

# TECHNICAL DATA SHEET

Date of issue: 21.07.2003

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|                                 |                   |                      |                                        |
|---------------------------------|-------------------|----------------------|----------------------------------------|
| Name:                           | WHITE VETRIFICANT | Category:            | High performances<br>bicomponent paint |
| Definition:                     | Epoxy enamel      | V.O.C. limit:        | 500 g/l                                |
| Code:                           | 24.1.90130        | V.O.C. ready to use: | 15 g/l                                 |
| Product according to 2004/42/CE |                   |                      |                                        |

## NATURE OF THE PRODUCT

Glossy top coat based on epoxy-amino compounds, solvent-free enamel.

## GENERAL USES

Top coat with high chemical resistance fit for the painting of tanks that are in contact also with food and alimentary liquids.

**Product according to CE 1935/2004 of 27/10/2004 for contact with food.**

## 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. This means that presence of grease and oils on the surfaces, is absolutely not allowed.

The product has direct adhesion on metals<sup>1</sup> 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: Epofix serie 29.3 cured 20% with 02.150

- 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 | 24.1.90130 | White Vetrificant       | 100 parts | 100 parts |
| Component B | 02.030     | Eporex epox<br>hardener | 33 parts  | 50 parts  |

Carefully mix until an even colour and consistency are obtained. No dilution is requested or maximum 5% dilution, for standard roller-brush application with epoxy thinner 07.006.

## APPLICATION

Spray gun: nozzles of 1,4-1,6 mm. diameter and 3-5 atm. pressure.

Airless. nozzle 0,09 inches, 120-150 bar

Brush/roller

<sup>1</sup> 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

**APPEARANCE (ASTM D 523):** Glossy (85±5 gloss).

**COLOURS:** *Only 24.1.90130 is according to the CE 1935/2004 (white color and produced by Siro by direct grinding). Others colors or paints of 24.1 series, formulated with the tintometer, are not compliant to the CE 1935/2004.*

**SPECIFIC WEIGHT (ISO 2811):** 1.47 ± 0.05 kg/l

**SUPPLY VISCOSITY :** 6000-9000 CPs

**SOLID ON VOLUME:** A + B 99 % (± 2%)

**SOLIDS CONTENT:** A + B 99 % (± 2%)

**DRYING AT 20°C** - Touch dry: 8-12 hours - Total hardening : 36-48 hours  
- Maximum chemical resistance: After 10 days

**RECOMMENDED COATS:** Two, with an interval of 10-12 hours.

**THICKNESS <sup>2</sup>:** 200/300 µm

**THEORETIC YIELD <sup>3</sup>:** 3-4 m<sup>2</sup>/kg. for each coat

**POT-LIFE AT 20°C:** 30' (for a 5 kg can.), with higher temperatures, the pot-life of the product decrease.

**ADHESION (ASTM D 3359):** B= 5 on surfaces treated like above reported.

**REPAINTING:** Within 8-12 hours. After complete hardening (24-48 hours), it is necessary to scratch before overcoat.

**STORAGE STABILITY:** Two year stored in closed packs, in a cool, dry place, away from any sources of heat. Keep to a temperature > 5°C

<sup>2</sup> Considering a dry film.

<sup>3</sup> The theoretical yield has been calculated for the thickness suggested and over plane and regular surfaces.