

Technical Data Sheet

Indothane 2075SG

Acrylic Polyurethane DTM (Direct-to-Metal) Semi-Glossy Finish

Product Description

Two component aliphatic Isocyanate cured high solid, Semi Glossy, DTM (Direct-to-Metal) acrylic polyurethane primer cum finish coating, pigmented with zinc phosphate to provide anti corrosive properties.

Recommended Use

Indothane 2075SG is specially designed for use as a single coat primer/finish coating system to protect Construction and Mining heavy machinery, Agricultural equipment, Transportation vehicles, material handling and lifting equipment, Tanks and Vessels, pumps, valves and other small motors and machinery. Indothane 2075G is particularly suited where Semi Glossy high DFT system required with increased production throughput. It gives good adhesion over correctly prepared steel, galvanised steel and stainless steel and provides Good colour retention.

Physical Data

Colour	: Any IS/ RAL/ Custom Shades
Finish	: Semi-Glossy (40-60 GU at 60° angle)
Soild by Volume	: 65 ± 2%
Supply Weight (Kg/ Ltr)	: 1.30±0.05
Flash Point	: 33° C
Dry Heat Resistance	: Intermittent : 120°C, Continuous: 100°C
Shelf Life	: 12 months

Film Thickness

Recommended film thickness per coat

Dry Film Thickness	: 50-125µ in single coat
Wet Film Thickness	: 75-200µ in single coat
Therotical Coverage Rate	: 11.00 sq.mt / lit at recommended DFT of 60µ

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. This product is suitable for use over phosphate washed steel.

Primed Surface: The primed surface should be dry and free from all contamination and Indothane 2075SG should be applied within the overcoating intervals specified in primer TDS.

Area of damaged primer or rework etc should be prepared as per specified standards, either by power tool cleaning or other means.

Steel: 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.

Stainless Steel, Galvanised Steel and Aluminium: Dirt and oils should be removed by solvent cleaning or other suitable cleaner followed by a thorough water rinsing. Sand or abrasive sweep blast to a standard similar to ISO 8501-1:2007 Sa1 to create a surface profile.

Application Data

Application Method	: Spray/ Airless Spray/Brush/ Roller
Mixing Ratio	: 5 Part (Base) : 1 Part (Hardener)
Pot Life	: Three Hours at 30°C
Thinner and Cleaner	: Indothane PU Thinner (IK.1705)
Airless Nozzle Orifice	: 0.38 - 0.53mm
Nozzle Pressure	: 155 kg/cm ² 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 recommence 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	: 60 mins
Touch Dry (to Handle)	: 2 Hours
Hard Dry	: 18 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, Epoxy MIO, Epoxy Mastic, Epoxy Zinc Rich, Polyurethane
Subsequent Coating	: Only Self, Polyurethane

Product Features

The gloss level mentioned above is subject to application method, dry film thickness and environmental conditions within a controlled OEM painting facility. Gloss level achieved may differ if there is excessive variation in cure temperature and application thickness. The best results in terms of gloss and appearance will always be obtained by air spray application.

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. Indothane 2075SG should be applied at least 3°C temperatures above dew point. During winters or at low temperature areas, condensation occurring during or immediately after application may result in a matt finish and an inferior film.

High DFT and over-application of Indothane 2075SG will increase the time to drying and overcoating times. Polyurethane based anti-corrosive products are most suitable for the protection of light industrial steelwork in internal dry environments or on exposed steelwork which is situated in low to medium corrosivity environments corresponding to ISO12944 C1, C2 and C3.

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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