

PRODUCT DATA SHEET

EPOX 61
Epoxy enamel

CHARACTERISTIC Epoxy-polyamide dual-component finishing, semi-glossy, drying at room temperature or forced air with excellent resistance to water, salts, alkalis; It is suitable for industrial and marine environments.

USE It can be used as a finish where high mechanical resistance to impact and abrasion are required, as well as good chemical resistance in painting machine tools, chemical plants, port facilities. Applied on epoxy intermediates it is ideal for the protection of works such as platforms, hulls of ships, chemical plants, storage tanks in particularly severe atmosphere.
It can be applied directly to galvanized supports properly treated.

PROPERTY OF THE PRODUCT	VALUE	METHOD
Specific weight (A+B)	1400-1500 g/l	
Application temperature	< +120 °C	
Flash point	25°C ± 2	
Solid by volume %	55 ± 2%	
Brilliance 60°	50-60	

SPECIFICATION DATA	VALUE	METHOD
Specific weight	1500-1600 g/l	Internal PF3
Pot-life	Max 6h	Internal PF7
Gloss	50-60	Internal PF6
Drying Time	Fully 20 h	Internal PF2

THICKNESS AND YIELD	Min.	Max	Recommended
Thickness of dry film, µm	40	80	60
Thickness of wet film, µm	73	146	109
Theoretical yield, m ² /l	13,7	6,8	9,2
Theoretical yield, m ² /kg	9,5	4,7	6,3

STORAGE Product is stable till one year as long as it is kept in original and unopened buckets at temperature between +5°C e +30°C.

COLOUR The range of colors can be chosen in shades of RAL. Between one production and the other, tint may be slightly different, it is therefore important to finish the job with the same batch.

PREPARATION OF SURFACE **General observation:** Surface must be dry and clean from any kind of oil, grease and salts.

Coated surface

With primer: it can be painted if the substrate is clean and free of dirt, oil, grease, and the application falls within the maximum re-coat time of the primer. If cleaning is required, perform pressure washing grade Wa 2 (surface free of oil, grease, salt, dirt).

With complete finishing coat: if undamaged compatible and non-chalky perform cleaning from any oil and grease with detergent, then run sanding surface followed by pressure washing to remove dust and salts.

Rusty coating: perform mechanical preparation St2 or St3 followed by pressure washing to remove oil, grease, dust and salt or sand blasting Sa2 or Sa2½; then

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restore the thickness of primer.
Localized maintenance: perform mechanical preparation St2 or St3 followed by pressure washing to remove oil, grease, dust and salt or sand blasting Sa2 or Sa2½. Round off the edges of the well anchored painting and restore the system in the original layers and thicknesses.

TOOLS

Conventional spray or airless (high temperature and humidity <40% is possible the formation of "dusting"), roller, brush (for small surfaces and profiles).

APPLICATION

Mix ratio in weight	100:25 by Induritore Multiepoxy
Mix ratio in volume	100:30 by Induritore Multiepoxy
Thinning	0-5% with Diluente S800
Application time at 23°C	Max 6 h
Application condition	+5°C +40°C >3°C at dew point Relative humidity: <70%
Application by airless	Nozzle pressure: 15 MPa (150 kp/cm ² , 2100 psi). Nozzle: 0,28 - 0,38 mm (0,011 - 0,018") Angle range: 40 - 80° Air pressure: Compression ratio 30:1 (pressure 150-180 kg/cm ²)
Application by conventional spray	Nozzle: 1,6 – 1,8 mm Angle range: 30 - 50° Air pressure: 3,5-4 kg/cm ²
Thinner for washing	Nitro NV5000

DRYING TIME

Dry time are purely indicative as it might be longer or shorter by keeping in consideration ventilation, humidity, thickness of the applied film. In over coating, best adhesion can be obtained when next application is done before catalysis is completed.

DTF 60 micron

Surface temperature	5°C	10°C	23°C	30°C
Out touch	2h	60'	45'	30'
Dry touch	16h	8h	6h	4h
Full catalysis	3 days	36h	20h	18h
Minimum time of over application	16h	8h	6h	4h

RECOMMENDED PRIMER

Epoxy.

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RECOMMENDED SYSTEM	Industrial and marine atmosphere.			
	Product	Coat	Wet Thickness	Dry thickness
	Epoxy zinc 2k	1	90	60
	Primer 40	1	109	60
	Epoxy 61	1	109	60
	Total	3	308	180

ALTERNATIVE SYSTEM	Product	Coat	Wet Thickness	Dry thickness
	Primer 40	1	127	70
	Epoxy 61	1	109	60
	Total	3	236	130

INSTRUCTIONS

To carry out the work in a proper way, it is needed to strictly follow the instructions for the preparation of the surfaces contained in the CAP Arreghini Books. The specification data and technical information have been calculated at +23°C with relative ambient humidity of 65%. In different conditions the data and the time intervals between the two phases of the above reported coating system may vary. This technical information is intended as a rough guide. However, because of the enormous variety of media and application conditions, it is essential to check the suitability of the product and test the effectiveness on a sample.