Technical Data Sheet

TRIOCOR NS 4511

Epoxy coating

DESCRIPTION:

Two-component epoxy coating of polyamide curing with high molecular weight.

TYPE AND RECOMMENDED USE:

It can be used as a primer layer as part of a system operated under ambient conditions (with an operating temperature of up to 120 ° C) or immersed in liquid (with an operating temperature of up to 50 ° C). It can be used for qualitatively prepared surfaces made of carbon, stainless and galvanized steel, steel with applied interoperable primer, aluminum, concrete, as well as surfaces with zinc metallization.
It can be used for surfaces and pipelines made of structural steel, operated in very aggressive environments and under water. Recommended for offshore environments, oil refineries, power plants, bridges, buildings and mining equipment.

PHYSICAL CONSTANTS:

Colour: gray, red brown

Volume solids: 65 ±5 %

Theoretical spreading rate: 0.138 ltr/m^2 – at 90 microns DFT

Film thicknesses:

Table of wet and dry film thicknesses

Film thicknesses	WFT, microns	DFT, microns
Minimum	120	80
Maximum	380	250
Recommended	140	90

Drying and recoating times:

Drying times at (85-90) microns DFT				
Surface temperature	0°C	10°C	20°C	35°C
Drying to degree 3	16 hours	9 hours	5 hours	2 hours
Recoating time:				
TRIOCOR NS 4511 primers or another layer of the coating system (Minimum)	16 hours	9 hours	5 hours	2 hours
Maximum	6 months			
Drying to a hard film (up to degree 5, GOST 19007)	24 hours	11 hours	7,5 hours	4 hours
Drying "before tilting" (to degree 7, GOST 19007)	29 hours	18 hours	12 hours	5 hours

The drying time is determined by the actual DFT. The drying times given in this section are of a recommendatory nature. When assessing the actual drying time, it is also necessary to take into account the presence of air flows and relative humidity.

SURFACE PREPARATION:

The material is applied to a prepared and dry metal surface with a temperature at least 3 ° C above the dew point. The preparation process includes the following operations: elimination of surface defects up to P3 according to ISO 8501-3; degreasing of the surface (if necessary; recommended solvent – P4); cleaning of the carbon steel surface to the degree of Sa $2^1/_2$ according to GOST R ISO 8501-1-2014 with a recommended roughness profile of 50-75 microns, local cleaning of P St 3 is allowed during repair, and desalting of the surface (if necessary); dedusting of the surface to a degree of 2 with a particle size of no more than Class 2 according to ISO 8502-3.

APPLICATION DETAILS:

Material preparation:	The material is two-component, requires mixing separately of the base and hardener before application. Mixing in ratios: 4:1 (base: hardener) by volume with thorough mixing until smooth.
Pot life:	4 hours – 23°C
Application method:	Airless spraying / Pneumatic spraying / Manual application.
Thinner:	Thinner TRIOSOLV 0002 (if necessary), up to 5 % by volume at airless spraying, up to 12 % by volume at pneumatic spraying. For detailed information, contact «O3-Coatings».
Nozzle size (recommended):	- .015” - .019” at airless spraying; - (1,7–2,0) mm at pneumatic spraying
Operating pressure (recommended):	- not less than 150 bar at airless spraying; - (1,7–2,0) bar at pneumatic spraying
Cleaning of tools:	TRIOSOLV 0002. (Can be to use other solvents in agreement with the company "O3-Coutings”)
Application conditions:	Should be applied at temperatures above -10°C; Relative humidity: 85% maximum. (In closed rooms it is necessary to provide supply-and-exhaust ventilation during application and drying to the extent necessary).

RECOMMENDED SYSTEMS:

Previous layer:	Epoxy coating, epoxy mastic coating, epoxy coating with zinc addition, zinc silicate coating. For more information, please contact «O3-Coutings»
The following layer:	Acrylic coating, epoxy coating, polyurethane coating, polysiloxane. For more information, please contact «O3-Coutings»

STORAGE: 48 months for the base, 24 months for the hardener from date of manufacture. Product should be stored in dry, dark space at temperatures between 0°C to + 30°C in the original sealed packaging, avoiding direct exposure to UV-rays and other sources of heat.

PACKAGE: Base - containers 20 l;

Hardener – containers 5 l

HEALTH AND SAFETY: Refer to the Safety Data Sheet before use.