

### FLEXIMETAL – EPP - MDF LINE

**DESCRIPTION** : It is an epoxy resin based, two-component primer containing anti-corrosive pigments. It has a reactive drying feature. It can endure up to 400-450°C. Paint film layer does not deteriorate, crack or fade up to 400-450 °C. Additionally, it is highly flexible.

**AREAS OF USE** : It can be easily applied on all metal surfaces that are subject to 400-450 °C temperature and that require corrosion resistance. Due to its high flexibility, it easily tolerates temperature differences.

**SOLVENT** : Solvent – Epoxy thinner

**APPEARANCE** : Half Matt

**COLORS** : Terra cotta, brown, gray

**DENSITY** : 1,30 Kg/L (as a mixture)

**SOLIDS** : by volume : % 62 ± 1 (ASTM D 2697-03)

**V.O.C.** : 331 g/L (ASTM D 3960-05)

**FLASH POINT** : 40<sup>0</sup> C ± 2

**PACKAGE** : 20 kg 1.component 5 kg 2.component

**STORAGE** : The product should be stored in a cool and dry location. Package covers should always be closed. Best kept over 5°C. Under proper conditions storage life is 1 year.

**PREPARING THE PAINT** : **Mix well before use.** Open packages should not be used and supplier should be contacted. Due to the two-component nature of the product, it is utmost important to that the mixture is made as per stated amounts. Any different mixture will contradict all theoretical estimations.

**PREPARING THE MIXTURE:** 1.component is the paint and 2. component is the hardener. The paint and the hardener should be mixed as **4:1 ratio by weight**. The amounts should be precise, any variation should be avoided. The mixture should have the fluidity for being used with epoxy thinner. The mixture should be used within 4-8 hours after preparation. Otherwise, the mixture will become jelly-like and unusable. When the two components are mixed, a drying reaction will begin. Thus, the produced amount should be equivalent to the amount to be used.

**PREPARING THE SURFACE:** Endurance of the coating system depends on cleaning the surface properly. The surface should be well cleaned from dirt, rust, grease and other unspecified layers. Best solution is received by spraying method in accordance with DIN 55928 section 4, standard degree Sa 2 ½ or DIN ISO 12944-4.

**APPLICATION TEMPERATURE:** The air and surface temperature should be between +5 and +30 degrees Celsius. Relative humidity rate is as important as the temperature. Surface temperature should be at least 3 °C more than dew point temperature.

**APPLICATION METHOD :** with airless or air gun.

**APPLICATION :** The application can start after the surface is prepared for painting and the paint is mixed as described. During application the equipment is as important as the paint. Airless systems are recommended. It is utmost important that the mixture is made as per stated amounts and the temperature should be at least over 5°C during application. One coat can be applied on top of the other. Two coat applications are recommended. During wet coat applications, at least 30 minutes flash off period should be waited. After this period, the second coat application can begin. Then the surface should be left for drying naturally or oven-dried.

**DRYING TIME :** Considering 20<sup>0</sup> C and 65% of relative humidity rate, non-dust holding drying would take 4 hours and dry to handle would take 8 hours. Full drying would occur after the painted area is heated up to 450°C. Since the product is heat resistant, it is important for full drying that the painted area is heated up to above mentioned degree. In oven drying 30 minutes in 80 °C would suffice.

**PAINTED AREA :** On both coats, depending on the surface 5 m2 can be painted with 1 kg. (calculations based on 100 micron dry film thickness)

**SAFETY WARNINGS :** Keep out of reach of children. Store in a cool location; 10-25°C is recommended. Upon contact with the eye, wash with fresh water and consult a doctor. Immediately consult a doctor when swallowed.

**DANGER WARNINGS :** Injurious to health when swallowed.