

CHARACTERISTICS

High solid epoxy paint, thixotropic, low solvent content, cured with amine, two component: I component symbol 7459-470-XX0, component II symbol 7459-470-000. High-gloss, hard coating, with good adhesion to surfaces and resistant to mechanical factors. Coating resistant to water, salt and alkali solutions, oil, fuel oil, heating oil, diesel, motor gasoline, ethyl gasoline, unleaded petrol, aviation fuel, ethyl glycol, glycerine and xylene. When exposed to sun radiation, the tint of the coating may change without impairing the properties.

PRODUCT USE**For self-protection of:**

- inside linings of fuel, sewage, ballistic and storage tanks;
- steel and concrete constructions operating in corrosion aggressive environment, where high decorative value of coating is not required,
- constructions in the ground, where the risk of petroleum derivatives or solvent exists.

For priming of:

- steel constructions operating in chemically aggressive environment.

PROPERTIES

Density (approx.), g/cm ³	1,5
Flash point, °C	26
Typical dry film thickness, µm	150
Typical wet film thickness, µm	200
Theoretical coverage at 100µm, dm ³ /m ²	0,20
Volume solids (about), % vol.	75
Recommended number of coats	2 - 3
Volatile Organic Compounds, g/dm ³	200

Given data may vary slightly for different colours as well as due to normal manufacturing tolerances.

COLOUR

250 red oxide 320 sand yellow 860 light grey

SURFACE PREPARATION

- Before cleaning of surface, it is recommended to wash it with water with addition of OLICLEAN 123 and then rinse with fresh water.
- Steel surface dry, salt- and grease-free, cleaned to the degree of cleanliness according to PN-ISO 8501-1, at least Sa 2½; surface roughness Rz at least 50-75 microns.
- EPIWELD[®] or EPIRUST[®] surface dry, rust-, salt-, grease- and dust-free.
- Steel surface previously primed using shopprimer should be dry and free of contamination. Rust, mechanical, thermal damage or any defects of surface should be cleaned to Sa 2½ according to PN-ISO 8501-1 light abrasive blasted. Surface dry, salt-, dust- and grease-free.
- Concrete surface fully cured (minimum 28 days at 20°C), rough, without cracks, crevices and laitance. Surface must be dry (relative humidity max. 3%), fat-, salt-, dust- and inclusions-free. Before painting it is recommended to prime surface using diluted varnish EPINOX[®] 12.

PAINT PREPARATION

Stir thoroughly component I, mix with component II according to the following mixing proportions:

	by weight	by volume
component I	100	100
component II	20	30

Mix thoroughly components and wait 15 minutes (at 20°C) before use.

Minimum temperature of the paint: 15°C.

Pot life in 20°C - 2 h

APPLICATION METHODS

Airless spray (brush – only for small surfaces). When using a brush it may be necessary to dilute paint (3% of thinner) and apply several layers to achieve recommended coating thickness.

Airless spray parameter:

Nozzle size	0,53 - 0,68 mm
Nozzle pressure	20 - 30 MPa

THINNING

Not required.

When necessary (for example – thickening product) use Thinner 779 (see Technical Information).

For cleaning tools: Thinner 564.

APPLICATION CONDITIONS**Application and curing conditions:**

- minimum surface temperature: +5°C and at least 3°C higher than dew point,
- relative air humidity below 85%,
- good ventilation.

Drying time (in 20°C):

dust dry	- 6 h
touch dry	- 7 h

Overcoating intervals:

temperature	30°C	20°C	10°C
minimum	6h	12h	24h
maximum	24h	48h	96h

Given indications relates to the recommended coating thickness, drying in good ventilation conditions. Overcoating times may be different with a change of temperature, ventilation, number of layers and the thickness of the coating.

Full cure:

temperature	30°C	20°C	10°C
minimum	4 days	7 days	16 days

SUBSEQUENT COAT

OLIVA's epoxy, vinyl, acrylic or polyurethane top-coats, when the construction in atmospheric conditions.

**ADDITIONAL
INFORMATION**

- Depending on application and type of construction, other thickness of a single layer can be assumed instead of recommended. Typical dry film thickness range using airless spray is from 150 to 250 μm . Changing the thickness of the coating changes the theoretical consumption, thickness, weight of dry coating, drying time, time of recoating and finishing work.

SHELF LIFE

The storage stability is shown on the label. Store in cool place and in tightly closed can.

CAUTION!

During application and drying of the coating flammable and health threatening substances are emitted. It is important to avoid inhaling the fumes of the product and contact with the eyes and skin. Use only in well ventilated rooms. Detailed information on dangerous substances contained in the products and threats connected with them are included in the specification cards of the dangerous substances, which we make available at the Customers' request.

The information of this data sheet is normative, based on laboratory tests and our experience. It is available for our Customers' convenience. We accept however, no liability for the actual application work, as this is to great extend dependent on the conditions during handling and application. We accept no liability for any damage from misapplication of the product. The technical terms in the instruction are explained at the beginning of the catalogue. We reserve the right to include changes in the instruction without prior notice.