

EP89

0001

Epoxy paints

2K-Epoxy Topcoat Paint

Trade name / Product code	EP89 / 0001																
Material base	Epoxy resin																
Glossiness level	Glossy																
Hardener	ET02 ET05, ET27																
Thinner	S6300																
Hardening ratio Paint : hardener	7 : 1 parts by weight 4.5 : 1 parts by volume The paint should not be thinned before processing!																
Reaction time	10 minutes after processing.																
Pot life, 20 °C	ET02 - max. 4 hours ET05, ET27 - max. 4 hours <u>Processed mixture must NEVER be used after the lapse of the pot life (4 hours) and should not be mixed with a newly produced mix and vice versa!</u>																
Processing data	<p>Air spraying</p> <p>Thinner: S6300</p> <p>Application viscosity: 20 to 40 s / 4 mm cup DIN / 20 °C</p> <p>Jet: 1.3 - 1.6 mm</p> <p>Pressure: 3 - 5 bar</p> <p>Airless / airmix spraying</p> <p>Thinner: S6300</p> <p>Application viscosity: 25 to 80 s / 4 mm cup DIN / 20 °C</p> <p>Jet: 0.28 - 0.33 mm airless / E311, E411 airmix</p> <p>Pressure: 120 - 150 bar airless 80 - 120 bar / 1.8 - 2.2 bar airmix</p> <p>Roller, brush</p> <p>Thinner: S6300</p> <p>Application viscosity: 20 to 80 s / 4 mm cup DIN / 20 °C</p>																
Processing	<p>The minimum temperature of both the base and the hardener before processing should be 10 - 25 °C!</p> <p>Mix the paint thoroughly after opening the package. When using less than the whole package, weigh the pre-calculated quantity of paint (7 parts of base and 1 part of hardener by weight) or measure parts by volume using the appropriate rule (4.5 parts of base and 1 part of hardener by volume). After mixing both components thoroughly, thin the processed mixture to the viscosity value needed for the specific application with thinner S6300. It is recommended to apply the paint after 10 minutes of processing (reaction time).</p>																
Drying times at 20 °C Wet thickness 50 µm	<table border="0"> <tr> <td></td> <td>ET02</td> <td>ET05, ET27</td> </tr> <tr> <td>Dustproof / 20 °C:</td> <td>60 minutes</td> <td>40 minutes</td> </tr> <tr> <td>Touch dry / non-sticking / 20 °C:</td> <td>180 minutes</td> <td>60 minutes</td> </tr> <tr> <td>Workable / 20 °C:</td> <td>12 hours</td> <td>6 hours</td> </tr> <tr> <td>Final curing time / 20 °C:</td> <td>10 days</td> <td>7 days</td> </tr> </table> <p>The rate of cure and achieving the final properties vary depending on the climatic conditions and coat film thickness.</p>		ET02	ET05, ET27	Dustproof / 20 °C:	60 minutes	40 minutes	Touch dry / non-sticking / 20 °C:	180 minutes	60 minutes	Workable / 20 °C:	12 hours	6 hours	Final curing time / 20 °C:	10 days	7 days	
	ET02	ET05, ET27															
Dustproof / 20 °C:	60 minutes	40 minutes															
Touch dry / non-sticking / 20 °C:	180 minutes	60 minutes															
Workable / 20 °C:	12 hours	6 hours															
Final curing time / 20 °C:	10 days	7 days															



EP89

0001

Epoxy paints

2K-Epoxy Topcoat Paint

Technical data

Additional drying temperature:	max. 60 °C
Colours:	RAL, NCS
Supplier viscosity, 20 °C:	thixotropic
Density, base, 20 °C:	1.40 to 1.60 g/cm ³
Density, processed mix, 20 °C:	1.30 to 1.50 g/cm ³
Dry matter content, base:	approx. 73 % by weight
Dry matter content, processed mix:	approx. 70 % by weight approx. 59 % by volume
VOC content, base:	approx. 270 g/kg
VOC content, processed mix:	approx. 300 g/kg approx. 420 g/l
Total organic carbon TOC content, processed mix:	240 g/kg
Theoretical spreading rate:	
Dry film thickness 40 µm	9 to 11 m ² /kg
Consumption depends on object shape, surface roughness, and application technique and conditions.	

Maximum thinning to 500 g VOC in 1 l of processed and thinned mix

120 g S6300 per 1 kg of processed mix (both hardener ET02 and ET05, ET27).
To Regulation No. 415/2012 Coll.

Application data

Application conditions	
Air temperature:	+5 to +30 °C
Base and hardener temperature:	+10 to +25 °C
Object surface temperature:	min. 3 °C above dew point
Relative humidity of air:	max. 70 %
Number of coats:	1 - 2
Wet film thickness:	min. 75 µm recommended: 100 - 125 µm
Dry film thickness:	min. 40 µm recommended: 60 µm
The thickness of a coat applied in a single working step on a vertical surface depends on object shape, surface roughness, and application conditions.	
Overcoatability:	The paint can be overcoated with the same paint.
Second paint coat can be applied "wet on wet" after 40 - 80 minutes.	

Application

Top coats of metal products used especially in interiors. The paint provides excellent mechanical and chemical resistance and first-class adhesion to the substrate. Filler and top coats of concrete grounds. The paint can be used to coat mineral grounds and some plastics (making an adhesion test being advisable).

Surface preparation Steel

Metal surface treated with a suitable primer or undercoat.

Surface preparation Concrete

The concrete ground must be free from any surface damaged by corrosion by means of grinding or blasting. Concrete should be mature, at least 28 days old, cohesive, free from dust, grease, and other dirt. Residual volumetric humidity max. 4 %. The paint is not suitable for coating floated, glazed or cast-in-situ concrete grounds.

The ground is filled with a processed mix diluted 1 : 1 with S6300 thinner. After



EP89

0001

Epoxy paints

2K-Epoxy Topcoat Paint

Utility properties	<p>the filler coat has dried up, however at least after 3 hours, apply 1 to 3 top coats of the processed mix diluted with S6300 thinner according to the application method. The recoating interval between the coats is at least 12 hours.</p> <p>The cured coat is resistant to abrasion.</p> <p>Cross-cut test (steel): degree 0 to 1</p> <p>Temperature resistance:</p> <p>Long term: 90 °C</p> <p>Short term (max. 60 minutes, dry): 120 °C</p> <p>For more details please contact our technical department.</p>
Cleaning and maintenance	<p>The mixing and application tools should be cleaned as soon as possible with thinner C6000 or S6300.</p>
Packages	<p>1 kg to 200 kg metal packages as agreed.</p>
Shelf life	<p>Paint - 24 months; hardener - 6 months from the date of manufacture if kept in the original closed packages in a dry room, out of direct sunlight and at a temperature from +5 to +25 °C. The storage areas should meet all the conditions for storage of hazard class II combustibles.</p>
Documentation	<p>Technical Application Guide Material Safety Data Sheet</p>
Waste disposal	<p>Coating composition N 08 01 11 Waste paints Empty packages N 15 01 10 Packages containing residues of hazardous substances</p>
Disclaimer	<p>The product data provided in this Technical Application Guide results from the current level of production, laboratory and application tests. The manufacturer reserves the right to make revisions according to the state of development. As the product is used frequently beyond our control, we cannot guarantee anything else than the quality of the product as such. We are not liable for any mistakes occurring due to wrong application, application past the shelf life or improper storage.</p> <p>This document only provides non-binding information that has to be concretized by the end user for the specific product type. On no account this document supersedes the identification data of this product specified in the material safety data sheet.</p>
Date of issue	<p>19. 10. 2015</p>
Revision date	<p>18.01.2018</p>

Before starting works with this product, ALWAYS read thoroughly the relevant material safety data sheet and the material safety data sheets of the applicable hardener! Observe the safe handling and occupational safety instructions.

For more detailed information please contact our technical department.