



Product Data Sheet

DAI NIPPON TORYO, CO.,LTD.

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For more or latest information please consult DNT

FEATURES: <ul style="list-style-type: none"> • Superior Resistance to Chemicals (Acid, Alkali) and Oil. • Excellent Water and Salt Water Resistance. • High Build Performance Properties. • Outstanding Workability by Airless Spray. 	NO./NAME: 1830 EPONICS #20 INTERMEDIATE COAT
	TYPE: Modified Aliphatic Polyamine Cured,High Build, Epoxy Coating.
	SHIPPING WEIGHT: 20kg. Unit (17kg. Base 3kg. Hardener)

SPECIFICATION DATA

PACKAGE 2 Component

COLOR Full Range Colors

FINISH Semi-gloss

SPECIFIC GRAVITY @23°C Mixed Material :1.37
 Volatiles : 0.87

VISCOSITY @23°C 85 Krebs Units

SOLIDS CONTENT 68% - by weight

DRYING TIME	@5	@20	@30	@40
@100MICRONS	(41°F)	(68°F)	(86°F)	(104°F)
To Touch:	2	1 1/2	1	1/2
Tack Free:	24	8	6	5(hours)

The recoating time is specified in the application instructions.

RECOMMENDED DRY FILM THICKNESS PER COAT 50 ~ 100 Microns

THEORETICAL COVERAGE @100MICRONS 276g./m²

When estimating working coverages allow for application losses, surface irregularities etc.

FLASH POINT Base : 22 (72°F)
 Hardener: 11 (52°F)

SHELF LIFE @20 1 Year

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

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EPONICS #20 INTERMEDIATE COAT

APPLICATION INSTRUCTIONS

SURFACE PREPARATION See Note 1.

MIXING RATIO Base 85 Parts to Hardener 15 Parts - by weight

AGING TIME Let Stand Approx. 30 Minutes

POT LIFE	@5	@20	@30	@40
	(41°F)	(68°F)	(86°F)	(104°F)
	12	6	4	2(hours)

APPLICATION METHOD Airless Spray

THINNER REQUIRED EPONICS THINNER B

DILUTION RATIO By Airless Spray
3 ~ 10%

RECOMMENDED FILM THICKNESS PER COAT Dry: 50 ~ 100 Microns
Wet: 125 ~ 225 Microns

AIRLESS SPRAYING CONDITIONS Air Pressure to Pump: 0.4MPa(4kg/cm²) or more
Pump Outlet Pressure: 12MPa(120kg/cm²) or more
Nozzle Tip No. : 163-515 ~ 715

COATING INTERVALS	@5	@20	@30	@40
@100MICRONS	(41°F)	(68°F)	(86°F)	(104°F)
Min.:	48	24	15	8(hours)
Max.:	14	7	7	5(days)

NOTES

- 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 B only.
- 6.Clean all equipment immediately after use with EPONICS THINNER B. Once cured, the material is not dissolved in this thinner.
- 7.If the film is exposed to rain in short period after application, it may whiten and weather conditions should be taken into consideration.

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