

2 PACK EPOXY FINISH

INTENDED USE

METAL FINISHING

A high performance, very tough durable coating. It has excellent resistance to mechanical damage, solvents, chemicals, humidity and occasional water immersion. When applied to well prepared substrates two pack epoxy systems (primers and topcoats) give very high levels of corrosion resistance.

NOTE When any epoxy system is used externally the colour will change and a chalky deposit appears on the surface due to the effect of UV light on the epoxy resin. Where 'high gloss' and 'colour stability' is required for exterior use overcoat epoxy primer with 2 Pack Acrylic Polyurethane.

DECORATION OF BUILDINGS - Factory Floor Finish

Dries with a high gloss and is suitable for floors subject to heavy use, such as regular use by fork lift trucks.

Do not use at temperatures below 10C during application and for 24 hours afterwards. For conditions below 10C use Promastic 600CT.

As a CONCRETE SEALER the first coat is thinned 2 Parts mixed paint with 1 part 2 Pack Epoxy Thinner which gives a VOC content of 600 g/litre VOC.
VOC classification 2004/42 Cat A/(h): 750 g/l (2010)

As a FLOOR FINISH apply unthinned when the VOC content is 475 g/litre mixed.
VOC classification 2004/42 Cat A/(j): 500 g/l (2010)

ARTICLES - that are not part of a building structure (and therefore are outside the scope of the building products VOC Product Directive)

Used as a refurbishment or maintenance coating whenever chemical, humidity and solvent resistance is required, for items such as:

INSIDE BUILDINGS: Machinery, fixed plant, moveable equipment, fork lift trucks, trolleys, frames, guards etc.

OUTSIDE BUILDINGS: Exterior surfaces of tanks, pipework and process plant, towers, bridges or any structure which is not part of a building

See also the Manor supplementary information sheet 'Guide to the UK VOC legislation' to understand how the VOC content of a coating determines its suitability for use in any application.

FOR ANYTHING OTHER THAN FLOORS

Manor 2 Pack Epoxy must be applied to a suitable primer: UPF, Promastic 600CT or 2 Pack Epoxy Primer

Surfaces must be dry, sound and free from dirt, dust and grease. Previously painted glossy surfaces should be lightly abraded prior to application to promote adhesion.

NEW CONCRETE

Apply only to dry, well prepared concrete after removal of loose cement laitance by scarifying or acid etching, then vacuuming. Apply the first coat as a sealer coat thinning 2 parts catalysed paint with 1 part Two Pack Epoxy Thinners, followed by one or two finishing coats leaving overnight to dry between coats.

PREVIOUSLY PAINTED FLOOR

Inspect the original coating for adhesion using a cross hatch test (cut an X in the coating with a sharp knife, apply strong adhesive tape over it and pull off sharply). If the paint is removed, blast or scarify the floor to remove the old coating. If the old paint remains intact then paint a test area to check the intercoat adhesion between old and new, leave for 48 hours to cure and repeat the cross hatch test. If there is any failure then the floor should be thoroughly abraded and the test repeated. If the test area wrinkles or lifts then the coating will have to be removed before using Two Pack Epoxy.

SUITABLE SUBSTRATES AND PREPARATION

AVAILABILITY

Gloss, semi-gloss and semi-matt finishes supplied in 3 litres of Base 'A' in a 5 litre tin; and 2 litres of Hardener 'B' in a 2.5 litre tin. An extensive range of colours are available from the Manormix scheme.

PRODUCT INFORMATION

(TYPICAL FIGURES)

Composition	Based on epoxy resin, pigmented with suitably selected pigments, the hardener contains a polyamide adduct.
Volume Solids	45% (for White when mixed)
Weight Solids	62% (for White when mixed)
VOC content	Base 430 g/litre Hardener 543 g/litre Mixed 3:2 475 g/litre (unthinned)
Supply Viscosity	Base 4 poise at 20C
Typical film thickness	90 microns wet and 40 microns dry
Theoretical coverage	11 sq. metres/litre at 90 microns wet film thickness.
Dry heat resistance	140C (some yellowing may be expected)
Flash Point	Within the range of 21-31C
PREFERABLY BRING PAINT TO 15-25C AND STIR WELL BEFORE USE	

APPLICATION DETAILS

Mixing	Mix 3 parts of Base to 2 parts Hardener by volume and allow product to stand for a few minutes before application. Once mixed the product has a workable life of approximately 6 hours, dependent on temperature.
Airless spray:	cold Up to 5% thinners may be added to suit equipment Typical tip size 9-13 thou or 0.23-0.33 mm Typical fluid pressure 140 kg/sq metre or 2000 p.s.i. heated Not recommended
Conventional spray	After mixing thin with approximately 20% thinners to a viscosity of 35-45 seconds BS B4 Flow Cup.
Brush Roller	Ready for use when mixed.
Thinner	2 Pack Epoxy Thinner

Film thickness per coat

	<u>Dry</u>	<u>Wet</u>
Minimum	25 microns	55 microns
Maximum	40 microns	90 microns

DRYING AND RECOATING

Approximate drying times at 40 microns d.f.t.

<u>Substrate temperature</u>	<u>Touch Dry</u>	<u>Overcoating times</u>	
		Minimum	Maximum
10C	4-6 hours	16 hours	3 days (see note)
20C	2-3 hours	8 hours	3 days (see note)

Environmental conditions	The air temperature should be at least 10 C with a surface temperature 3 C above the dew point and the relative humidity below 90% thus ensuring that the surface is dry and that condensation will not occur. Curing will cease if the temperature falls below 5C and may not resume if the film is allowed to pick up moisture.
Overcoating / repainting	If required a further coat of Manor 2 Pack Epoxy may be applied. If left for more than 3 days between coats, it is important to abrade the surface to improve adhesion.

SHELF LIFE

Store in cool, dry conditions, typically 5-25C. After a period of storage the product should be thoroughly stirred. Usable life is 2 years from date of manufacture in unopened containers.

**SAFETY
PRECAUTIONS**

Refer to Manor Safety Data Sheet

LIMITATIONS

The information given in this data sheet is based on experience and is accurate to the best of our knowledge. No guarantee should be implied however, since the conditions of use are beyond our control. This data sheet does not constitute a specification.

A Painting Guide can be accessed via our website which provides additional information on paint and painting and definitions of terminology.

In case of doubt as to the suitability of the product please consult our Technical Department. If you are advised that the paint can be used in a manner not specified on this datasheet our Technical Department will confirm this to you in writing. Do not use paint prior to receiving this confirmation.

References to other primers, topcoats, cleaners and thinners are to the Manor Product of that name only.

This data sheet supercedes all previous issues.

REFERENCES

Amended date: November 21, 2012

Reference and number:TP- 6