

# Technical Data Sheet



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**Product Name:** 2 Pack Low VOC Epoxy Finishes

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**Product Number:** 53000 Range

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**Product Description:** Low VOC epoxy topcoats, formulated to take account of US and European environmental issues and pressures.

The range is not only low VOC, but has been formulated on lead free pigment systems and is aromatic hydrocarbon free.

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**Approvals/Specifications:** Meets the performance requirements of several aerospace and industrial specifications

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**Performance:** After 7 days air curing or force curing (typical 30 minutes @125°C) will pass:

- **Heat Resistance:** 48 hours @ 204°C (400°F)
- **Heat Resistance:** 100 hours @ 180°C (356°F)
- **Hot Oil:** 8 hours in ASTM fluid 101 (ASTM D 471) at 177°C (350°F) showing no peeling or softening
- **Hot Lube Oil:** 100 hours @ 150°C (302°F)
- **Fuel Resistance:** 4 hours in ASTM 'fuel B' at room temperature: no peeling or softening
- **Skydrol (hydraulic fluid) Resistance:** up to 336 hours @ 70°C (160°F)
- **Corrosion Resistance:** >350 hours salt spray to ASTM B-117 (after 48 hours high temperature conditioning at 204°C (400°F))
- **Cyclic Corrosion:** 10 cycles of 4 hours @ 150°C (302°F) + 20 hours salt spray to ASTM B-117
- **Low Temperature Resistance:** Will withstand temperatures down to -40°C

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**Components:**

<b>Base:</b>	53000 Range
<b>Catalyst:</b>	53-CAT or 53-FAST CAT
<b>Thinner:</b>	IP3-Reducer

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## Application:

**Surface Preparation:** Ensure all surfaces are clean and free from dirt and contaminants  
Can be applied directly to clean metals, but more usually applied over phosphate steels or conversion coating treated aluminium. For full performance, apply over 53-6500 chrome free anti-corrosive primer.

**Paint Preparation:** 2 component products: will require pre-mixing with 53-CAT standard catalyst or 53-FASTCAT fast cure catalyst – refer to base component can label for mixing ratio, as these can vary from colour to colour. Allow 15 minutes induction time and re-stir before using

**Thinner / Reducer Addition:** Thin as required with 5-10% 53-Reducer

**Application Method:** Apply by spray – compliant guns recommended. Refer to gun manufacturers instruction regarding pressures etc.

**Drying Curing:**

**Air Dry:**

- Standard Cat:
  - *Touch Dry:* 2-3 hours
  - *Hard Dry:* 16-24 hours
- Fast Cat:
  - *Touch Dry:* 1-2 hours
  - *Hard Dry:* 405 hours

**Heat Cure:**

- Flash Off:
  - 30-45 minutes @ RT
- Cure:
  - 90 minutes @ 80°C
  - 30 minutes @ 125°C

## Technical Properties:

**Supply Viscosity:** 70-75 Seconds / ISO5 Cup / 23±2°C

**Flash Point:** ≥22°C≤32°C

**VOC Content:** *Base:* 160-200gm / litre (on colour)  
*Catalyst:* 118gm / litre  
*Fast Cat:* 146 gm / litre

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<b>Colour:</b>	Various
<b>Pack Size:</b>	1 and 5 Litres
<b>Density:</b>	<i>Base:</i> 1.10-1.55kg/l -depends on colour <i>Catalyst:</i> 0.987kg/l <i>Fast Cat:</i> 0.978kg/l
<b>Gloss:</b>	Various
<b>Thinner:</b>	IP3 Reducer
<b>Solvent/Clean Up:</b>	IP3 Reducer or 40006
<b>Catalyst:</b>	53-CAT or 53-FAST CAT
<b>Theoretical Coverage:</b>	20-27.5m <sup>2</sup> / litre (dependent on colour & film thickness)

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## Storage:

Highly flammable liquid: store and use in accordance with the flammable liquid regulations

**Shelf Life:** 12 months temperate; 6 months tropical

**Before use, refer to Product Safety Data Sheet**

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## Safety Data Sheets:

For Safety Data Sheets please contact our Sales Department:

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