

# VIKING

## Two component Solvent Free Epoxy coating, suitable for transport and storage of drinking water

Base Code 59061 white - Hardener code 59060

**NATURE AND USE** Two- component, solvent free epoxy-polyamine fast drying coating to be applied with **hot bi-mixer** spray application.(suggested method).Internal High build coating of steel pipes and tanks ,suitable to get in contact with drinking water (according to the Ministry of Health Circular n. 102 of 02.12.1978 – DM Nr 174 dated 06.04.2004) and suitable also to get in contact with some alimentary substances listed in the enclosure of D.M. dated 21.03.1973 and following updating. (For more details please contact our technical dept.).

Viking can be used as internal protection and also as external high built passive protective barrier (alone or used in a coating system with other types of coatings) on steel items operating in the air or buried, when the requirements impose **good chemical and mechanical resistances also in critical exercise conditions**. The coating forms a hard, compact, non-toxic and long lasting film, resistant to the aggression of different chemical agents such as Sulphuric Acid solutions ( 1% H<sub>2</sub>SO<sub>4</sub> in water), caustic soda (1% NaOH in water), brackish water (tested with a content of 35% NaCl in water) and sea water, lubricating oil, Diesel oil, fuel, natural gas, sewage water .

**NB: No free or combined aromatic amines are present in the product.**

**Approvals: O.T.E.C. Certificate no.07829 / ARPA certificates N. 5146/RGA – 5147/RGA / PDC Lab Certificate N. 08/123/A – 08/0123/B.  
Australian AWQC Certificate Nro 43966 to AS/NZS 4020:2005/ WRc Certificate N.Mat/LAB 1381  
The product Complies with BS 6920 / Complies with Spanish Royal Decree 866/2008/ Complies with AWWA C-210**

<b>TECHNICAL DATA</b>	Colour:	White (On request : Honey, light grey, blue, red oxide)		
	Appearance:	glossy		
	Mixing ratio:	(by weight)	70 parts Base	30 parts Hardener
		(by volume)	2 parts Base	1 part Hardener
	Pot life at +20°C:	60 ± 10 min. about		
	Specific gravity (A + B)	kg/l	1.55 ± 0.05	
	Suggested thickness per coat:	400µm; min. 250/max. 600 µm		
	Theoretical spreading rate:	1.6 m <sup>2</sup> /Kg or 2.5 m <sup>2</sup> /lt at a dry film thickness of 400 µm.		
	Theoretical use:	about 625 g/m <sup>2</sup>		
	Solids Content:	100 % (A+B)		
Curing at +25°C:	dust dry 5 – 7 h / handling after 18 - 30 h recoat interval within 24 - 36 h fully cured 7 days at +25°C.			
Exercise dry temperatures in °C :	-20/+80 with peaks of + 110 °C			

Note : All epoxy products, due to their nature, under the effect of UV, humidity and other agents, tends to whiten and chalk

### SURFACE

#### PREPARATION

**All kind of steel substrates:** Cleaned, degreased, decontaminated, roughened and perfectly dry. (when necessary, treated with a suitable primer. Info available by our Technical Service).

**Steel :** Sandblasting to SA 2,5 minimum, according to ISO 8501-1 for steel, with minimum roughness profile Rz DIN 50 – 70 µm./ maximum 100 µm. Then accurately remove all dust with compressed dry air jetting.

#### PREPARATION OF THE PRODUCT

Stir the two components separately in their original supply can. Check Base and Hardener quantity taken to prepare the mix for the required application

#### - Airless application and Hard Bristles brush

After the catalysis of the two components stir the mix for not less than 5 minutes until a complete homogenization is reached.

#### - Bi-mixer application

Pour each of the two components in the dedicated bi-mixer heating tank. Heat each of the two components until a proper atomisation spray has been reached as to fluidity .  
(Suggested base and hardener mix at the "head " just before the spraying nozzle)

MTDS 0911/1 page 1 of 2

**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 brunostoppa nipa nts.com](mailto:sales@industri brunostoppa nipa nts.com) [sales@ibspaints.com](mailto:sales@ibspaints.com) [www.industri brunostoppa nipa nts.com](http://www.industri brunostoppa nipa nts.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 changes 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 the 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.

# VIKING

## Two component Solvent Free Epoxy coating, suitable for transport and storage of drinking water

Base Code 59061 white - Hardener code 59060

---

<b>APPLICATION DETAILS</b>	Hot airless bi-mixer equipment (Hard bristles brush, only for small touch up, repairs and limited surfaces)
	Traditional airless pump with compression ratio 60 : 1 minimum, only in specific conditions (Ask for info our tech. Service dept)
Ø Nozzle:	0.015 - 0.031 inches (indicative data)
Nozzle pressure:	240 - 300 Kg/cm <sup>2</sup>
Suggested temperature of the preheating (airless-bi-mixer):	Base +50/+60 °C Hardener +40/+50 °C
Product temperature before its application (Hard bristles or traditional airless)	+25/+30 °C (Suggested temperature)
Room temperature:	+5 ÷ 40 °C
Temperature of the substrate:	over +3/+5 °C above the dew point
Humidity:	< 85%
Thinning:	None – Do not thin
Tools Cleaning	Thinner 333 or Epothinner
Precautions:	Avoid contact with the skin. All the equipment must be immediately cleaned after use with Thinner 333 or Epothinner .

---

<b>HANDLING</b>	Handling / Transport:	Keep in well ventilated places at a maximum temperature of +40 °C / minimum +5 °C in the sealed original containers. Do not expose to low temperatures during transport.
<b>STORAGE AND SAFETY PRECAUTIONS</b>	Shelf life:	12 months if the product is properly preserved
	Safety precautions:	Avoid contact and vapour inhaling. Use protective gloves, safety glasses and garments completely protecting the skin. <b>Refer to Material Safety Data Sheet.</b>

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

---

<b>Further advises :</b>	<b>Excess Product</b>	Hardener and Base - Close the cans/drums properly and store as above specified. Check the Shelf Life.
	<b>Cured product</b>	Disposal of waste accordingly to local environmental specifications

---

### PRECAUTIONS IN CASE OF WATER FOR HUMAN CONSUMPTION PIPELINE AND TANKS (INTERNAL)

Be sure the internal of pipes and tanks during coating and curing have been duly ventilated to grant good air changes during time.  
Before commissioning the pipeline or tank , rinse repeatedly the internal surface with water and or other suitable products solutions to grant a hygienic surface.

**To get further suggestions for the coating of pipelines, please contact our Technical Department**

MTDS 09011/1 Page 2 of 2

---

**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@industriebraunostoppainpaints.com](mailto:sales@industriebraunostoppainpaints.com) [sales@ibspaints.com](mailto:sales@ibspaints.com) [www.industriebraunostoppainpaints.com](http://www.industriebraunostoppainpaints.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 changes 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 the 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.