TECHNICAL DATA SHEET

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Date of issue: *20.06.2001*

Last updating:n°3 *12.11.2012*

Name:	**SEMIGLOSSY EPOXY ENAMEL**	**Category:**	**high performances bicomponent paint**
Definition:	**Epoxy two pack top coat**	**V.O.C. limit:**	**500 g/l**
Code:	**21.2**	**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 alloys[1]. Fit for coats of automatic machine tools and manufacturing machine. 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 metals[2] 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	21.2	Epolux semiglossy	100 parts	100 parts
Component B	02.120	Eporex standard type	20 parts	30 parts
Component B	02.150	Eporex rapid type	20 parts	30 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.

Roller or brush: Only for small surfaces

[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.

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TECHNICAL DATA

PRODUCT TYPE:	Two pack product			
FILM APPEARANCE (ASTM D 523):	semiglossy 70±5 gloss			
COLOURS:	By request (the binder .21.2.K2 has to be used in a ratio 80/20 with the tintometric system tinters)			
SPECIFIC WEIGHT (ISO 2811):	A+B: 1,30 kg/l (± 0,08)			
SUPPLY VISCOSITY (DIN 53211):	18"±3" Ford 8			
SOLID ON VOLUME:	51% (± 3%) A+B			
SOLIDS CONTENT:	67% (± 5%) A+B			
DRYING AT 20°C	- Dust dry:	30-40'	- Touch dry:	5-6 hours
	- Total hardening :	36 hours	- Forced drying[3]	45' at 60°C
	- Maximum chemical resistance:	After 7 days		
RECOMMENDED COATS:	One crossed coat.			
THICKNESS[4]:	50-60 µm.			
THEORETIC YIELD[5]:	8 m^2/kg			
POT-LIFE AT 20°C:	8 hours at temperature of 20°C. At higher temperat ures, 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 applyed on surfaces treated like above reported.			

CHEM. RESIST .[6] (UNI EN ISO 12720):

Hydrochloric acid-HCl 10%	solut. vote	4-3	7 days

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

[4] Considering a dry film.

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

[6] 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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	Nitric acid-HNO_3 solut. 10%	vote	2-1	7 days
	Sulfuric acid-H_2SO_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
	Cycloexanone	vote	2-1	7 days
	Solvesso 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.