

## TECHNICAL DATA SHEET

**Item number:** 0503-236-XXX0

**Product name:** ALMADUR SOLID 236

# ALMADUR SOLID 236

**Description:** Two-component, anti-corrosive and high-build epoxy coating with a high content of solid parts. It exhibits superb resistance to abrasion, very good insulating properties, resistance to atmospheric conditions and fairly aggressive chemical splashes. Exposure to sunlight may cause minor discoloration. The coating cures in low temperatures.

### ADVANTAGES

- very good adhesion
- high resistance to mechanical impact
- fast curing even in lowered temperatures
- coating resistant to harmful atmospheric conditions

### RECOMMENDED USE

- As a primer, topcoat and anti-corrosive coating for highly resistant painting systems where low contents of volatile organic compounds and high-build coat are required.
- As a primer for steel structures exposed to marine, marine coastal, urban and industrial environments.

### TECHNICAL PROPERTIES

• Density (approx.), kg/dm <sup>3</sup>	1,5
• Recommended film thickness per one coat, dry/wet μ m	100/125 300/380
• Dry time (at 20 °C): 1st degree (tack-free), h	2
• Pot life at 20 ° C, h	2
• Full curing at 20 ° C, days	4
	at 15 ° C, days
	6
• Theoretical coverage at 100 μm film thickness, dm <sup>3</sup> /m <sup>2</sup>	0,11
• Solid parts (±2), % by volume	83±1
• VOC in a ready-to-use product, g/l	150
• Recommended number of coats	1 – 2

**GLOSS** semi-matte

**COLOR** gray oxide red

## APPLICATION

ALMADUR SOLID 236 contents come in two separate containers and should be mixed keeping the proportions as delivered.

**Paint preparation** – Add content II (content II – 0504-236-0000) to mechanically stirred content I with the following volume proportions:

- content I 4
- content II 1

Stir the mixture until homogenous but avoid excessively long stirring which can cause aeration of the mixture. At 20°C, the paint is ready to use after 10 minutes. If painting in low temperatures, it is necessary to wait at least 20 minutes.

The product does not require thinning.

However, in extreme environments, it is recommended to use 5% of THINNER ALMA 8040. The pot life of the prepared mixture is 2 hours at 20°C. Higher temperatures decrease the pot life, lower temperatures increase the pot life.

The prepared mixture should be used within the recommended pot life.

Minimal temperature of the ready-to-use product is 15°C.

**Product application** – after mixing the contents

- brush
- hydrodynamic spraying: Ø0,38-0,53 mm; 15 - 20 MPa

**Thinner** THINNER ALMA 8040

## APPLICATION METHOD\*

**Surface** - the higher cleanness degree of a surface, the longer durability of the coating. The highest chemical and mechanical resistance are achieved when the coats are painted directly over steel substrates which have been sandblasted or shot-blasted down to the minimal cleanness degree of Sa 2½\*

- Steel surface: dry, degreased and free of any foreign contaminants – cleaned down to at least **Sa 2\*** cleanness degree (for immersed surfaces) or at least **Sa 2\*** for exterior surfaces. In the case of exterior surfaces, a minimal cleanness degree of **Sa 3\*** is acceptable.
- The surface to be coated should be dry, free of salt, grease, dust and any other contaminants.
- Prior to coating concrete surfaces make sure the substrate is clean and free of grease, oil, fluid bituminous substances and detergents. In the case of fresh concrete (min. C20/25) cement milk should be removed. Mechanically smoothed concrete requires roughening, e.g., with moderate shot blasting, to achieve the CSP-3 profile (according to the ICRI standards). In the case of repairs, the minimum concrete surface profile should be CSP1 and exhibit adhesive value >1.5 MPa according to the pull-off adhesion testing (PN-EN 1542)

Recoating window	30°C	20°C	10°C	0°C	-5°C
The shortest time(h)	3	8	12	24	35
The longest time	1 month**				

These time lapses refer to the coat with recommended thickness and drying in a well-ventilated environment. The times given may vary according to changes in the temperature, ventilation quality, number of coats and their thickness.

\*\* At times of exposure to high temperatures and strong sunlight, the longest time is 1 week.

contaminants and chalking products. We recommend abrasive sweeping or water and sandblasting, roughening the surface.

- If the coating is exposed to an aggressive environment, it is recommended to prepare the surface with great care and proceed with recoating before the full cure of previous coats.

Full cure	20°C	10°C	0°C	-5°C
Days	4	6	10	40

Use with caution.

The containers are delivered with appropriate safety labels to follow.

#### Recoating

ALMA-COLOR: two-component epoxy, polyurethane and one-component acrylic coatings.

#### Painting and curing conditions:

- minimal surface temperature 0°C
- product temperature above 15°C
- surface temperature above the dew point (to avoid condensation)
- relative humidity of the air not higher than 85%
- efficient ventilation.

**SHELF LIFE:** 12 months from the production date in the original unsealed container.

**\*PN-ISO 8501-1:2008**

The above information, as much as it is valid to the best of our knowledge — based on laboratory tests as well as on our hands-on expertise — should not be considered complete. As a manufacturer, we are not able to monitor all the various conditions in which the product is applied or many other factors that can influence the final result of the product application and use. We are not responsible for any damages caused by any misuse of the product be it by not following our recommendations or by using the product for purposes other than intended by the manufacturer. We keep the right to modify the manual any time without prior notice.

**WARNING!** This product is designed for professional use in the given industry. The detailed information regarding product safety can be found in the MSDS.

LEWY MARGINES: industrial coatings

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