ROPOXY FINISH HB 606

Description

two component general purpose **high build** 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 / semi-gloss.
Flash point (DIN 53213)	: Base 27 ºC hardener 28 ºC.
Mass density	: Approx. 1.29 gm / cm3
Solid content	: Approx. 66.5 % ± 2 by volume
Theoretical spreading rate	: 4.4 m2/ltr for 200 microns D.F.T.
	: 3.4 m2/ kg for 200 microns D.F.T.
Touch dry after	: Approx. 3 - 4 hours
D.F.T	: 100 – 200 ums (per one coat) without sagging
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

mixing ratio : by weight: base to hardener **5 : 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 C : 8 hours

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 : 05 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

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.