

NATURE AND USE

Pithostop is a two component Ceramic epoxy paint. The product is solvent and benzyl Alcohol free, it contains no free or combined aromatic amines, is free also from plasticizers butyl phthalate based.

Pithostop is studied for alimentary contact: all its components are included in the positive substances list, allowed and provided for by the Italian and European laws with regards to alimentary contact. The product, correctly applied and fully polymerized, complies with CEE regulations nr. 1895/2005, about the restrictions involving some epoxy derivatives in materials expected to come in contact with alimentary substances. The product is certified according to the D.M. 21/03/1973 (simulants A, B, C, D) and following updating for continuous, direct and extended contact with all alimentary substances both liquid and solid ones, such as grains, flowers, fruit or vegetable purée, vegetable oils, wine, beer, potable water, slaughtered meat, fish, etc. Pithostop is mostly used as coating or vitrification of the internal of tanks containing potable water, silos for cereals, wine vats, cisterns for vegetable oils, refrigerator cells etc.

Pithostop can also be applied as internal high thickness coating of steel tubes transporting potable water or water to become potable, provided that the product is certified also according to the DM 174 dated 06/04/2004 And following updates.

The coating forms a hard, compact non-toxic film, which is long lasting through times, resistant to many chemical agents aggressions such as mild solutions of acids and alkali, brackish water (tested with a content of 35% NaCl in water) and sea water, lubricating oil, diesel oil, fuel, natural gas, sewage water.

Note : Like other materials of the same nature and type also Pithostop polymerized film, when operating exposed in air in external ambient, due to the action of atmospheric agents (sun, rain etcetera) may undergo colour changing with chalking and tarnishing.

These phenomena are only aesthetic ones and do not indicate a loss of the corrosion protection property from the coating itself as the characteristic of the film is not altered.

Avoid the product application under critical humidity and temperature conditions (We recommend not to use at temperature below +10°C).

SSOG Certificate Nr. 18LA00981 and UNIONE ITALIANA VINI r.d.p. N° 18VR20372 -18VR20373 - 18VR23841 18VR23842-18VR23843-18VR23844 and encl/

TECHNICAL DATA

Type of Binder:	Epoxy-Polyamine
Specific Gravity A+B:	Kg/l 1,30 ± 0,05 @ +20°C
Solids by Weight and Volume:	% 100 ± -2 % A+B
Mixing ratio by Weight:	70 parts of Base / 30 parts of Hardener
Mixing ratio by Volume:	2 parts of Base / 1 part of Hardener
**Pot life @ +20°C	~ 60 minutes ± 10
Temperature resistance:	Up to +80°C (exposition in dry air and without simultaneous mechanical stress)
Suggested Colour A+B:	Oxide red (red wine, tomato sauce etc.) Okra yellow (white wine, beer, vegetable oil etc.) White (Potable water, vegetable oil etc.)
Film Appearance:	Glossy



SUBSTRATE PREPARATION

All kind of steel substrates: Cleaned, degreased, decontaminated, roughened and perfectly dust free. Substrates must always be humidity free and when necessary, treated with a suitable primer.

Gelcoat: Dry Sandpapering with abrasive paper type P120-P180.
Before applying Pithostop verify that the substrate must be fully dry (U.R. $\leq 0,8\%$).

Steel: Sandblasting minimum to SA 2.5 according to ISO 8501/1 for steel, minimum roughness Rz DIN 60 - 100 μm . Follow with accurate dusting by dehumidified compressed injected air

Cement: The cement should be clean (free from oils, detaching greases and any contaminant) completely dry (less than 4% of internal humidity), and fully seasoned: about 28 days for ordinary Portland cement, then roughened and dust free. The substrate must have no detaching particles and no efflorescence.
Before application of PITHOSTOP verify the total internal absence of actions generated by water presence and due to capillarity and water creeks.

PRODUCT PREPARATION

Perfectly mix the two components and wait 5 minutes before application.

** The "POT LIFE" time of two components products (time within which it is possible to apply the paint mix of Base and Hardener), is exponentially dropped by the increase of product temperature.

Note: The use of a mix of paint (Base + Hardener) over the POT LIFE time is irreparably compromising all the properties of the coating film.**

APPLICATION DETAILS

Application method:	Standard Airless Spray Dual Feed Hot Airless Spray for two component with compression ratio 60:1 minimum Roller, Brush
Nozzle diameter:	0.015 - 0.031 inches (indicative value)
Nozzle pressure:	240 - 300 Kg/sqcm
Suggested temperature of the preheating (airless-bi-mixer):	Base +50/+60 °C / Hardener +40/+50 °C
Thinning:	Product ready to use. Possible thinning only in particular conditions (application method used, Need to impregnate porous substrates, others..) using only Ethyl Alcohol "Buon Gusto" (for Alimentary use) but in a percentage not higher than 3% maximum by Volume. N.B.: The use of excessive amount of thinner in high thickness coatings and /or without solvent, might cause "solvent entrapment", bringing to a premature failure of the coating.
Cleaning:	Thinner for epoxy products
Hardening @ +25°C:	Dust free 3 – 5 hours Trough Dry 24 - 36 hours Fully cured 10 days
Overcoating @ +20°C:	Within 24 - 36 hours

Application Temperature	Between +10°C and +35° C
Temperature of the product:	Between +10°C and +35° C
Temperature of the substrate:	Between +10°C and +35° C and always at least +3/+5 °C above dew point
Relative Humidity:	≤ 85%
Suggested Thickness per coat:	300 µm; min. 250 / max. 500 µm dry (DFT)
Theoretical spreading rate:	sqm/Kg ~ 2,55 @ 300 µm (DFT)
Theoretical consumption:	g/sqm ~ 390 @ 300 µm dry (DFT)
More info by writing to sales@industribrunostoppaipaints.com or by calling +39 030 9745116	

REMARKS about the coating treatment before and during service:

Before commissioning:

- 1- Wait the complete polymerization condition of the material (full curing) that is at least 10 days @ +25°C.
- 2 - Always verify the hardness of the coating, which must reach a final value of $\geq 75 \pm 5$ when measured with a durometer "Shore D" or ≥ 94 points when measured with durometer Buchholz (typical values of the polymer @ +23 \pm 2 °C).
- 3 - Sanitize the coating washing with an aqueous solution with 10% of Soda, continuing with repeated washing systems using potable water.

Final rinse with the liquid to be contained is strongly recommended.

****Attention:** Tarnishing and/or chromatic changes of the coating after commissioning and in exercise are aesthetical phenomena only and do not indicate a performance loss of the material.

HANDLING STORAGE AND SAFETY PRECAUTIONS

Warning: All handling and/or use activities of the material and its components must strictly refer to the given indications in the Safety Data Sheet (Base and Hardener). The following advices are stated by common sense and in good faith, they are uncompleted and do not substitute the content of each specific safety data sheet of the product.

Handling: The material must be used only by professional and qualified applicators suitably trained. All the operations involving the use of the product, must be carried on in compliance with all the relevant National Health, Safety & Environmental standards and regulations.

Precautions: When the product is used in enclosed areas (rooms, containers, vessels, etc.) it is imperative to use adequate means providing the necessary air circulation, to be granted during the whole application and coating polymerization time, also to avoid conditions open to potential explosion danger.

All electrical installations must always be grounded. Where explosion hazards exist, the workmen should be required to use only non-ferrous tools and wear conductive non-sparking shoes and clothing. Explosion and flame-proof equipment too are required.

Storage and transport: Keep far from flames, sparks or heat sources. Do not leave exposed under direct solar

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The content of the present technical data sheet is the most complete currently available, based on practical experience and given in good faith. Should any change 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 product for the intended use under his own risk and responsibility. No warranty is impressed or implied. The Company refuses all liability not directly related with defects of the product or consequent to deviations from written instructions.



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Company with quality management system UNI EN ISO 9001:2015 certified

action. Store under shelter in original unopened packaging, in cool, dry and ventilated areas, at temperatures between +5°C and +35°C.

Shelf life: **Base** **12 months** in the suggested storage conditions (original unopened packaging)
Hardener **12 months** in the suggested storage conditions (original unopened packaging)

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

Refer to Material Safety Data Sheet



Access catalogues, data sheets and company presentations