



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"> • Modified Epoxy Coating. • High Build Performance Properties at One Coat Without Retarding of Cure. • Excellent Workability by Airless Spray. • Excellent Physical and Chemical Properties. 	NO./NAME: 1 8 4 1 EPOALL #65
	TYPE: Modified Polyamide Amine Cured Epoxy Coating.
	SHIPPING WEIGHT: 18kg. Unit (15.3kg. Base, 2.7kg. Hardener)

SPECIFICATION DATA

PACKAGE	2 Component				
COLOR	Black, Brown, Gray				
FINISH	Low Gloss				
SPECIFIC GRAVITY @20	Mixed Material : 1.35				
	Volatiles : 0.87				
VISCOSITY @20	88 Krebs Units				
SOLIDS CONTENT	71% - by weight				
DRYING TIME		@5 (41)	@20 (68)	@30 (86)	@40 (104)
	To Touch (hours)	6	3	2	1
	Tack Free (hours)	72	24	15	8
The recoating time is specified in the application instructions.					
RECOMMENDED DRY FILM THICKNESS PER COAT	100 ~ 200 Microns				
THEORETICAL COVERAGE @200 MICRONS	488g./m ²				
	When estimating working coverages, allow for application losses, surface irregularities, etc.				
FLASH POINT	Base : 23 (73)				
	Hardener : 23 (73)				
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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EPOALL #65

APPLICATION INSTRUCTIONS

SURFACE PREPARATION	SSPC-SP3 (ISO-St3)				
MIXING RATIO	Base 85 Parts to Hardener 15 Parts – by weight				
AGING TIME	Let Stand Approx. 30 Minutes				
POT LIFE (hours)	@5 (41)	@20 (68)	@30 (86)	@40 (104)	
	24	6	4	1	
APPLICAION METHOD	Brush, Airless Spray				
THINNER REQUIRED	EPOALL THINNER A				
DILUTION RATIO	By Airless Spray : 3 ~ 10 %				
RECOMMENDED FILM THICKNESS PER COAT	Dry : 100 ~ 200 Microns Wet : 200 ~ 400 Microns				
AIRLESS SPRAYING CONDITIONS	Air pressure to Pump : 0.5MPa (5kg/cm ²) or more Pump Outlet Pressure : 12MPa (120kg/cm ²) or more Nozzle Tip No. : 163-417 ~ 725				
COATING INTERVALS		@5 (41)	@20 (68)	@30 (86)	@40 (104)
	Min. (hours)	96	24	20	12
	Max. (days)	14	7	5	3

NOTES

- 1.Mix Base and Hardener in accordance with the specified mixing ratio, then stir thoroughly until it is of uniform constituency. Keep aging times as specified and stir again prior to application.
- 2.This product is high build type at one coat. Avoid overreducing and apply equally at the specified coverage to obtain the recommended film thickness.
- 3.Use up the mixed material within pot life.
- 4.The above coating intervals is under normal temperature conditions. When applied below 10 (50 ° F), curing will be retarded and coating intervals should be checked before overcoating.
- 5.For thinning, use EPOALL THINNER A only.
- 6.Clean all equipment immediately after use with EPOALL THINNER A. Once cured, the material is not dissolved in this thinner.

SAFETY: If hardener contacts with skin wash thoroughly with soap and water after removing with thinner.
Hardener is no use of free amine and no violent skin pain, evaporation and odor.

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