

SERIES 6310.0000 EPOXY ENAMEL – CATALYST 9410.0209
Uses

For industry maintenance especially if subject to irregular and permanent chemical type of aggression. Used to paint: machinery, plants, pipelines, stationary casings, containers, etc. of chemical industry.

General features

Finishing product with two components with polyamides hardener , with:

- High chemical resistance to: saline solutions, demineralized and sea water, thinned acids, alkali, solvents at room temperature.
- Excellent adhesion on sandblasted iron or, better, on epoxy primer,
- High gloss,
- Resistance up to 120° C,
- High mechanic quality as hardness, elasticity, toughness.

Technical data

Viscosity (Ford cup 8/20° C)	sec.	11 +/- 2
Specific weigh	kg/ltr	1,200 +/- 0,100
Solids content in weight (after catalysis)	%	61 +/- 2
Solids content in volume (after catalysis)		46 +/- 2
Optimal film thickness	micron	35-45 (each hand)
Theoretical spreading rate	sq.m./ltr.	8 – 9(at thickness indicated)
Adhesion (cross out adhesion test)	%	100%
Film appearance	gloss	95-98 (shine)
Thinner	Item	9310.0009
Dust free	minutes	60 at 18° C
Touch dry	hours	8 – 10
Dry in depth	hours	24-36

Application modalities

Catalysis Ratio	6310.0000 9410.0209	100 parts in weight 50 parts in weight
Pot-life hours	Hours	10-12 at 20°C
By spray	To dilute with	9310.0009 at maximum 10%
Spray gun	Nozzle size Pressure	mm. 1,5 - 1,8 Atm. 3 - 4
Airless	Nozzle size pressure compression ratio	0,013 - 0,019 inches 120 - 160 kg/cm ² 30 ÷ 1

Indicative cycles:

1°) - Sandblast surfaces at SA degree-2,5 of Swedish SIS norms.

2°) - Application, the soonest possible with Epoxy antirust zinc phosphate based Item n° 6120.0010 catalyse with 20% of 9410.0209 or Epoxy Antirust metal zinc based Item n° 6120.0015 catalysed with 10% of 9410.0209.

After 24 hours, apply Epoxy enamel in one or more hands leaving 24 hours between each hand.

Notes

The product, if applied externally can become yellow and loose its shine. But the barrier film quality will always be excellent even for years. If the final appearance is important, as final coat in the painting system we advise to apply the non-yellowing Polidur Enamel Item n° 6430.0000 (See relative technical instructions).

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