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EPOXY ENAMEL

PRODUCT DATA SHEET

A high quality two-pack polyamide cured epoxy coating for metallic, wood and masonry surfaces. It cures to a tough film with excellent adhesion and flexibility, good resistance to abrasion, salt, water, oil, grease, common solvents and provides excellent protection against corrosion and mild chemicals. **EPOXY ENAMEL** is an ideal choice for the protection of surfaces located in industrial marine and other highly corrosive environment.

THIS IS A TWO PACK SYSTEM. MIX THE TWO COMPONENTS THOROUGHLY BEFORE USE. DO NOT USE THE BLEND AFTER THE POT LIFE LIMIT.

USAGE

- On suitably primed mild steel, galvanised steel and aluminium surfaces.
- As a primer, intermediate and/or finishing coat on masonry surfaces where a fully washable finish is required and where colour is not of prime importance.
- As a primer, intermediate and/or finishing coat on wood.
- In mild to highly corrosive environment.
- For interior and exterior use.

EPOXY ENAMEL will yellow and chalk when exposed to direct sunlight. This chalking effect will not affect the integrity of the coating. To avoid colour change and chalking, **EPOXY ENAMEL** can be over-coated with **ACRYLINE FINISH**.

Note: -

Condensation or dew formation on metallic surfaces will result in poor adhesion and subsequent flaking of the paint. Avoid painting during early morning, late evening or during humid and wet periods.

For specialised application such as internal tank linings, permanent immersion and other specific conditions, please contact your supplier for advice on product selection.

PHYSICAL DATA

- **Finish :** Gloss
- **Colour :** Standard colours
- **Consistency :** Semi - viscous Liquid, mixed
- **Specific Gravity :** 1.1 - 1.5, mixed depending on colour
- **Volume Solids :** 58% (Approx.), mixed
- **Flash Point :** < 23 °C, closed cup
- **Hardener :** **EPOXY ENAMEL HARDENER.**
- **Mixing Ratio :** 4 parts BASE / 1 part HARDENER by volume
- **Pot Life :** 4 - 5 hours at 25°C depending on volume of mix
- **Shelf Life :** 12 months, kept in separate containers.
- **Packing :** 4 L, 1L

Paints should be stirred before use and occasionally whilst in use.
Contact your supplier for further information

APPLICATION

- **Surface preparation : Clean and Dry**
- **Application method:** Apply two to three coats by brush or solvent resistant roller. Low pressure or airless spray methods can also be used.
- **Dilution:** Mix base and hardener before thinning with **EPOXY THINNER**. Dilute as required for ease of application.
- **Spreading rate / Film thickness:** One litre of undiluted **EPOXY ENAMEL** can be applied at a spreading rate between 6 and 10 m² of surface in one coat; at this spreading rate the dry film thickness will vary between 95 and 58 microns on a completely smooth, non absorbent surface.
- **Drying time:** Dry to touch in approximately 4 hours. **EPOXY ENAMEL** can be over-coated after 6 to 8 hours dependent upon film thickness. It must however be over-coated within 4 days of its application. Best inter coat adhesion is obtained when the next coat is applied on a slightly tacky previous coat. Full cure will be achieved after approximately 7 days. After this stage, it is advisable to roughen the surface to promote inter coat adhesion. A clean surface is mandatory to ensure good inter coat adhesion.
- **Cleaning solvent: EPOXY THINNER.**
- **Preceding coat :**
 - ◇ On mild steel use **EPOXY ZINC PHOSPHATE OXIDE PRIMER**.
 - ◇ On galvanised steel use **METAL PRIMER GREY**.
 - ◇ On wood use **EPOXY Varnish CLEAR** or **EPOXY UNDERCOAT**.
 - ◇ On concrete or plaster use **EPOXY VARNISH** or **EPOXY UNDERCOAT**.
- **Subsequent coat: ACRYLINE FINISH** to prevent chalking and where colour retention is important. Alternatively no subsequent coat is required.

SAFETY

- **EPOXY ENAMEL** is flammable, keep away from ignition source. Do not smoke whilst using.
- Wear adequate protective equipment during application; remove splashes from skin with soap and water. In case of contact with eyes, rinse with ample water and seek medical advice if necessary.
- Ensure good ventilation during application and drying.
- Keep containers tightly closed and away from children.

MAINTENANCE

Surfaces prepared and painted according to specification will provide lasting protection and will facilitate maintenance. Carry out repairs as and when required and wash the surface occasionally; use mild detergent and light scrubbing to remove stains.

These recommendations are meant as a guide, no guarantee is implied since conditions of use, method of application and cleanliness of the substrate prior to painting are beyond our control.