

Technical Data Sheet

Industrial Finishes



PRODUCT NAME: 2 Pack Low VOC Epoxy Finishes

CODE NUMBER: 53000 RANGE

PRODUCT DESCRIPTION: Low VOC epoxy topcoats, formulated to take account of US and European environmental issues and pressures.

The range is not only low VOC, but has been formulated on lead free pigment systems and is aromatic hydrocarbon free.

APPROVALS / SPECIFICATIONS: Meets the performance requirements of several aerospace and industrial specifications.

PERFORMANCE/USE: After 7 days air curing, or force curing (typical 30 minutes @ 125°C), will pass:

- Heat Resistance: 48 hours @ 204°C (400°F)
- Heat Resistance: 100 hours @ 180°C (356°F)
- Hot oil: 8 hours in ASTM fluid 101 (ASTM D 471) at 177°C (350°F) showing no peeling or Softening
- Hot Lube Oil: 100 hours @ 150°C (302°F)
- Fuel Resistance: 4 hours in ASTM "fuel B" at room temperature: no peeling or softening
- Skydrol (hydraulic fluid) Resistance: up to 336 hours @ 70°C (160°F)
- Corrosion Resistance: >350 hours salt spray to ASTM B-117 (after 48 hours high temperature conditioning at 204°C (400°F))
- Cyclic Corrosion: 10 cycles of:- 4 hours @ 150°C (302°F) + 20 hours Salt spray to ASTM B-117
- Low Temperature Resistance: Will withstand temperatures down to -40°C

APPLICATION: **Surface Preparation:** Ensure all surfaces are clean and free from dirt and contaminants

Pre-Treatment: Can be applied directly to clean metals, but more usually applied over phosphated steels or conversion coating treated aluminium. For full performance, apply over 53-6500 chrome free anti-corrosive primer

Mixing Instructions: 2 component products: will require pre-mixing with 53-CAT standard Catalyst or 53-FASTCAT fast cure catalyst – refer to base component can label for mixing Ratio, as these can vary from colour to colour. Allow 15 minutes induction time, and re-stir before using.

Thinner/Reducer Addition: Thin as required with 5-10% 53-Reducer

Application: Apply by spray - compliant guns recommended. Refer to gun manufacturers Instructions regarding pressures etc.

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Application Specification: Refer to IPAS 433S-Ind

CURING:

Air Dry:	Standard Cat: Touch dry:- 2-3 hours Hard dry:- 16-24 hours
	Fast Cat: Touch dry:- 1-2 hours Hard dry:- 405 hours
Heat Cure:	Flash off: 30-45 minutes @ RT
	Cure: 90 mins @ 80°C
	30 mins @ 125°C

TECHNICAL PROPERTIES:

Viscosity:	70-75 seconds/ISO5 cup/23±2°C	Film Thickness:	Typical 30-40 microns
Supply Solids:	Base: 82-88% w/w dependent on colour Catalyst: 88% w/w Fast Cat: 85% w/w	Theoretical Coverage:	20-27.5 square metres per litre dependent on colour & film thickness
Flash Point:	≥22°C: ≤ 32°C	Thinner:	IP3-Reducer
Supply VOC:	Base: 160-200gm/litre dependent on colour Catalyst: 118 gm/litre Fast Cat: 146 gm/litre	Solvent / Clean-up:	IP3-Reducer or 40006
Mixed VOC:	150-175 gm/litre dependent on colour		
SG:	Base: 1.10-1.55 dependent on colour Catalyst: 0.987 Fast Cat: 0.978		

STORAGE:

Highly flammable liquid; store and use in accordance with the flammable liquid regulations.

Shelf Life: 12 months temperate; 6 months tropical.

Before use, refer to Product Safety Data Sheets.

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