

EPOKIM SATIN

Series 0434

Satin-finish, epoxy enamel for metal



TECHNICAL FEATURES

Satin-finish epoxy enamel characterized by excellent resistance to acids and weak alkalis and mechanical resistance. The product can be used for direct adhesion to metal (DTM) even if it does not have anticorrosive properties and guarantees good adhesion for products dedicated to the interior usage.

APPLICATION FIELD

Satin-finish epoxy enamel, ideal as final coat for iron, light alloys or galvanized steel and where good chemical and mechanical resistance are required. Particularly suitable for chemical plants, pumps, industrial plants, electro-medical equipment, machine tools and carpentry.

GENERAL INFORMATION

System: Two pack - 2K

Nature: Solvent-based

Packages: 4 kg - 20 kg

Tinting Service: Tinting service with solvent-based colorants Series 0615

Color fans and color cards: Ral 841 GL, Ral Design, Ncs 1950, ColoradoMix 1040, Colorado Box 2.0

SUBSTRATE PREPARATION

As this is a finishing product, in case of outdoor application or where anticorrosive protection is required, it is necessary to first apply a suitable primer. The preparation of the substrate must be carried out with reference to what is indicated in the specific technical data sheet of the appropriate primer. In order to investigate and select the ideal coating system, it is advisable to consult the technical assistance service or the commercial support in order to obtain the precise indication of the suitable primers to be used according to the type of product and the support to be painted. Finally, it is essential to respect the overcoating times of the primer.

APPLICATION

Application conditions

The application of the coating product is subject to various factors such as environmental conditions (among which it is necessary to mention temperature, humidity and ventilation), geometry and laboriousness of the products to be painted, surface profiles and thicknesses to be applied. The application system to be used is of particular importance as, depending on the type of system, various parameters may vary including the transfer efficiency of the coating product, the overspray, the aesthetic appearance obtained, the sagging stability of the product and the ease or complexity of application. For these reasons, prior to applications on systems and lines of considerable scope, it is advisable to contact the technical assistance service in order to carry out the inspection and the necessary surveys for a consultancy activity relating to the application methods and the definition of ad hoc technical details on the plant in question.

EQUIPMENT	VISCOSITY	NOOZLE	PRESSURE	NOTES
AIRBRUSH - CUP GUN	20" - 30" Ford Cup 4	1,4 - 1,7 mm	3,5 - 4 bar	-
AIRMIX	Depending on application parameters	9 - 11	60 - 100 bar	-
ELECTROSTATIC	-	-	-	Contact technical assistance to decide the suitable antistatic additive

EPOKIM SATIN Series 0434

CATALYSIS

SERIES	HARDENER	CATALYSIS	USE	POT LIFE AT 20°C	PACKAGE
1600	EPOX STANDARD HARDENER	25% by weight (100 + 25) or 3:1 by volume	Fast	6 hours	1 kg - 5 kg
0917	EPOX FAST HARDENER	15% by weight (100 + 15)	Fast High Solid	6 hours	1 kg - 3 kg
0918	EPOX SLOW HARDENER	20% by weight (100 + 20) or 3:1 by volume	Slow for primer	6 hours	4 kg

ENVIRONMENTAL CONDITIONS



ENVIRONMENT
TEMPERATURE

12°C - 35°C



SUBSTRATE
TEMPERATURE

12°C - 35°C



RELATIVE
HUMIDITY

60 %



SHELF LIFE

Store 2 years in original sealed packaging
at +5/+35°C

TECHNICAL DATA



THEORETICAL AVERAGE SPREADING RATE	APPLICATION	DILUTION	GLOSS	WET FILM THICKNESS EACH COAT	DRY FILM THICKNESS EACH COAT	N° OF COATS	TOTAL DRY FILM THICKNESS	THEORETICAL AVERAGE CONSUMPTION
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7 m ² /kg each coat at the dry film thickness of 50 µ	Spray	10-15% with Epoxy Thinner Series 0981	50 - 60 gloss	96 µ	50 µ	1 or 2 coats to achieve the total desired thickness	90 µ	143 g/m ²
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DRYING



OVERCOATING INTERVAL	AIR DRYING	DUST-FREE DRYING	DRY TO TOUCH	DRY THROUGH	FULL CURE	FLASH OFF	STOVING DRYING	RESISTANCE TO TEMPERATURE
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6 - 96 hours (after it is necessary to sand)	20°C	30 minutes	2 - 3 hours	24 - 36 hours	28 days	-	-	80°C continuous exposure
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WARNINGS AND RECOMMENDATIONS

- As this is a finishing product, it has no anticorrosive properties, therefore in case of exterior application or where anticorrosive protection is required, it is necessary to apply a suitable anticorrosive primer.
- Do not apply the product at ambient temperatures below 12°C and maintain this limit, with reference to both the product and the surface to be treated, at least for 8-12 hours after application.
- If exposed to UV rays it tends to chalk and yellow, without losing its essential characteristics.
- To obtain a homogeneous satin/matt effect, the product must be applied in light coats, trying to maintain regular and homogeneous thicknesses.
- The degree of gloss can be influenced by the chosen color and the thickness applied. Unlike glossy final coat, resistance to scratching and polishing is lower.
- It is advisable to wait 8-10 days before the dried film comes into contact with oils.
- The color match is evaluated after the application and drying of the product. It is recommended to carry out practical tests, such as spreading or applying the colored product on small surfaces made of suitable material, before proceeding with the product painting.
- After having colored the product with the suitable colorants, mix the product in a short time.
- In order not to incur financial penalties, after having colored a product with tinting machine, send the MSDS and apply the appropriate legal labelling printable using the Databook P&C tinting software.
- Total color development in epoxy resins is obtained after the hardening and dilution of the product.
- For slightly matt colored products (yellow, orange, red) it is recommended to use a suitable white primer.
- Shelf Life Component B: the shelf life of the hardener used with Component A is 24 months.
- The system is partially resistant to aromatic and strong solvents (ketones) and to highly acid or alkali materials.

SUPPLY TECHNICAL DATA

Composition: Epoxy polyamide

Reference color: White

% solid content by weight: 77 ± 2%

% solid content by volume: 58 ± 2%

VOC: 369 ± 2 g/l

VOS: 22,7 ± 2%

PARAMETER	DATA	TEST METHOD
VISCOSITY	3000 - 4000 mPa.s (20°C) Rod 4 Speed 20	ISCOL 1
GLOSS	50 - 60 gloss 60°	ISCOL 6
SPECIFIC WEIGHT	1,45 - 1,65 g/ml	ISCOL 2

MIXING RATIO A+B

Specific weight after catalysis (A+B): 1,46 ± 0,05 g/ml

% solid content by weight (A+B): 68 ± 2%

% solid content by volume (A+B): 52 ± 2%

VOC (A+B): 477 ± 2 g/l

VOS (A+B): 32,2 ± 2%

METHOD	1600	0917	0918
A+B BY WEIGHT	100 + 25	100 + 15	10 + 20
A+B BY VOLUME	3:1	100 + 30	3:1

TINTING SERVICE

BASE	BASE PACKAGING	COLORED PACKAGING	% MIXING RATIO
BINDER	3,4 kg 17 kg	4 kg 20 kg	85 - 15

EPOKIM SATIN Series 0434

NOTES

Cleaning tools: At the end of the application, carefully wash the spray guns, the painting systems and the containers with a suitable thinner and store the tools dry to avoid encrustations.

Sanitary labelling: Handle the product with care. Make reference to the MSDS and respect the national and local regulations in force concerning personal and environmental safety.

Additional notes:

- The spreading rates are theoretical, indicative and intended per coat as they can be influenced by the color and the application system. Practical application test is suggested.
- The data reported in this data sheet have been obtained using only Franchi&Kim production materials (coatings, hardeners, thinners) applied in accordance with the specifications described. The improper use of thinners and/or hardeners, other than those mentioned or not manufactured by Franchi&Kim, can compromise application features, performances and final curing of the product. Therefore, in case of mixed coating systems with Franchi&Kim and other brand products, the conformity of the results with the parameters indicated in the technical data sheet cannot be granted.
- All times indicated in the drying section are to be intended at the temperature of 20°C, unless otherwise specified.
- The gloss indicated and tested may change during the application phase because it can be influenced by the following factors: realized color, thickness, number of coats, environmental conditions, thinner and hardener used if different from those established in the technical data sheet.
- The data relating to section catalysis ratio A+B are to be considered referring only to the first recommended catalyst.
- Pot Life times have been defined at the temperature of 20°C, therefore higher or lower temperatures, hardeners, environmental conditions and humidity different from the standard can influence in defect or in excess the duration of the Pot Life.

The information contained in this technical document is correct and accurate to the best of our knowledge, and should therefore be considered reliable. In any case, they cannot imply a guarantee on our part, as certain factors such as the preparation of the product and the substrate, the conditions of use, application, drying and overcoating, as well as the state of conservation of the products, are outside our strict control. It is responsibility of the user to verify the suitability of the products for the specific use, as well as the correct and precise execution of the work in accordance with the content of the technical data sheet, the recommended coating system and preparation of the support. For further information regarding the method of application and conditions of use, it is recommended to contact our technical support service. It should be noted that the packaging image could have a placeholder purpose and could therefore be an indicative reference. The packages indicated may vary according to the additions or changes of the annual price lists. This document replaces all previous versions. In any case, it is advisable to refer to the annexes with the explanatory notes to better understand and deepen the parameters of the technical data sheet. The updated edition, available on the website www.franchi-kim.com in the section technical data sheets of the download area is to be considered the only ones to consult as reference.

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