

## Technical Data Sheet

# Indoprotect 4900CS

## Casting Sealer based on Acrylated Modified Polymer

### Product Description

A single component, Semi Glossy, medium solids, very fast curing, special polymer based Casting Sealer pigmented with zinc phosphate to provide added anti corrosive performance and full cure to your casting surface in a single coat.

### Recommended Use

This product is recommended as Casting Sealer coating to well prepared surface for better corrosion resistance and storage. Indoprotect 4900CS is specialized developed coating to provide better durability than conventional alkyd based products. It is recommended for Casting and Forging components such as diesel engines & its components, Castings used in Railways, ACE & Mining Machineries etc.

### Physical Data

Colour	: Customized Limited Shades
Finish	: Eggshell & Semi Glossy
Soild by Volume	: 52 ± 3%
Supply Weight (Kg/ Ltr)	: 1.25±0.05
Flash Point	: 34° C
Dry Heat Resistance	: Intermittent : 140°C, Continuous : 120°C
Shelf Life	: 12 months

### Film Thickness

#### Recommended film thickness per coat

Dry Film Thickness	: 30-50μ in single coat
Wet Film Thickness	: 60-95μ in single coat
Therotical Coverage Rate	: 17.25 sq.mt / lit at recommended DFT of 30μ

### Surface Preparation

All surfaces to be coated should be clean, absolutely dry and oil or moisture free before painting application. Oil and grease should be removed by solvent cleaning.

**Casting Surface:** Abrasive blast clean to a minimum of Sa2½ (ISO 8501-1:2007). Surface defects revealed by the blast cleaning process should be ground, filled, or treated in the appropriate manner. A surface profile of 30-40 microns is recommended. Casting Sealer should be applied within 2 hours of surface cleaning.

**Primed Surface:** Already primed surface should be dry and free from all contamination and Indoprotect 4900CS should be applied within the overcoating intervals specified in earlier primer TDS. Area of damaged primer or rework etc should be prepared as per specified standards, either by power tool cleaning or other means.

## Application Data

Application Method	: Spray/ Airless Spray/Brush
Mixing Ratio	: One Component Coating
Thinner and Cleaner	: Indokote Thinner (IK.900)
Airless Nozzle Orifice	: 0.33 - 0.45mm
Nozzle Pressure	: 155 kg/cm <sup>2</sup> or 2200 psi

**Working Precautions:** Material should not be allowed to remain in pipeline, hoses, gun or spray equipment. Thoroughly flush all equipment with IK.1702 thinner. Once units of paint have been mixed they should not be resealed and it is advised that after prolonged stoppages, the work should recommences with freshly mixed units.

**Maintenance:** Clean all equipment immediately after use with IK.1702 thinner. It is good working practice to periodically flush out spray equipment during the course of the working day. All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.

## Drying Characteristics

Surface Dry	: 10 mins
Touch Dry (to Handle)	: 20 mins
Hard Dry	: 24 Hours
Overcoating Interval	: Minimum 2 Hours

Drying and curing times are determined at 30°C under controlled temperatures and relative humidity below 85 %, and at average of the DFT range for the product.

## Compatibility

Previous Coating : Epoxy, Acrylated

Subsequent Coating : Polyurethane, Epoxy, Acrylated, Modified Alkyd

## Product Features

Anti corrosive products based on special polymers are most suitable for the protection of light industrial steelwork in internal dry environments or on exposed steelwork which is situated in low corrosivity environments corresponding to ISO12944 C1, C2 and C3 only. Anti-corrosive performance on hand prepared steel is related directly to both the degree of surface preparation and the dry film thickness of the system applied.

This product must only be thinned using the recommended thinner. The use of alternative thinners, might contains alcohols, can severely affect the curing mechanism of the coating. Indoprotect 4900CS should be applied at least 3°C temperatures above dew point and below 85% of relative humidity.

When overcoating with Epoxies or Polyurethanes, it is recommended to adhere to the DFT specifications and sufficient time of curing is given. Overcoating of Indoprotect4900CS should be avoided in this case.

## Storage

This is solvent based coating and the containers should be kept in a dry, cool, well ventilated space and away from sources of heat and ignition. Containers must be kept tightly closed.

## Precaution

This product is for professional use only. The paint applicators should be trained, experienced and have the capability and equipment to mix and apply the coatings correctly as instructed. Applicators should use appropriate protection equipment when using this product.

This is solvent based product and should be use under well ventilated conditions. Do not inhale spray mist. Skin contact should be avoided. In case of spillage on the skin, it should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water.

### Limitation of Liability

This information is given to the best of our knowledge. Because of the multitude of formulations, production, and application conditions, all the above-mentioned statements have to be adjusted to the circumstances of the processor. Our products are often used under conditions beyond INDOKOTE's control. INDOKOTE cannot guarantee anything but the quality of the product itself. No liabilities can be derived from this fact for individual cases. This issue replaces all previous versions – Printed in India.

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