

STOPCOAT 308

Code: Base 59085 – Hardener 59086

NATURE AND USE STOPCOAT 308 is an epoxy-polyamide zinc phosphates and micaceous iron oxide based product, which can be recoated within 3 months from its application. Designed as primer or intermediate coat, it is particularly suggested for anticorrosion coating systems in aggressive environment. It can be used as tie-coat on inorganic zinc based and epoxy products.

TECHNICAL DATA		Base (part A)	Hardener (part B)
Type of binder:		Epoxy	polyamide
Specific gravity	Kg/l	1,50 ± 0,05	
Colour:		grey	transparent
Mixing ratio	by weight:	90	10
Solids content by Volume:		62 ± 2%	
Solids content by weight:		77 ± 2%	
Pot life (+20°C):		≥ 6 h	
Temperature Resistance:		+70/+ 80°C (in continuous in air, dry conditions).	

SUBSTRATE **Steel/Iron:** If applied as primer, blast cleaning to SA 2,5 according to ISO 8501/1 with minimum roughness profile RZ Din 30-50 µm. is suggested. When blasting is not possible, the substrate must be dry, degreased and perfectly cleaned from rust and mill scales and possibly mechanically abraded and suitably primerized.

All substrates previously primerized:

Dry and cleaned follow the same recoat interval as for the first coat.

PREPARATION OF THE PRODUCT Homogenize the Base and the Hardener in the original containers. Mix Base and Hardener in the right proportions, stirring the obtained mix for another 5 minutes until a complete homogenization is reached. Pour the mix in the spray equipment tank.

APPLICATION DETAILS	Application:	brush, wool roller, conventional spray or airless with minimum compression ratio 45 : 1.
	Thinner:	Thinner for epoxy products Epothinner.
	Thinning:	% brush, roller, conventional spray 10 – 15; different thinning can be necessary according to absorption of the substrate, the thickness required and the coating system chosen.
	Drying (at +25°C):	touch dry 2 – 3 h; handling 24 / 36 h.
	Recoat interval (+25°C):	18/24 h (after 48-72 h we recommend a light sandpapering). Full cure with max. resistance characteristics is obtained after 7 days. It can be over-coated with any kind of two component coating.
	Temperature of the product:	+20 ÷ +30°C
	Suggested temperature during application:	+15 ÷ +40°C (minimum +5°C)
	Temperature of the substrate: °C	+5 / + 40°C however over +3/5°C from the dew point
	Relative humidity: %	< 85
	Suggested thickness:	75 microns DFT (WFT 125 µm) – min.40 / max. 150µm dft
	Theoretical spreading rate: m ² /Kg	8,2 m ² /l – 5,5 m ² /kg at the suggested thickness.

HANDLING STORAGE AND SAFETY PRECAUTIONS	Handling:	Use individual protection means: gloves, glasses mask.
	Storage:	Keep in well dried and ventilated places at a temperature between min. +5°C and +40°C max. in the sealed original cans. Do not expose to low temperatures during transport.
	Shelf-life:	12 months at the suggested storage conditions.
	Safety precautions:	Refer to Material Safety Data Sheet.

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

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