

SIPOXY FINISH 225

Epoxy Finish, Polyamide Cured

Product No. 6225

Features

- Provides a smooth finish coat.
- Easy application and cleaning.
- Aesthetically pleasing.
- Wide colour range.
- Durable and chemical resistant coating.

Recommended Use

- As a (sea) water, weather and abrasion resistant coating in marine and industrial environments. Because of its long pot life very suitable for application in hot climates.

Physical Data

Finish : Gloss
Available in semi gloss
under code 6227.

Colours : Various

Volume Solids : 60%

Recommended Film Thickness :
50 microns dry = 83 microns wet

Theoretical Coverage :
12 m²/ltr. at 50 microns

Density (mixed) : 1.25 kg/ltr.

**Drying & Recoating Times at 50 microns
(25°C/65% RH) :**

Dry to Recoat : 4 Hours
Hard Dry : 12 Hours
Maximum Recoating Time : Not Limited
Cured : 5 Days

Heat Resistant :
Up to 120°C in dry environment

Flash Point : 27°C

Specification Data

Preparation

Steel

SIPOXY FINISH 225 is designed as a finishing coat on steel substrate, which has been blast, cleaned and primed with the appropriate primers and intermediate coats.

Prior to application of SIPOXY FINISH 225 ensure that the substrate is intact and free from contaminants. All damaged areas of primer and mid-coats should be rectified and made good to ensure uniformity of the system. The substrate should then be thoroughly degreased in accordance with SSPC-SP1. All dust should be removed from the substrate using clean brushes and/or dry compressed air. Ensure that the substrate is completely dry prior to the application of this product.

Concrete and Masonry

Substrates should be thoroughly dry. All dirt, dust and loose flakes to be removed. Prime substrates with SIPOXY FINISH 225 mixed with 20% thinner No.740. Subsequent coats according to specification.

Because of the excellent re-coatability of SIPOXY FINISH 225 no special surface preparation is required after ageing and weathering before applying a new coat of SIPOXY FINISH 225.

Application Data

Mixing Ratio by Volume	Base : 4 parts Hardener : 1 part																								
Mixing Advice	Prior to application, stir the A-component, add B-component and mix thoroughly to obtain an homogeneous mixture. Use a mixer for this, which is powered by air or a flameproof electromotor.																								
Thinning	Thinner 740. When mixed, the paint is ready for brush or airless spray application. If the paint is too thick, in cold weather for example, then add a small amount of thinner 740 to obtain the suitable viscosity. The amount of thinner that may be added is dependent on the application conditions and methods. Overthinning will lead to poor results. Add thinner only after mixing of the components.																								
Pot Life	Pot life at 20°C : 12 hours																								
Induction Time	Induction time at 20°C : 15 minutes																								
Application Condition	Application temperature : 5 - 50°C. The minimum temperature required for satisfactory drying is 10°C. The surface temperature must be at least 3°C above the dew point to prevent condensation. Never apply paint under adverse weather conditions. In confined spaces, constant purging of the air during application and drying is necessary to eliminate solvent vapours for reasons of health and safety as well as to assist evaporation. The dry film is liable to chalking when exposed to sunlight.																								
Application Methods & Details	<table border="0" style="width: 100%;"> <thead> <tr> <th></th> <th style="text-align: center;"><u>Airless spray</u></th> <th style="text-align: center;"><u>Conventional Spray</u></th> </tr> </thead> <tbody> <tr> <td>Recommended thinner :</td> <td>Type 740</td> <td>Type 740</td> </tr> <tr> <td>Thinner addition :</td> <td>0 - 20 vol.</td> <td>0 - 20 vol.%</td> </tr> <tr> <td>Nozzle orifice :</td> <td>0.015" - 0.019</td> <td>2 - 3 mm</td> </tr> <tr> <td>Working pressure :</td> <td>140 - 160 bar</td> <td>2 - 3 bar</td> </tr> <tr> <td></td> <td style="text-align: center;"><u>Brush/Roller</u></td> <td></td> </tr> <tr> <td>Recommended thinner :</td> <td>Type 740</td> <td></td> </tr> <tr> <td>Thinner addition :</td> <td>0 - 5 vol.%</td> <td></td> </tr> </tbody> </table>		<u>Airless spray</u>	<u>Conventional Spray</u>	Recommended thinner :	Type 740	Type 740	Thinner addition :	0 - 20 vol.	0 - 20 vol.%	Nozzle orifice :	0.015" - 0.019	2 - 3 mm	Working pressure :	140 - 160 bar	2 - 3 bar		<u>Brush/Roller</u>		Recommended thinner :	Type 740		Thinner addition :	0 - 5 vol.%	
	<u>Airless spray</u>	<u>Conventional Spray</u>																							
Recommended thinner :	Type 740	Type 740																							
Thinner addition :	0 - 20 vol.	0 - 20 vol.%																							
Nozzle orifice :	0.015" - 0.019	2 - 3 mm																							
Working pressure :	140 - 160 bar	2 - 3 bar																							
	<u>Brush/Roller</u>																								
Recommended thinner :	Type 740																								
Thinner addition :	0 - 5 vol.%																								
Cleaning of Equipment	Use Thinner 740.																								

Storage Information

Pack Size	5 and 20 ltr. two component kits
Storage	Store generally in original sealed container, indoors, at a temperature between 5 and 40°C and relative humidity below 70%.
Shelf Life	1 Year

Safety Information

See the material safety data sheet and product label for complete safety and precaution requirements.

Disclaimer

The information in this data sheet represent test results or experience under well defined conditions. Its accuracy or suitability under the actual conditions of any intended use is not guaranteed and must be determined by the user. All advice given about this product is given in good faith. Since as we have no control over conditions of substrate and application, manufacturer and seller can not accept any liability in connection with the use of the product relative to coverage, performance, injury or damage, unless we specifically agree in writing to do so. The information in this data sheet is subject to change without notice and it is the user's responsibility to ensure it is current. For further information and advice contact Technical Services on Tel. (03) 847 2299, Fax (03) 847 3780.