

# STOPCOAT 411

**NATURE AND USE** STOPCOAT 411 is a two component epoxy polyamide high build coating modified with vinyl copolymers for a long recoatability. The product is semi-glossy and generally supplied in light ivory colour but is available also in sample colours on demand. It is suitable as intermediate / top coat for anticorrosion and maintenance coating systems exposed to severe environmental conditions, as primer with good adhesion on light alloys, galvanized steel plates and galvanized sheets or as tie-coat for inorganic zinc based products if applied "wet on wet".

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

\* smokes, vapours, sprays.

**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  
**New Galvanized Steel :** dry, abraded and perfectly degreased  
**Galvanized Steel previously coated :** Abrade in order to remove all traces of rust.  
**Aluminium :** Dry, degreased and lightly abraded, or chemically treated  
**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):	90 parts Base - 10 parts Hardener
Mixing ratio (by volume):	84 parts Base - 16 parts Hardener
<b>Shelf life:</b>	Max. 12 months in the sealed original cans (minimum temp. +5°C / Max. +40°C)
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 Ebothinner
Suggested thickness:	80 µm dry film thickness (wet film thickness about 140) Min. 50 / Max. 150 µm
Method:	Application by airless pump with compression ratio minimum 45:1 Nozzle 0.015 - 0.020 inches Pressure 150 - 180 Kg/cm <sup>2</sup> .
Theoretical spreading rate:	7 m <sup>2</sup> /l – 5.0 m <sup>2</sup> /Kg at the suggested thickness
Theoretical consumption:	190 g/ m <sup>2</sup>
Drying at +25°C:	Touch dry 3/4 h, Handling 24/36 h
Over-coating(+25°C)	min. 18-24 h /Max. unlimited.
Solids content by volume:	56 ± 3 %
Specific gravity (average mixed):	1.40 ± 0.05
Pot life (+20°C):	≥ 6 h
Final appearance of the film:	semi-glossy

(\*) NOTE: Like all epoxy coatings, Stopcoat 411 also when exposed in external areas, under U.V., water, action etc. naturally tends to chalking and whitening. This phenomena is not the index of a lower corrosion protection of the substrate, but only the index of a superficial film degradation

**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 04012/1

**INDUSTRIE BRUNO STOPPANI R.P.S. S.r.l. - Sede Legale Via Creta 72 25124 BRESCIA**  
**Sede Operativa : Via Industriale 119 25020 Capriano del Colle Bs , TEL.0039 0309745116 r.a. FAX 0039 030 9745383**  
**Mail: [sales@industri brunostoppainpaints.com](mailto:sales@industri brunostoppainpaints.com) [sales@ibspaints.com](mailto:sales@ibspaints.com) [www.industri brunostoppainpaints.com](http://www.industri brunostoppainpaints.com)**  
**Azienda con sistema di gestione qualità UNI EN ISO 9001:2008 certificato da Certiquality - Certificato Nro 2134**



The content of the present technical data sheet is the most complete currently available. It is based on practical experience and is given in good faith. Should any change be necessary, the present data sheet will be updated without prior notice.  
The applying conditions of use differ according to environmental conditions and subjective application factors outside our control of the Company. The user shall determine the suitability of the products for the intended use. On request more detailed recommendations are available from the Company. No warranty is impressed or implied.  
The Company refuses all liability not directly related with defects of the product or when differing from written instructions