



Product Data Sheet

DAI NIPPON TORYO. CO., LTD.
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For more or latest information please consult DNT

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FEATURES: <ul style="list-style-type: none"> • Superior Corrosion Resistance and Adhesion to Steel. • Excellent Chemical, Water and Salt Water Resistance. 	NO./NAME: 1 8 0 1 EPONICS #10 UNDER COAT
	TYPE: Polyamide Amine Cured Epoxy Primer.
	SHIPPING WEIGHT: 16kg. Unit (12.8kg. Base, 3.2kg. Hardener) 4kg. Unit (3.2kg. Base, 0.8kg. Hardener)

SPECIFICATION DATA

PACKAGE	2 Component				
COLOR	Red Iron Oxide, Iron Oxide, White, Grey				
FINISH	-				
SPECIFIC GRAVITY @23	Mixed Material : 1.35				
	Volatiles : 0.85				
VISCOSITY @23	80 Krebs Units				
SOLIDS CONTENT	67 % - by weight				
DRYING TIME		@5 (41)	@20 (68)	@30 (86)	@40 (104)
	To Touch (hours)	3	1	1/2	1/3
	Tack Free (hours)	24	8	4	2
The recoating time is specified in the application instructions.					
RECOMMENDED DRY FILM THICKNESS PER COAT	30 Microns				
THEORETICAL COVERAGE @ 30 MICRONS	85 g./m ²				
	When estimating working coverages, allow for application losses, surface irregularities, etc.				
FLASH POINT	Base : 22 (72)				
	Hardener : 23 (73)				
SHELF LIFE @23	1 Year				

The above data indicates the average under normal conditions and may vary slightly depending on the conditions.

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EPONICS #10 UNDER COAT

APPLICATION INSTRUCTIONS

SURFACE PREPARATION	SSPC-SP10 (ISO-Sa2 ^{1/2})				
MIXING RATIO	Base 80 Parts to Hardener 20 Parts – by weight				
AGING TIME	Let Stand Approx. 30 Minutes				
POT LIFE (hours)	@5 (41)	@20 (68)	@30 (86)	@40 (104)	
	48	24	12	4	
APPLICAION METHOD	Brush, Airless Spray, Spray				
THINNER REQUIRED	EPONICS THINNER A				
DILUTION RATIO	By Brush 0 ~ 5 %		By Airless Spray 0 ~ 10 %		
RECOMMENDED FILM THICKNESS PER COAT	Dry : 30 Microns Wet : 75 Microns		Dry : 30 Microns Wet : 75 Microns		
AIRLESS SPRAYING CONDITIONS	Air pressure to Pump : 0.4MPa (4kg/cm ²) or more Pump Outlet Pressure : 12MPa (120kg/cm ²) or more Nozzle Tip No. : 163-515 ~ 715				
COATING INTERVALS		@5 (41)	@20 (68)	@30 (86)	@40 (104)
	Min. (hours)	24	12	8	6
	Max. (days)	14	7	7	5

NOTES

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| <ol style="list-style-type: none"> 1.Remove completely all dirt, grease, oil, water or other contaminants from surface to be coated. 2.Mix Base and Hardener in accordance with the specified mixing ratio, then stir thoroughly until it is of uniform constituency prior to application. If the proportion is varied, neither cure nor expected properties may result. 3.Use up the mixed material within pot life. 4.Application in excess of the specified coating intervals may cause the lack of adhesive properties. Should be overcoated within the specified intervals. When it exceeds, rough the painted surface with sandpaper, then clean with rags. 5.For thinning, use EPONICS THINNER A only. | <ol style="list-style-type: none"> 6.Clean all equipment immediately after use with EPONICS THINNER A. Once cured, the material is not dissolved in this thinner. 7.When applied below 10 (50 ° F), curing will be retarded and coating intervals should be checked before overcoating. |
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