

NATURE AND USE

Stopcoat 410 HB is an Epoxy-polyamide product. Studied as Primer and intermediate coat for anticorrosion Coating systems, the product is particularly recommended for the maintenance of structures and plants in aggressive atmosphere.
It can be used as **tie-coat** on epoxy and inorganic galvanizing products.

TECHNICAL DATA

Protection from corrosion:	The application of one single coat provides good protection to steel Steel substrates
Abrasion:	Good resistance to abrasion and to mechanical damage
Adhesion:	Excellent on substrates duly prepared
Resistances:	
Acid solutions.....	Good
Alkaline solutions.....	Excellent
Sea water.....	Excellent
Deionised water.....	Good
Marine atmosphere.....	Excellent
Industrial atmosphere.....	Excellent
Petrochemical atmosphere.....	Excellent
Temperature.....	+70/+ 80°C (in continuous in air, dry conditions)

TECHNICAL DATA



Specific Gravity A+B:	kg/l	1,35 ± 0,05 @ +20°C
Solids by Weight:	%	73 ± 2 % A+B
Solids by Volume:	%	60 ± 2 % A+B
Mixing Ratio by Weight:		83 parts of Base / 17 parts of Hardener
Mixing Ratio by Volume:		75 parts of Base / 25 parts of Hardener
**Pot life @ +20°C:		≥ 6 hours
Colour:		Grey, (satin)

SUBSTRATES PREPARATION

All types of substrates: All surfaces must be free from residual of greases and contaminants.
After roughening, perform accurate dust removal. Verify that the substrates to coat are always completely free from traces of humidity.

Steel: Sandblasting at grade SA 2,5 according to ISO 8501/1 with minimum roughness profile Rz DIN 30 – 60 µm. When sandblasting is not possible, the substrate should be dry, degreased, perfectly cleaned and free from rust or calamine, mechanically abraded at the minimum grade ST3 according to ISO 8501/1.

Steel already coated: All detaching or not well anchored parts of old paint must be mechanically stripped as well as all rust scraped off. Roughen well the surface to treat to reach the proper adherence between paint and substrate. Eliminate all dust and other residuals from the above operations.

Note: We suggest to verify always in any case and preliminarily the compatibility between old paint and the new one to be applied.

Other Substrates : Perfectly cleaned and duly treated with suitable primer.

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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

PRODUCT PREPARATION

Homogenize separately the two components in their original cans. Mix the two components in the right proportions and stir for 5 minutes until a complete homogenization is reached. Then pour the mix in the dedicated tank of the spray equipment.

** 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 compression ratio 45:1 minimum Conventional Spray Roller, Brush
Airless Spray:	Nozzle 0.015 - 0.020 inches Pressure 150 - 225 Kg/cm ² .
Thinning:	5 / 10 % with Epothinner
Cleaning:	Epothinner
Hardening @ +25°C:	Touch dry ¾ hours Handling 24/36 hours
Overcoating @ +20°C:	24 -36 hours
Application Ambient Temperature:	Between +5°C and +35°C
Suggested Temperature of the product:	+20 ÷ +30°C
Substrate Temperature:	+5 / +40°C always at least +3/5°C above dew point
Relative Humidity:	≤ 85%
Suggested thickness:	75 µm dry (DFT) wet film thickness about 125 µm (WFT) Min. 40 / Max. 150 µm dry (DFT)
Theoretical spreading rate:	sqm/l 8,0 – 6,0 sqm/Kg at the suggested thickness
Theoretical consumption:	g/sqm 167

More info by writing to sales@industri brunostoppa nipa nts.com or by calling +39 030 9745116

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