

STOPCOAT 304

NATURE AND USE STOPCOAT 304 is an epoxy modified aluminium mastic, **surface tolerant**, formulated with polymeric plasticizers, zinc phosphates and iron oxide. Designed as primer / intermediate / semi-glossy top coat for steel, it is particularly suggested for the maintenance of plants and structures in aggressive environment.

It can be applied up to a dry film thickness of 200 µm per coat. Can be also applied on iron mechanically brushed or abraded when sandblasting is not possible, or on concrete substrate duly prepared.

TECHNICAL DATA **Protection from corrosion:** The application of one single coat provides a good protection to steel substrates.

Abrasion: Good resistance to abrasion and to mechanical damages.

Adhesion: Excellent on substrates correctly prepared.

Resistances:	Acid solutions	Good
	Alkaline solutions	Good
	Sea water	Excellent
	Deionised water	Good
	Marine atmosphere	Excellent
	Industrial atmosphere	Excellent
	Petrochemical atmosphere	Excellent

SUBSTRATE PREPARATION **Steel** Blast cleaning down to bare metal to SA 2,5 according to ISO 8501/1 with medium roughness profile 40-70 µm.

Substrates previously coated Wash with water / degrease Brushing ST3 prior to product application.

Oxidized substrates: Sandblasting SA1 / SA2 / brushing ST3 with grinding wheel for steel .

Concrete Application on dry, cleaned and seasoned substrate, free from possible contaminants and duly primed.

APPLICATION DETAILS **Mixing ratio (by weight):** 87 parts Base - 13 parts Hardener

Mixing ratio (by volume): 83 parts Base - 17 parts Hardener

Shelf life: Max. 18 months in the sealed original cans protected (Minimum temperature +5°C / Max. +40°C)

Colours: Available in various colours on demand (epoxy products lose brightness and tend to chalk if exposed outdoor).

Mixing method: Stir thoroughly Base and Hardener. Add slowly, always stirring, the hardener to the base. Go on stirring until a complete homogenization of the components is obtained. (Follow the same procedure also in case of thinning).

Conditions for application: Minimum temperature of the substrate +5 °C - max. +40°C.

Application temperature +3°C over the dew point.

Temperature of the product +20°C min.

Relative humidity 0 / 85 %

Thinning: 0 / 15 % Epothinner

Suggested thickness: 150 µm dry film thickness (wet film thickness about 175 / 180)

Min. 100 / Max. 200 µm

Method: Application by airless pump with compression ratio minimum 45:1

Nozzle 0.018 - 0.021 inches Pressure 160 - 180 Kg/cm².

Brush / Roller

Theoretical spreading rate: 5.9 m²/l – 4.1 m²/Kg at the suggested thickness

Theoretical consumption: 243 g/ m²

Drying at +25°C: Touch dry 2 / 4 h. Handling 24/36 h

Over-coating (+25°C) : 24 / 36 h (after 48-72 h we recommend a light sandpapering).

Total solids by volume: 85 +/- 2 %

Total solids by weight: 91 +/- 2 %

V.O.C.: 130 +/- 10 (referred to the colour)

Specific gravity (average mixed): 1.45 +/- 0.05

Pot life: ≥ 6 h at +20°C

HANDLING

Provide a suitable ventilation during the use. Avoid skin contact using gloves, protective creams and masks.

STORAGE

Refer to Material Safety Data Sheet.

AND SAFETY

Product for professional use only and exclusively for the uses not regulated under CE Directive 2004/42/CE.

MTDS 04012/1

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