

## NATURE AND USE

Pithostop varnish is a two component, solvent free epoxy vitrescent suitable to get in contact with alimentary substances according to the Ministerial Decree dated 21/03/1973 and following updates.

The product is Benzyl alcohol free and is certified for continuous contact with liquid or solid substances such as cereals, flours, potable water, vegetal oils, wine, beer etc.

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.

No free or combined aromatic amines are present in the product.

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

These phenomena are only aesthetic ones and do not indicate a loss of the corrosion protection property from the coating 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. 17LA01189

## TECHNICAL DATA



Type of Binder:	Epoxy-Polyamine
Specific Gravity A+B:	Kg/l 1,10 ± 0,05 @ +20°C Base / 1,00 ± 0,05 @ +20°C Hardener
Solids by Weight and Volume:	% 100 ± -2 % A+B
Mixing ratio by Weight:	65 parts of Base / 35 parts of Hardener
Mixing ratio by Volume:	65 parts of Base / 35 parts of Hardener
**Pot life @ +20°C	~ 45 ±10 minutes
Temperature resistance:	Up to +80°C (exposition in dry air and without simultaneous mechanical stress)
Polymerized Film Appearance:	Glossy

## SUBSTRATE PREPARATION

**All type 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 Vernice verify that the substrate must be fully dry (U.R. ≤ 0,8%).

**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 VERNICE 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.\*\*

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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

## APPLICATION DETAILS

<b>Application method:</b>	Standard Airless Spray with compression ratio 45:1 minimum Airmix spray application Roller, Brush (or in particular cases by pouring, asking for info our technical dpt.)
<b>Thinning:</b>	The product is 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.
<b>Cleaning:</b>	Thinner for epoxy products
<b>Hardening @ +25°C:</b>	Dust free 3 – 5 hours Trough Dry 24 - 36 hours Fully cured 10 days
<b>Overcoating @ +20°C:</b>	Within 12 - 24 hours
<b>Application Temperature</b> <b>Temperature of the product:</b> <b>Temperature of the substrate:</b>	Between +10°C and +35° C Between +10°C and +35° C Between +10°C and +35° C and always at least +3/+5 °C above dew point
<b>Relative Humidity:</b>	≤ 85%
<b>Thickness per coat:</b>	min. 100 / max. 250 µm dry (DFT)
<b>Theoretical spreading rate:</b> sqm/l	~ 10 per coat at a dry film thickness of 100 µm (DFT) depending on the roughness and porosity of the substrate as well as on the application method.

More info by writing to [sales@industri brunostoppa nipa nts.com](mailto:sales@industri brunostoppa nipa nts.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  $\geq 94$  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.

Possible final rinse with wine or 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.

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## 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 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