

NATURE AND USE

Stopcoat 411 is a two component epoxy polyamide high build coating modified with vinyl copolymers for a Long overcoatability. The product is semi-glossy and generally supplied in light ivory colour but is available also in sample colours on demand.

Suitable as intermediate / top coat for anticorrosion and maintenance coating systems exposed to severe environmental conditions, as primer with good adhesion on light alloys, galvanized steel plates and galvanized sheets or as tie-coat for inorganic zinc based products if applied "wet on wet".

Note: Like all materials of the same nature and type also Stopcoat 411 polymerized film, when 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 as the characteristic of the film is not altered.

GENERAL PROPERTIES

Protection from corrosion: The application of one single coat provides good protection to steel substrates.

Abrasion: Good resistance to abrasion and to mechanical damage.

Adhesion: Excellent on substrates duly prepared.

Resistances:

Acid solutions.....Good *

Alkaline solutions.....Good *

Sea water.....Good *

Deionised water.....Good *

Marine atmosphere.....Excellent

Industrial atmosphere.....Excellent

Petrochemical atmosphere.....Excellent

Temperature.....+70/+80°C (in continuous and in air, dry conditions).

* smokes, vapours, sprays.

TECHNICAL DATA

Specific Gravity A+B: kg/l 1,40 ± 0,05 @ +20°C

Solids by Weight: % 73 ± 3 % A+B

Solids by Volume: % 58 ± 3 % A+B

Mixing Ratio by Weight: 90 parts of Base / 10 parts of Hardener

Mixing Ratio by Volume: 84 parts of Base / 16 parts of Hardener

****Pot life @ +20°C:** ≥ 6 hours

Colour /Final film appearance: RAL Semi-glossy



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.

New Galvanized Steel : dry, abraded and perfectly degreased

Galvanised Steel previously coated : Abrade in order to remove all traces of rust.

Aluminium : Dry, degreased and lightly abraded, or chemically treated.

Other Substrates : Perfectly cleaned and duly primerized.

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 Ø 0.015 - 0.020 inches Pressure 150 - 180 Kg/cm ² .
Thinning:	5 / 10 % with Epothinner
Cleaning:	Epothinner
Hardening @ +25°C:	Touch dry 3/4 hours Handling 24/36 hours
Overcoating @ +20°C:	Minimum 18-24 hours /Maximum unlimited
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:	80 µm dry (DFT) wet about 140 µm (WFT) Min. 50 / Max. 150 µm dry (DFT)
Theoretical spreading rate:	sqm/l 7,0 – 5.2 m ² /Kg at the suggested thickness
Theoretical consumption:	g/sqm 190

More info by writing to sales@industribrunostoppapaints.com or by calling +39 030 9745116

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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

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