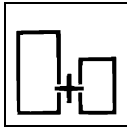
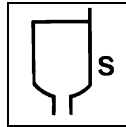


29170 - EPODUR



1000 ml +
200 ml +
200-250 ml

Pot life at 20° C :
7 hours



20° DIN 4
at 20° C



Ø 1,4 mm
4 bar
HVLP:
Ø 1,3-1,4 mm
2-2,5 bar
N. of coats: 2-3



Air drying at 20° C
Tack free- handling:
5-6 h
through-drying:
48 h
Low baking at 60° C:
60 min.

DESCRIPTION

Two pack glossy epoxy-vinyl enamel.

USE

In industrial application suitable for any substrates, where very good chemical resistance, but no weather resistance, is required.

CHARACTERISTICS

- Very good hardness and adhesion. The product does not contain any anticorrosive pigments: on steel sheet protection is given by barrier layer effect.
- Excellent aggressive chemical agents resistance (mineral, vegetable and animal oils and fats, acids, alkalis, organic solvents in normal conditions, and low concentration).
- Excellent brightness.
- The product does not contain any anticorrosive pigments, therefore it gives steel a protection due to barrier-effect.

SUBSTRATE PREPARATION

Metallic substrates: apply one coat of EPOXY PRIMER. It is possible to apply directly EPODUR.
On **porous substrates** like **concrete** and **wood** apply a first impregnation coat of very diluted product.

APPLICATION

Spray application.

Mixing ratio

EPODUR (enamel)
29376 - 29377 EPODUR INDURITORE (hardener)
00516 EPODUR DILUENTE (thinner) or
00535 EPOFAN DILUENTE (thinner)

by weight and by volume

1000 parts
200 parts
200 - 250 parts

Pot life at 20 °C: 7 hours
Spray viscosity at 20 °C: 20° DIN 4
Ø Air cap: 1.4 mm; HVLP: 1.3 - 1.4 mm
Air pressure: 4 bar; HVLP: 2 - 2.5 bar
Number of coats: 2 - 3
Film thickness: 50 - 60 µ
Theoretical coverage: 1 l mixture = 8.5 - 9 m² at 50 µ

1 kg mixture = 7.5 - 8.5 m² at 50 μ
V.O.C. of the mixture ready for use: ~ 550 g/l

Brushing application is possible. The mixing ratio of EPODUR + Hardener is the same.
The quantity of the thinner has to be limited to 5 - 10%.

DRYING TIME

Air drying at 20°C

Dust-free: 30-40 min.
Handling: 5 - 6 hours
Through-drying: 48 hours

Low bake at 60°C:

60 min. (after 30 min. flash-off)

The complete hardening occurs in the following 3 - 4 days.
Low baking at temperatures over 50°C can cause a slight yellowing to white and very light colours.

OBSERVATIONS

It is important to consider that the drying temperature must be over 15 - 18°C.
At lower temperatures the drying time becomes too long and the cross-linking of the film remains incomplete with a reduced chemical resistance. In case of weather exposition (sun rays) the films of EPODUR (like all the epoxy films) may be chalking and light colours may be yellowing.
Besides the standard hardeners also an extra fast hardener – 29378 EPODUR INDURITORE RAPIDO INDUTSRIA – is available and must be used only for dark colours as it is yellowing.
Moreover the use of fast hardeners causes a reduction of pot-life times.
The product is usable with electrostatic units.

TECHNICAL DATA SHEET N° 0377-GB
UP DATED 11/2004

The information shown in these sheets is given in good faith as being true and although every effort of verification has been made before use, we cannot accept responsibility for any inaccuracy. THIS PRODUCT IS FOR THE PROFESSIONAL PAINTING OF ROAD VEHICLES BY QUALIFIED PERSONNEL