

TECHNICAL DATA SHEET

HYDRO EPOX 61

Waterbased epoxy enamel

FEATURES	Two-component water based epoxy gloss enamel with good speed drying at room temperature or with forced air (max. 70° C). Characterized by good adhesion properties and durability in industrial and marine environments, with good resistance to abrasion, water and salts.			
TYPICAL USE	It is used where resistance to mechanical stress and a corrosive liquids is required. It is a finish with an excellent aesthetic result in industrial painting of car bodies, containers, chemical plants, port facilities.			
PERFORMANCE DATA	DESCRIPTION	VALUE		
	Specific weight (A+B)	1050-1150 g/l		
	Working temperature	< +120 °C		
	Solid by volume %	50% ± 2		
	Gloss level 60°	35-45		
THICKNESS AND COVERAGE		Minimum	Maximum	Recommended
	Thickness of dried film, μm	40	100	70
	Thickness of wet film, μm	80	200	140
	Theoretical coverage m ² /l	12,5	5	7,1
	Theoretical coverage m ² /l	11,4	4,6	6,5
SHELF LIFE	6 months in its original and unopened can at a temperature from +5°C and +30°C.			
COLOUR RANGE	The range of colours can be chosen in shades of RAL. Between one production and the other, tint may be slightly different, it is therefore important to finish the job with the same batch.			
SURFACE PREPARATION	<p>General considerations: for the success of the work the surface must be free from previous treatments and cleaned of pollutants of various kinds such as dirt, oil, grease and salts</p> <p>Coated surfaces</p> <p><i>With primer:</i> if clean and free of dirt, oil, grease, salts and dry, and recoated part in a maximum of the primer coating can be over applied. If cleaning is necessary , perform high-pressure washing Wa 2 (surface free of oil, grease, salt, dirt).</p> <p><i>With complete coating:</i> if undamaged compatible and non-chalky perform cleaning oil and grease with detergent, then perform surface sanding followed by pressure washer to remove dirt and salts.</p> <p><i>Rusty coating:</i> perform mechanical preparation St2 or St3 followed by a pressure washer to remove oil, grease, dust and salts or sandblasting Sa2 or Sa2,5;</p> <p><i>Localized maintenance:</i> perform mechanical preparation St2 or St3 followed by a pressure washer to remove oil, grease, dust and salt or sand blasting Sa2 or Sa2,5. Round off the edges of the paint well stuck and restore the system in the original layers and thicknesses.</p>			
TOOLS	Conventional or airless spray, roller, brush.			

TECHNICAL DATA SHEET

HYDRO EPOX 61

Waterbased epoxy enamel

APPLICATION

Mixing ratio in weight	100:50 with Induritore Hydro Epox Smalto
Mixing ratio in volume	100:58 with Induritore Hydro Epox Smalto
Thinning	0-10% with water
Use time @ 23°C	5-6 h
Application conditions	+5°C +40°C Temperature > 3°C than dew point Relative humidity: < 70 %
Airless application method	Nozzle pressure 15 MPa (150 kp/cm ² , 2100 psi). Nozzle: 0,28 - 0,38 mm (0,011 - 0,018") Angle range; 40 - 80° Air pressure: 150-180 kg/cm ² Compression ratio 30:1 Nozzle: 1,6 - 1,8 mm Angle range; 30 - 50° Air pressure: 3,5-4 kg/cm ²
Thinner for washing	Water

DRYING TIMES

I The data supplied must be considered merely indicative. The actual drying time can be shorter or longer, taking account of film thickness, ventilation, humidity. In the subsequent coating the better adhesion is achieved when the application of the next hand is done before the time of complete catalysis.

DTF 70 micron

Surface temperature	10°C	23°C	35°C	Oven 60°C
Out touch	60'	45'	30'	20'
Dry to touch	6h	3h	2h	1h
Full catalysis	72h	24h	16h	1h
Minimum time of over application	6h	3h	2h	1h
Maximum time of over application	6 days	5 days	3 days	2 days

RECOMMENDED UNDERCOATS

Epoxy undercoat Hydro Primer 40, polyacrylic undercoat Hydro Primer 46.

RECOMMENDED SYSTEM

Industrial and marine atmosphere

POSSIBLE SYSTEMS

Product	Coats	Wet thickness	Dry thickness
Hydro Primer 40	1	160	80
Hydro Primer 40	1	160	80
Hydro Epox 61	1	140	70
total	3	460	230

Product	Coats	Wet thickness	Dry thickness
Hydro Primer 46	1	200	100
Hydro Epox 61	1	140	70
total	2	340	170

TECHNICAL DATA SHEET

HYDRO EPOX 61

Waterbased epoxy enamel

INSTRUCTIONS

To carry out the work in a proper way, it is needed to strictly follow the instructions for the preparation of the surfaces contained in the CAP Arreghini Books. The specification data and technical information have been calculated at +23°C with relative ambient humidity of 65%. In different conditions the data and the time intervals between the two phases of the above reported coating system may vary. This technical information is intended as a rough guide. However, because of the enormous variety of media and application conditions, it is essential to check the suitability of the product and test the effectiveness on a sample.