ratio : by weight: base to hardener 4 : 1

the temperature of the mixed base and hardener should be above 15 ºC otherwise 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.

Pot life at 20 ºC	8 hours
Recommended thinner	Roots thinner No. RO 10455 (flash point 26 °C)

<u>Airless spray</u>

Volume of thinner	0-5 % depending on required D.F.T.
Nozzle orifice	approx. 0.48 mm(= 0.019 inch)
Nozzle pressure	05 MPa (= Approx. 150 at ; 2100 p.s.i)
Cleaning solvent	Roots thinner No. RO1003 (flash point 26 °C)

<u>Air spray</u>

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	12.5	8.3	6.25
dft	um	50	75	100

* Max. dft without sagging with airless spray : 100 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 hours	8 hours	6 hours
max interval	3 months	2 months	1 month

Over coating table with Polyurethane paint

substrate temperature	20 ºC	30 ºC	40 ºC
min interval	24 hours	16 hours	12 hours
max interval	3 months	2 months	1 month

Curing table

substrate temperature	Dry to handle	full cure handle
20 ºC.	10 hours	4 days
30 ºC.	7 hours	3 days
40 ºC .	5 hours	2 days

Pot life (at application viscosity)

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