ROPOXY HB 640

Product Description & Uses :

two component high solid polyamine cured epoxy coating used for tank coating, build coat for underwater and marine purposes .

Ropoxy HB is an excellent chemical resistant against a wide range of chemicals, excellent impact and abrasion resistance .

White colors used for solid food.

Surface Preparation : New steel *:* blast clean to ISO Sa 2.5 , previous coat dry and free from any contamination .

Physical Properties:

Colors	light shade.
Gloss	Semi-gloss
Flash point	base 27 ^{o}C - hardener 29 ^{o}C
Product Density	1.4 g/cm^{3} approx.
Volume Solids %	78 ± 2 % Approx.
Theoretical spreading rate	4 m^{2} / L (200 um D.F.T)
Touch dry	2 - 3 hour approx.
Recommended D.F.T	150 – 200 ums.
Full Cure	7 days
Shelf Life	12 months at least. (at the original containers)

Application Data :

Mixing Ratio Base to Hardener	15.2 - 4.8 (by volume)
Pot life at 20 ^{o}C	1.5 hours at 20 ^{o}C.

Recommended Thinner	Roots thinner No. RO10455 (flash point 26 °C)
Induction Time	5 min. at 25 ^{o}C
Over coating interval	Min. 16 hours at 20 ^{o}C max. one month

Application Method & Delusion:

Brush & Roller	Solvent required 0 – 5 % .
Airless Spray	Solvent required 0 – 5 % .
Air Spray	Solvent required 5 – 10 % .

This quantity depend on the DFT required for the system .

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

N.B : Spray Data :

Set.	Nozzle Orifice.	Nozzle Pressure
Airless Spray	0.48 mm (0.019 inch)	150 atm.
Air Spray	1.5 - 3.00 mm	3 - 4 atm.