

STOPCOAT 410

NATURE AND USE STOPCOAT 410 is an Epoxy-polyamide product. Studied as Primer and intermediate coat for anticorrosion coating systems, the product is particularly recommended for the maintenance of structures and plants in aggressive atmosphere. It can be used as **tie-coat** on epoxy and inorganic galvanizing products.

TECHNICAL DATA	Protection from corrosion:	The application of one single coat provides good protection to steel substrates.
	Abrasion:	Good resistance to abrasion and to mechanical damage.
	Adhesion:	Excellent on substrates duly prepared.
	Resistances:	
	Acid solutions	Good
	Alkaline solutions	Excellent
	Sea water	Excellent
	Deionised water	Good
	Marine atmosphere	Excellent
	Industrial atmosphere	Excellent
	Petrochemical atmosphere	Excellent
	Temperature:	+70/+ 80°C (in continuous in air, dry conditions).

SUBSTRATES PREPARATION **Steel / Iron:** Sandblasting at grade SA 2,5 minimum according to ISO 8501/1 and roughness profile RZ Din 30 – 50 µm. When sandblasting is not possible, the substrate must be dry, degreased, perfectly cleaned and without traces of rust and mill scale and anyhow mechanically abraded

Cement: Cleaned, dry, seasoned, free from flaking parts, efflorescence and detaching oils.

Other Substrates : Perfectly cleaned and duly primerized.

PRODUCT PREPARATION Homogenize separately the two components in their original cans. Mix the two components in the right proportions and stir for 5 minutes until a complete homogenization is reached. Then pour the mix in the dedicated tank of the spray equipment.

APPLICATION	Mixing ratio (by weight):	83 parts Base - 17 parts Hardener
	Mixing ratio (by volume):	75 parts Base - 25 parts Hardener
	Conditions for application:	Minimum temperature of the substrate min. +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:	5 / 10 % with Epothinner
	Suggested thickness:	75 µm dry film thickness (wet film thickness about 125) Min. 40 / Max. 150 µm
	Method:	Application by airless pump with compression ratio minimum 45:1 Nozzle 0.015 - 0.020 inches Pressure 150 - 225 Kg/cm2. Application by Brush or Roller
	Theoretical spreading rate:	8 m ² /l – 6.0 m ² /Kg at the suggested thickness
	Theoretical consumption:	167 g/ m ²
	Drying at +25°C:	Touch dry ¾ h., Handling 24/36 h
	Over-coating (+25°C)	24 -36 h
	Solids content by volume:	61 ± 2 %
	Solids content by weight:	73 ± 2 %
	Specific gravity (average mixed):	1.35 ± 0.05
	Pot life (+20°C) :	≥ 6 h
	Shelf life:	Max. 12 months in the sealed original cans (Minimum temperature +5°C / Max. +40°C) Do not expose during transport at temperatures lower than +5°C

HANDLING	Handling : Provide a suitable ventilation during the use. Avoid skin contact using gloves, protective creams and masks. Avoid Skin contact.
STORAGE	Storage: Keep at room temperature in the sealed original cans. Keep far from flames sparks or heat sources
AND SAFETY PRECAUTIONS	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.

MTDS 05012/1

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