

# STOPCOAT 411 FINISH

Two component epoxy vinyl finish

## NATURE AND USE

**Stopcoat 411 Finish** is a two-component epoxy polyamide high build coating modified with vinyl copolymers studied as finish for new and maintenance coating systems operating in severe exposure conditions.

Note: Like all materials of the same nature and type also Stopcoat 411 Finish 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:

% 56 ± 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 Appearance of the film:

RAL Semi-glossy

## SUBSTRATES PREPARATION

**Steel:** On substrate blast cleaned to SA 2,5 apply one coat of epoxy undercoat or of primer with zinc. After 24 hours apply a second coat of epoxy intermediate and then complete with 1-2 coats of Stopcoat 411 Finish enamel, recoat interval 24 hours between each coat.

**Aluminium, Light alloys, Hot Galvanized Steel:** Remove the oxidized superficial coat by mechanic brush or grinding disk. Remove dust and brushing residuals, degrease the substrate with Epothinner and apply 1 coat of STOPCOAT 305 or EPOXY PRIMER 938 or other suitable Primer. Finish with the application of 1-2 coats of Stopcoat 411 Finish, recoat interval 24 hours between each coat.

**Substrates already coated:** Verify the compatibility with the underlying material, perform very accurate cleaning of the substrate and removal of any contaminant. The substrate shall be perfectly dry and free from any traces of humidity.

MTDS 01018/ Page 1 of 3

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**Other substrates:** Cleaned, adequately prepared and treated with suitable primer.

## 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

<b>Application method:</b>	Standard Airless Spray compression ratio 45:1 minimum Nozzle Ø 0.015 - 0.020 inches Pressure 150 - 180 Kg/cm2.
<b>Thinning:</b>	5 / 10 % with Epothinner
<b>Cleaning:</b>	Epothinner
<b>Hardening @ +25°C:</b>	Touch dry 4/5 hours Handling 24/36 hours
<b>Overcoating @ +20°C:</b>	Minimum 18-24 hours /Maximum unlimited
<b>Application Ambient Temperature:</b>	Between +5°C and +35°C
<b>Suggested Temperature of the product:</b>	+20 ÷ +30°C
<b>Substrate Temperature:</b>	+5 / +40°C always at least +3/5°C above dew point
<b>Relative Humidity:</b>	≤ 85%
<b>Suggested thickness:</b>	80 µm dry (DFT) wet about 140 µm (WFT) Minimum 50 / Maximum 150 µm dry (DFT)
<b>Theoretical spreading rate:</b>	sqm/l 7,0 – 5.0 sqm/Kg at the suggested thickness
<b>Theoretical consumption:</b>	g/ sqm 190

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

MTDS 01018/ Page 2 of 3

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**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

MTDS 01018/ Page 3 of 3

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