

GLOSS: matte

COLOR: 0680 dark green 0780 dark gray 0980 black

FOLLOWING COATS

Epoxy or polyurethane topcoats

PRODUCT APPLICATION

PREPARATION OF MIXTURE – precisely mix part I with part II – (Part II item number – 0504-450-0000)

in the following ratio:

	by volume	by weight:
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- | | | |
|---------------------------------------|---|-----|
| • part I | 5 | 100 |
| • part II | 1 | 11 |
| • Thinner number 8040: 0-5% by volume | | |

After 10 minutes (in 20°C) the product is ready-to-use

Application methods:

- airless sprayer: Ø0,48-0,63 mm; 10-15 Mpa
- brush

APPLICATION*

Surface- the higher degree of surface cleanness the longer period of paint durability. The paint achieves the highest chemical and mechanical resistance when applied directly on steel that was sand-blasted or shot-blasted to at least Sa 2 ½ * cleanness degree.

- ⚡ Steel surface must be free from any contaminants, grease, oil and cleaned to at least Sa 2* cleanness degree for immersed surfaces. For exterior surfaces – at least St 3* cleanness degree. For interior surfaces it is allowed to clean to at least St 2* cleanness degree
- ⚡ For priming an epoxy paint surface – dry and free from corrosion, grease, oil and contaminants
- ⚡ Aluminum surface – dry, degreased and tarnished with abrasive fabric
- ⚡ Concrete surface after a minimum of 1 month weathering – clean, sound and free from cracks, crevices and cement slurry. Before final painting the surface should be primed with EPOXY COATING 5+2

Full cure of the coat at (± 2)°C	23	10	0	-10
days	4	8	12	35
The shortest time (h) for application of following coats of ALMADUR EXTRA	6	7	12	35
The longest time for application of topcoats	Unlimited / depending from the aggressiveness of the environment**			

** re-coat time should be as short as possible in order to avoid contamination of the surface and chalking. The best adhesion between coats is achieved by applying following coats before the previous coat fully cures.

Painting and curing conditions

- in cold temperatures attention should be paid if there is no risk of surface icing which does not allow proper adhesion
- minimal substrate temperature: -10°C ,
- surface temperature above dew point (omitting condensation)
- paint temperature above 15°C
- air temperature above -10°C
- relative humidity up to 90%
- good ventilation

SHELF LIFE: 9 months from the production date in original unsealed container.

*PN ISO 8501-1:1996

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