

DUASOLID 50

DESCRIPTION

A two component oxirane ester paint containing active anti-corrosive pigments.

PRODUCT FEATURES AND RECOMMENDED USES

- ◆ Used as a single coat or as a topcoat in oxirane ester-based systems on steel surfaces exposed to abrasion and chemicals in severe climatic conditions.
- ◆ Excellent durability.
- ◆ Environmentally more friendly and for users more safe alternative than epoxy and polyurethane paints. High volume solids and does not contain any epoxies or isocyanates.
- ◆ High film build properties, up to 100 µm (4 mils DFT) / one coat.
- ◆ Suitable for painting earth moving machines, haulage and lifting equipment, forklifts, agricultural machinery, electric appliances, internal bushes, pumps and other steel structures, equipment and machinery.

TECHNICAL DATA

Volume solids

Approx. 65 ± 2 %.

Specific gravity

Approx. 1.5 kg / l

Mixing ratio and product codes

Base 2 parts by volume 527-series
 Hardener 1 part by volume 008 7675 (55904), other hardeners: see page 2

Pot life

8 hours (23 °C / 74 °F)

Recommended film thicknesses and theoretical coverage

Recommended film thicknesses approx.		Theoretical coverage approx.
dry	wet	
60 µm (2.5 mils)	95 µm (3.7 mils)	10.6 m ² /l – (417 sq ft gallon)
100 µm (4 mils)	160 µm (6 mils)	6.4 m ² /l – (261 sq ft gallon)

Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated.

Drying time

DFT 80 µm (3 mils)	+ 23 °C (73F)
Dust dry, after	30 - 60 min
Touch dry, after	4 - 6 h
Dry to handle, after	8 - 12 h
Recoat with other Duasolid 50 paints, after	a few min
Through dry at increased temperature 45 min / 80 °C (176F)	

Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation.

Finish

Varies depending on the used hardener. See page 2.

Colors

RAL, NCS, SSG, BS, MONICOLOR NOVA and SYMPHONY colorcards. TEMASPEED tinting.

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APPLICATION DETAILS

Surface preparation (ISO 12944-4) Oil, grease, salts and dirt are removed by appropriate means. (ISO 12944-4)

Steel surfaces: Blast clean to grade Sa2½. (ISO 8501-1) If blast cleaning is not possible, phosphating is recommended for cold rolled steel to improve adhesion.

Primed surfaces: Oil, grease, salt and dirt are removed from the surface by appropriate means. Repair any damage to the primer coat. Note the overcoating time of primer. (ISO 12944-4)

Galvanized & Aluminum Metal surfaces: Contact Advance Polymerics, Inc. technical service. (api-smartcoat.com)

Primer DUASOLID PRIMER and DUASOLID 50.

Finish DUASOLID 50.

Application conditions All surfaces must be dry. The temperature of the ambient air, surface or paint itself should not fall below +10 °C / 50 °F during application or drying. Relative humidity should not exceed 80 %. The surface temperature of the steel should remain at least 3 °C / 10 °F above the dew point.

Mixing components First stir base and hardener separately. The correct proportions of base and hardener must be mixed thoroughly before use. Use a mechanical agitator for mixing.

Application By airless, conventional or electrostatic spray. At airless spray application the paint can be thinned if necessary to a viscosity of 20 s DIN 4. Airless spray nozzle tip "0.013 - 0.015", pressure ratio at least 30:1, nozzle pressure 160 - 200 bar and atomization air pressure 2 - 4 bar.
At conventional spray application the viscosity should be 20 - 40 s DIN 4 and at electrostatic spraying 20 s DIN 4.

Properties and gloss of DUASOLID 50 will vary according to the used hardener: Hardener 008 7675 (55904) gloss abt. >

70 mixing ratio 2:1
 Hardener 008 7665 (55911) gloss abt. 60 mixing ratio 2:1
 Hardener 008 7667 (55917) gloss abt. 10 mixing ratio 2:1
 Hardener 008 7672 (55939) gloss abt. 40 mixing ratio 2:1
 Hardener 008 7666 (55907) gloss abt. >

70 mixing ratio 8:5 Avoid hot spray!

Thinner Thinner 1048 or Thinner 1112 (62401).

Cleaning of equipment Thinner 1048 or Thinner 1112 (62401).

VOC

The Volatile Organic Compounds amount is 320 g/lit re of paint mixt ure.

HEALTH AND SAFETY

Containers are provided with safety labels, which should be observed. Further information about hazardous influences and protection are detailed in individual health and safety data sheets. A health and safety data sheet is available on request from

Tikkurila Coatings Oy.

For professional use only.

The above information, based on laboratory tests and practical experience, has been proved valid at the date marked on the product data sheet. When necessary verify the validity of the product data sheet. The quality of the product is ensured by our operational system, based on the requirements of the standards ISO 9001 and ISO 14001. As a manufacturer we cannot be responsible for any damages caused by using the product against our instructions of for inappropriate.

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