

TECHNICAL DATA SHEET

Date of issue: 30.06.2000

Last updating: 08.08.2014



SIRO S.r.l.

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Name:	GLOSSY EPOXY ENAMEL	Category:	high performances bicomponent paint
Definition:	Epoxy two pack top coat	V.O.C. limit:	500 g/l
Code:	21.1	V.O.C. ready to use:	500 g/l
Product according to 2004/42/CE			

NATURE OF THE PRODUCT

Two-pack epoxy-amino top coat to be mixed before use.

GENERAL USES

Product for general use on steel, zinc plated iron, aluminium, plastics, light alloys¹. Fit for coats of automatic machine tools and manufacturing machine. It can be used also as top coat in painting cycles for artefacts to be immersed. Not recommended for external use

APPLICATION METHOD

PREPARATION OF SURFACES

The cleaning of the application surface should be total and painstaking and it is a fundamental and necessary condition to obtain positive result of the painting cycle. The product shows direct adhesion on metals² without a previous primer application. Because of the big variety of substrates is always better to perform some preliminary tests before. Eventual suggested primers for this product are: Acrydur serie 69.3, Epofix serie 29.3, Basic 2 serie 69.4.

- Ferrous surfaces. SA2 1/2 sandblasting or very careful mechanical abrasion followed by degreasing using thinners, then proceed with the direct application of the product or, if preferred with the application of a primer and then the top coat.
- Aluminium. Chromate or phosphorous chromate treatment or in alternative sanding procedure followed by degreasing using thinners. Then proceed with the direct application of the product or, if preferred with the application of a primer and then the top coat.
- Galvanized sheet. Delicate sanding (with scotch brite paper) followed by degreasing using thinners. Then proceed with the direct application of the product or, if preferred with the application of a primer and then the top coat.

PREPARATION OF THE PRODUCT

	code	name	By Weight	By Volume
Component A	21.1	Epolux glossy	100 parts	100 parts
Component B	02.025	Eporex standard type	40 parts	50 parts
Component B	02.120 ³	Eporex standard type	30 parts	40 parts

Carefully mix until an even colour and consistency are obtained. Diluted with 10-15% of our thinner 07.006 (to obtain a viscosity of 22-26" Ford 4).

APPLICATION

Spray gun: nozzles of 1,8-2,2 mm. diameter and 1-2 atm. pressure.
Airless. nozzle 0,09 inches, 120-150 bar

¹ Given the variety of alloys on sale, we recommend carrying out a few preliminary adhesion tests.

² If it is necessary to improve the corrosion resistance of the painted artefact, we suggest to apply a primer.

³ With this hardner, depending on temperature and relative umidity, you can obtain a film with lover gloss level due to haze.

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Roller or brush: Only for small surfaces

TECHNICAL DATA

PRODUCT TYPE:	Two pack product		
FILM APPEARANCE (ASTM D 523):	glossy 85±5 gloss		
COLOURS:	By request (the binder .21.1.K1 has to be used in a ratio 75/25 with the tintometric system tinters)		
SPECIFIC WEIGHT (ISO 2811):	A+B: 1,25 kg/l (± 0,08)		
SUPPLY VISCOSITY (DIN 53211):	18"±3" Ford 8		
SOLID ON VOLUME:	48% (± 3%) A+B		
SOLIDS CONTENT:	62% (± 5%) A+B		
DRYING AT 20°C	- Dust dry:	30-40'	- Touch dry: 5-6 hours
	- Total hardening :	36 hours	- Forced drying ⁴ 45' at 60°C
	- Maximum chemical resistance: After 7 days		
RECOMMENDED COATS:	One crossed coat.		
THICKNESS⁵:	50-60 µm.		
THEORETIC YIELD⁶:	8 m ² /kg		
POT-LIFE AT 20°C:	8 hours at temperature of 20°C. At higher temperatures, pot-life decreases.		
SALT SPRAY TEST (ASTM B 117):	With a dry film of 50 µm on iron treated like above reported, 200 hours		
IMPACT TEST (ASTM D 2794):	direct 10-15 kg depending on the nature of the support.		
ADHESION (ASTM D 3359):	B=5, perfect if applied on surfaces treated like above reported.		
CHEM. RESIST.⁷ (UNI EN ISO 12720):	Hydrochloric acid-HCl solut. vote	4-3	7 days

⁴ Baking the product can change the final gloss result, it could result more matt, and also the final colour can result more yellow.

⁵ Considering a dry film.

⁶ The theoretical yield has been calculated for the thickness suggested and over plane and regular surfaces.

⁷ The quality of chemical resistance goes from a value of 5 (means optimum) to 1 (means not good). For further information please contact Siro's technical service.

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10%

Nitric acid-HNO ₃ solut. 10%	vote	2-1	7 days
Sulfuric acid-H ₂ SO ₄ solut. 10%	vote	2-1	7 days
Acetic acid solut. 10%	vote	2-1	7 days
Mix of NaCl 10%, Lactic acid 5%	vote	4-3	7 days
Synthetic sweat	vote	5	7 days
Hydrogen peroxide 35%	vote	1	7 days
Ammonia solut. 30%	vote	5	7 days
Sodium hydroxide solut. 10%	vote	4	7 days
Acetone	vote	5-4	7 days
Cyclohexanone	vote	2-1	7 days
Solvello 100	vote	5-4	7 days
Ethyl acetate	vote	5	7 days
Ethanol	vote	5-4	7 days
Synthetic oil	vote	5-4	7 days
Idraulic oil	vote	5	7 days
Transmission oil SAE 30	vote	5	7 days
Engine oil 15W40	vote	5	7 days

REPAINTING: Within 24 hours or, after the complete hardening of the film, it is better a light sanding before overcoating

STORAGE STABILITY: Two years in closed packs, in a cool, dry place, away from any sources of heat.