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EPOXY SOLVENTLESS ENAMEL

PRODUCT DATA SHEET

EPOXY SOLVENTLESS ENAMEL is two pack solvent free cold curing epoxy paint. It cures to a hard and highly resistant coating which has good resistance to fresh water, crude oil, kerosene, molasses, and to abrasion.

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

USAGE

- As a heavy duty coating where colour is not important.
- As a primer, intermediate and/or finishing coat according to specifications.
- As a tank lining for hazardous materials.
- In confined spaces.
- On concrete, timber and steel.
- In mild to highly corrosive environment.

EPOXY SOLVENTLESS ENAMEL will yellow and chalk when exposed to direct sunlight. This chalking effect will matt down the film but will not affect the integrity of the coating. **EPOXY SOLVENTLESS ENAMEL** should not be applied directly on galvanised steel or on zinc metal treated surfaces.

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.

PHYSICAL DATA

- **Finish :** Gloss
- **Colour :** White, other colours on request
- **Consistency :** Viscous Liquid, mixed
- **Specific Gravity :** 1.27, (Approx.) mixed
- **Volume Solids :** 100% , mixed
- **Flash Point :** > 23 °C, closed cup
- **Hardener :** **EPOXY SOLVENTLESS ENAMEL HARDENER.**
- **Mixing Ratio :** 3 parts BASE / 1 part HARDENER by volume
- **Pot Life :** 15-20 minutes at 25°C. It is recommended not to mix more than 1 litre at a time.
- **Shelf Life :** 12 months, kept in separate containers.
- **Packing :** 4 L, 1

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

APPLICATION

- **Application method:** Apply one to two coats by brush or roller. Dilute 10% by volume for airless spray application. Apply to obtain a continuous, pin-hole free paint film. Due to the high consistency of the paint, a wavy paint film may be obtained on application by brush. Check or calculate the dry film thickness in order to confirm the number of coats required.
- **Dilution:** Not required, if necessary use **EPOXY THINNER**.
- **Spreading rate / Film thickness:** One litre of undiluted **EPOXY SOLVENTLESS ENAMEL** can be applied at a spreading rate between 6 and 8 m² of surface in one coat ; at this spreading rate the dry film thickness will vary between 150 and 125 microns on a completely smooth, non absorbent surface.
- **Drying time:** Dry to touch in approximately 2 hours at 25°C.
- **Recoating intervals :**

SURFACE TEMPERATURE	20 °C	25 °C	30 °C	40 °C
Dry film thickness, microns	150	150	150	150
Recoating interval , minimum	3 hours	2 hours	1½ hours	1 hour

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 :-**
As specified, alternatively:
 - ◇ 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 diluted **EPOXY VARNISH CLEAR**.
- **Subsequent coat:** **ACRYLIC FINISH** to prevent chalking and where colour retention is important. Alternatively a subsequent coat is not recommended.

SAFETY

- **EPOXY SOLVENTLESS 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.
- A complete Material Safety Data Sheet is available on request.

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.