



EPOCOAT 210

TECHNICAL DATA SHEET 2/21

PROPERTIES AND RECOMMENDED USAGE

Paint type

Epocoat 210 is a two component, fast drying, polyamide cured epoxy top coat.

Typical and recommended uses

As a top coat in epoxy based paint systems in environmental classes C2-C5. Can be recoated also with polyurethane paints.

Chemical resistance

Used in recommended paint systems and correctly applied Epocoat 210 withstands splashes and spillage of occasional water, oil and weak process chemicals.

Weather resistance

Epoxy paints have a natural tendency to chalk and discolor on exterior exposure.

Colour

RAL-, NCS-, KY-, SSG-colours with limitations. The objects painted with the same shade, but using different paint types, might have differences in the appearance and shade due to the variation in the paint properties, gloss levels and application methods.

Finish

Semigloss

TECHNICAL DATA

Volume solids*	53 ± 2 %
Total mass of solids*	740 g/l
VOC value*	420 g/l

* Values are calculated

Mixing ratio

Resin	4 parts by volume
Cure	1 parts by volume

Pot life (+23 °C)

Standard Comp. B	approx. 7 h after mixing
S-Comp. B	approx. 3 h after mixing

Packaging

	Volume (l)	Size of container (l)
Comp A	8 / 16	10 / 20
Comp B	2 / 4	2 / 4,2

Drying time 70 µm +23 °C

	Stand. Comp. B	S-Comp. B
Surface dry	1,5 h	1 h
To touch	4 h	3 h
To recoat	4 h	3 h
To handle	8 h	6,5 h
Fully cured	7 d	7 d

Drying times are typical on recommended film thicknesses at given temperatures.

Calculated theoretical coverage and recommended film thickness

Dry	Wet	Coverage
50 µm	95 µm	10,5 m ² /l
70 µm	135 µm	7,4 m ² /l
80 µm	150 µm	6,7 m ² /l

Practical coverage

Depends on wind conditions, structure to be painted, roughness of the surface and application method.

Thinner

OH 17, OH 31 (slow)

Roller thinner

OH 12

Cleaner

OH 17

APPLICATION INSTRUCTIONS

Surface preparations

All solid impurities that could prevent adhesion should be removed from the surfaces to be painted. Remove salts and other water soluble impurities by wet cleansing with brush, high pressure-, steam- or alkali cleansing. Remove grease and oils by alkali-, emulsion- or solvent cleansing (SFS-en ISO 8504-3, SFS-EN ISO 12944-4). The surfaces should be rinsed carefully with fresh water after cleansing. Old, painted surfaces, in which maximum overcoating interval has expired, additional roughening with suitable method is recommended. The place and time for the surface preparation should be chosen correctly, to avoid contamination and moistening of the treated surface before the paint application.

Primer

EPOCOAT 21 PRIMER, EPOCOAT 21 HB,
NORECOAT FD PRIMER, NORMAZINC SE,
PENGUARD EXPRESS, NORECOAT HS

Top coat

EPOCOAT 210

Environmental conditions during application

The surface should be dry and clean. During application and drying time the temperature of the paint, air, and surface should be above +10 °C and the relative humidity below 80 %. The surface temperature should be min 3 °C above the dew point of the air. Exhaust gases during drying process may cause yellowing of the paint film.

Disclaimer

The above information is given to the best of our knowledge based on laboratory tests and practical experience. However, as the paint is often used under conditions beyond our control, we cannot guarantee anything but the quality of the paint itself. We reserve the right to change the given data without notice. Please contact our office for more specific information. The product is intended for professional use only. If there are deviations in the different language versions of the technical data sheets, the English version applies.

Method of application

Use airless spray or brush. Stir resin and cure separately and then mix both components thoroughly. The mixing ratio is 4:1 (resin:cure) by volume. If needed, 0-10 % thinner (OH 17) may be added. High pressure airless spray with a nozzle tip of 0,013" - 0,015" orifice. Spray angle depending on the object to be painted. In order to ensure the best possible performance of the product, it is recommended that the paint is at room temperature before the application.

Storage and shelf life

The product must be stored in original sealed containers at temperatures from 5 °C to 30 °C. The storage conditions are to keep the containers in a dry, well ventilated space away from source of heat and ignition. When stored as described above, the unopened component A will keep up to 3 years and unopened component B to 2 years from the date of manufacture. The manufacturing date found in the label is also the batch number of the paint.

Safety

Please follow the environmental and safety instructions displayed on the container and Safety Data Sheet. Use under well ventilated conditions. Do not breathe or inhale mist, use respirator mask. Avoid skin contact. Spillage on the skin should immediately removed with suitable cleanser, soap or water. In case of contact with eyes, rinse immediately with plenty of clean water and if necessary seek medical advice.