



# TECHNICAL SHEET



Product name:

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Date: 13.4.2016

<b>Characteristics:</b>	Dispersion two-pack epoxy-acrylic enamel		
<b>Description:</b>	Two-pack water-thinnable enamel intended for top coats of metal parts and structures treated with anticorrosion primer. The enamel features very good resistance to UV radiation and climatic effects, excellent adhesion to various substrates and long durability, while maintaining its appearance and color shade.		
<b>Composition (general):</b>	The acrylic component DENAPOX E contains special acrylic dispersion, inorganic and organic pigments, coalescent agents, soaking and dispergation agents, antifoaming agent, rheology modifiers and other ingredients enhancing the properties of the substance. DENAPOX TUŽIDLO (hardening agent) contains epoxy-resin emulsion		
<b>Application:</b>	It is used as top coat for steel, galvanized and aluminum structures, treated with the primer of the DENAKOR, DENAPOX Z or EPOXIDEN Z series. The enamel features very good resistance to UV radiation and climatic effects, excellent adhesion to various substrates and long durability, while maintaining its appearance and color shade.		
<b>Colors:</b>	It is produced according to RAL, EUROTREND, NCS, ČSN color charts or in the agreed shades, matte.		
<b>Properties:</b>	<b>Paint:</b>	<b>Hardening agent:</b>	<b>Hardened mixture:</b>
<b>Density (g/cm<sup>3</sup>):</b>	1.08 - 1.3	1.1	1.13 - 1.18
<b>Volume solids ONL (%):</b>	30 - 40	63.5	30 - 40
<b>Weight solids (%):</b>	35 - 50	67	40 - 50
<b>KU viscosity:</b>	65 - 100		
<b>Flow time by use of flow cups F6 (s):</b>	10 - 70		10 - 70
<b>pH (at 20 °C):</b>	7 - 10		7 - 10
<b>VOC (volatile organic compounds) (kg/kg):</b>	0.06 - 0.09	-	0.05 - 0.08
<b>0.006 TOC (total organic carbon content) (kg/kg):</b>	0.04 - 0.06	-	0.03 - 0.05
<b>Maximum permissible value of VOC content (g/l):</b>	140		
<b>Max. VOC content in the product in the ready-to-use condition (g/l):</b>	95		
<b>Water-thinnable paint category:</b>	A/j multiple-pack reactive coatings with a special function for specific purposes.		
<b>Appearance/color:</b>	liquid		
<b>Gloss value (at 60°):</b>	60 - 90		
<b>Pendulum hardness (2H/80 °C):</b>	min. 30 %		
<b>Miscibility:</b>	miscible with water		
<b>Adhesion by the grid-cutting method:</b>	degree 0 (cut edges are completely smooth and free of any defects)		
<b>Impact resistance:</b>	30 cm		
<b>Drying, degree 1 (surface dry):</b>	65 min		
<b>Drying time, degree 2 (dry to touch):</b>	70 min		
<b>Drying time, degree 4 (dry-through):</b>	90 min		
<b>Chemical resistance:</b>	Weak acids and bases, Savo, motor oil		
<b>Substrate preparation:</b>	The substrate must always be pre-treated with anticorrosion paint. The possibility of using the types of primers other than DENAKOR, DENAPOX Z, DENAPUR Z or EPOXIDEN Z must always be tested or discussed with the manufacturer.		
<b>Application conditions:</b>	The air and substrate temperatures during the application and drying of the paint shall not fall below +10 °C. At lower temperatures, the enamel does not create a perfect film and the quality and durability of coatings are reduced. The open time of the hardened paint is at least 12 hrs at 20 °C.		
<b>Thinning:</b>	The paint is prepared for direct application and it shall not be thinned before the application.		



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<b>Hardening:</b>	Prior to application, the DENAPOX E enamel and DENAPOX TUŽIDLO (hardening agent) shall be mixed at the ratio of 100:10, while the hardening agent should be added to the paint during continuous stirring. Stirring should be performed with an appropriate stirrer (e.g. a drill with a stirrer); manual stirring is not permitted. The mixing ratios of both the components can be changed upon agreement with the manufacturer on the requirements for the final properties of the coating.								
<b>Recommended method of application:</b>	With a brush, a roller or by spray painting - air, pneumatic, high-pressure - Airless, Airmix								
<b>Recommended coating system:</b>	<p>1 - 2 layers of DEPOXIDEN Z (or DENAPOX Z, DENAKOR), the optimum paint thickness 80 DFT, the re-spray interval with two layers is 24 hrs at 20 °C; if additional drying is employed at temperatures to 80 °C, the interval can be reduced up to 2 hrs.</p> <p>1-2 layers of DENAPOX E, two-pack epoxy-acrylic enamel, the optimum layer thickness 80 µm DFT, the re-spray interval between the substrate and the enamel must be at least 4 hrs. If two enamel layers are employed, the coating interval is 24 hrs at 20 °C - if additional drying not exceeding 80 °C is employed, the interval can be reduced.</p> <p>The paints of the DENAKOR series can be used as anticorrosion primers.</p>								
<b>Application data:</b>	The paint should be applied with a paint roller, a paint brush or by spray painting in one, two or more layers, with a time lag between coatings of at least 4 hrs. It is recommended that the method of application, the number and the thickness of layers always be discussed with the manufacturer in advance.								
<b>Spreading capacity and recommended thickness:</b>	<p>Theoretical consumption of DENAPOX E - see the chart,</p> <table border="1"><tr><td>Wet-film thickness WFT (µm)</td><td>230</td></tr><tr><td>Dry-film thickness DFT (µm)</td><td>80</td></tr><tr><td>Theoretical spreading capacity (m<sup>2</sup>/kg)</td><td>3.30</td></tr><tr><td>Theoretical spreading rate (kg/m<sup>2</sup>)</td><td>1.20</td></tr></table>	Wet-film thickness WFT (µm)	230	Dry-film thickness DFT (µm)	80	Theoretical spreading capacity (m <sup>2</sup> /kg)	3.30	Theoretical spreading rate (kg/m <sup>2</sup> )	1.20
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<b>Packaging:</b>	Plastic containers weighing 0.8 - 200 kg.								
<b>Storage:</b>	Store in original, well-closed containers in cool, dry and well-ventilated areas at temperature from +5 to +25 °C. Protect from freezing. Keep the mixture separated from drinks, foodstuff, feedstuff and medicine. Store away from the reach of children. The shelf life is a minimum of 12 months from the date of manufacture. The product must not freeze.								
<b>Disposal of packaging and waste:</b>	Product residues and contaminated packaging shall be disposed of as hazardous waste in accordance with the applicable regulations.								
<b>Safety and hygiene:</b>	Observe the principles of personal hygiene. Ensure good ventilation of the workplace. During application, wear respiratory protection. If on the skin, wash the affected areas with soap and water. In case of contact with the eyes, rinse immediately with plenty of water, seek medical advice. If swallowed, rinse mouth with water, do not induce vomiting and get medical attention.								
<b>Legislation, certificates, attestations, other tested parameters:</b>	See the Declaration of Conformity								