

VIKING

Two component solvent free epoxy paint, for transport and storage of drinking water

NATURE AND USE

Two component, solvent free epoxy polyamine fast drying coating to be applied with hot bi-mixer spray application (suggested method). Internal high build coating of steel pipes and tanks, suitable to get in contact with drinking water (according to the Ministry of Health DM Nr 174 dated 06.04.2004) and it is suitable also to get in contact with some alimentary substances listed in the enclosure of D.M. dated 21.03.1973 and following updating. (For details please contact our technical dept.).

Viking can be used as internal protection and also as external high built passive protective barrier (alone or used in a coating system with other types of coatings) on steel items operating in the air or buried, when the requirements impose good chemical and mechanical resistances also in critical exercise conditions: the coating forms a hard, compact, non-toxic and long-lasting film, resistant to the aggression of different chemical agents such as sulphuric acid solutions (1% H₂SO₄ in water), caustic soda (1% NaOH in water), 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 Viking 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.

O.T.E.C. Certificate no.07829 / ARPA certificate N. 5146/RGA – 5147/RGA / PDC Lab Certificate N. 08/123/A 08/0123/B / SSICA Certificates Nro 605/1 e 605/2 according to DM 174 06/04/04 and following updates, according to DM 21/03/73 and following updates and according to UE N. 10/2011
Australian AWQC Certificate Nro 43966 to AS/NZS 4020:2005

WRc Certificate N.Mat/LAB 1381 - The product Complies with BS 6920 / Complies with Spanish Royal Decree 866/2008 - Complies with AWWA C-210 - 2015 Report IPN 012/2018 Università degli Studi di Trento .

TECHNICAL DATA

Specific Gravity A+B:	kg/l	1,55 ± 0,05 @ +20°C
Solids by Weight and Volume:	%	100 % 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 ± 10 min. about
Temperature Resistance:		Up to +80°C (exposition in dry air. without simultaneous mechanical stress)
Colour:		White (Honey on request)
Appearance		Glossy



SUBSTRATE PREPARATION

All kind of steel substrates: Cleaned, degreased, decontaminated, roughened and perfectly dry (when necessary, treated with a suitable primer. Info available by our Technical Service).

Steel : Sandblasting to SA 2,5 minimum, according to ISO 8501-1 for steel, with minimum roughness profile Rz DIN 60 – 100 µm. Then accurately remove all dust with compressed dehumidified air jetting.

PRODUCT PREPARATION

Stir the two components separately in their original supply can. Check Base and Hardener quantity taken to prepare the mix for the required application.

Bi-mixer application: Pour each of the two components in the dedicated bi-mixer heating tank. Heat each of the two components until a proper atomisation spray has been reached as to fluidity.

MTDS 09018/ Page 1 of 3

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.



INDUSTRIE BRUNO STOPPANI R.P.S. S.r.l.

Sede Operativa: Via Industriale 90-119 25020 Capriano del Colle (Bs) – Italy - Phone +39 030 9745116 – Fax +39 030 9745383

sales@industri brunostoppa paints.com - www.industri brunostoppa paints.com

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

VIKING

Two component solvent free epoxy paint, for transport and storage of drinking water

Airless and hard bristle brush application: After the catalysis of the two components, stir the mix for not less than 5 minutes until a complete homogenization is reached.

****** 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:	Dual Feed Hot Airless Spray for two component with Compression ratio 60:1 minimum Standard Airless Spray with compression ratio 68:1 minimum only in specific conditions Hard bristles brush, only for small touch up, repairs and limited surfaces Traditional airless pump with compression ratio 60 : 1 minimum, only in specific conditions Ask for info our tech. Service dept.
Nozzle diameter:	0.015 - 0.031 inches (indicative data)
Nozzle pressure:	240 - 300 Kg/sqcm
Suggested temperature of the preheating (airless-bi-mixer):	Base +50/+60 °C Hardener +40/+50 °C
Product temperature before its application (Hard bristles or traditional airless):	+25/+30 °C (Suggested temperature)
Thinning:	None – Do not thin
Cleaning:	Thinner 215 or Epothinner
Precautions:	All the equipment must be immediately cleaned after use with Thinner 215 or Epothinner
Hardening @ +25°C:	Dust dry 5 – 7 hours Handling after 18 - 30 hours Fully cured 7 days at +25°C
Overcoating @ +20°C:	Within 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 per coat:	400µm DFT; Min. 250/Max. 600 µm dry (DFT)
Theoretical spreading rate:	sqm/Kg 1.6 or 2.5 sqm/l at a dry film thickness of 400 µm (DFT)
Theoretical use:	g/sqm ~ 625

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

MTDS 09018/ Page 2 of 3

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.



INDUSTRIE BRUNO STOPPANI R.P.S. S.r.l.

Sede Operativa: Via Industriale 90-119 25020 Capriano del Colle (Bs) – Italy - Phone +39 030 9745116 – Fax +39 030 9745383

sales@industri brunostoppa nipa nts.com - www.industri brunostoppa nipa nts.com

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

VIKING

Two component solvent free epoxy paint, for transport and storage of drinking water

PRECAUTIONS IN CASE OF WATER FOR HUMAN CONSUMPTION PIPELINE AND TANKS (INTERNAL)

Verify that the internal of pipes and tanks during coating and curing is duly ventilated to grant good air changes through application time.

Before commissioning the pipeline or tank, rinse repeatedly the internal surface with water and/or other suitable products/solutions to grant a hygienic surface.

To get further suggestions for the pipelines coating, please contact our Technical Department

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

FURTHER ADVISES

Excess Product	Hardener and Base: Close the cans/drums properly and store as above specified. Check the Shelf Life of the product.
Cured product	Disposal of waste accordingly to local environmental specifications



Access catalogues, data sheets and company presentations

MTDS 09018/ Page 3 of 3

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.



INDUSTRIE BRUNO STOPPANI R.P.S. S.r.l.

Sede Operativa: Via Industriale 90-119 25020 Capriano del Colle (Bs) – Italy - Phone +39 030 9745116 – Fax +39 030 9745383

sales@industri brunostoppa nipa nts.com - www.industri brunostoppa nipa nts.com

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