

zandleven coatings

MONOPOX® METALSEALER

epoxy

A two components epoxy sealer, pigmented with micaceous iron oxide and inert extenders.

- Excellent adhesion on fine blasted or chemical pre-treated hot-dip galvanised steel.
- Easy to apply in thick layers.
- After hardening excellent chemical and mechanical resistance.
- Can be used as primer/sealer on zinc rich primer like Monopox Micro-zink,
- Monopox LG micro-zink and Zinksilicaat ZL 400-55, also as primer on hot-dip galvanised steel and metal sprayed steel.
- Can even be recoated after long outdoor exposure with practically any paint system.

Product information

Finish Mat

Colour Green, red-brown, black and grey according to the micaceous

iron oxide colouring card

Mass density approx. 1.65 kg/L. (mixed product)
Solids content by volume ca. 60 volume % (mixed product)

VOC approx. 350 gr./L (volatile organic compound)

Recommended film thickness 50-100 µm d.f.t. per layer

85-165 μm w.f.t. per layer (undiluted)

Theoretical spreading rate $$\rm At\ 50\ \mu m\ d.f.t.\ 12.0\ m^2/L$$

At 80 μm d.f.t. 7.5 m^2/L

Practical spreading rate Depending on several factors like shape of object, profile of surface,

method of application, application circumstances and experience.

A few guiding principles are:

Brush/roller 85-90% of the theoretical spreading rate

Spraying 50-70% of the theoretical spreading rate

Flashpoint ISO 1523 Base 26 ℃

Hardener 2V4 30 $^{\circ}$ C Thinner FGM 631 26 $^{\circ}$ C Thinner WTD 107 14 $^{\circ}$ C

Dry temperature resistance 120 ℃

Durability At least 12 months, provided that it has been contained in closed

original packing at a dry and cool spot.



Drying times

For d.f.t. up to 100 µm Dust dry Transportable Complete hardening Recoatable: Minimum interval Maximum interval *

30℃	20℃	10℃	5℃
½ hour	1½ hour	2 hours	3 hours
8 hours	16 hours	24 hours	36 hours
3 days	4 days	6 days	10 days
4 hours	6 hours	16 hours	32 hours

*)This period can be extended by cleaning and sanding the coating prior to application of the next layer

1 month

3 months

Film thickness, ventilation, temperature and relative humidity are of great influence on the drying times.





Application instructions

Mixing ratio Volume: Base - hardener 2V4 80:20 Weight: Base - hardener 2V4 88:12

Base and hardener should be mixed and applied at temperatures above 10 °C. Mixing instructions

At lower temperatures extra thinner is needed which gives a slighter resistance

against sagging and which will delay hardening. The components should be mixed homogeneously,

with a mechanical blender. Pay attention to the side and bottom of the can.

Induction time At 20 ℃ not necessary

At 10 ℃ at least 10 minutes

approx. 16 hours at 10 ℃ Pot life after mixing 20 litre packing:

approx. 8 hours at 20 ℃ approx. 5 hours at 30 ℃

Optimal application circumstances

Temperature : 15-25℃ Humidity : 40-75%

Technical and esthetical properties can change when the product has been

applied under different conditions.

Usage information

Type of thinner Recommended thinner (depending on application

and equipment) Nozzle orifice

Nozzle pressure Typical d.f.t.

Cleaning of equipment

Airless-spray	Air spray	Brush/roller
FGM 631 / WTD 107	FGM 631 / WTD 107	FGM 631 / WTD 107
5 – 15 vol. %	10 – 25 vol. %	0 – 5 vol. %

0.46 – 0.53 mm 0.018 – 0.021 inch	2.0 – 2.5 mm		
150 – 180 bar	3 – 5 bar		
125 μm	80 μm	60 μm	
Thinner FGM 631 / W	TD 107		

Surface conditions

Steel

Apply Monopox Metal sealer on with zinc dust paints primered surfaces,

free from impurity and zinc salts.

Hot-dip galvanised steel Blast with a fine, non-metallic blasting medium until a level roughened surface

is obtained, or degrease the surface and then phosphatize or chromatize

(according to the rules of the manufacturer).



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Product Characteristics

No coating work shall be carried out when the temperature of the surface is less than 3° C above dewpoint and when the substrate temperature is below 5° C.

Due to the presence of solvents, applying this product in confined spaces, adequate ventilation has to be ensured.

At low temperature and under humid conditions, amine blushing can occur, which can effect the intercoat adhesion negatively. Prior to the application of the next layer, the previous layer must be checked for this phenomenon.

Discoloration or loss of gloss or other surface defects, can occur during drying and curing by condensation and or early water spotting. In particular bright and "full" colours.

This coating product is based on epoxy technology. It is recommendable that it should be overcoated with a durable finish.

Maximum film build in one coat is best attained by airless spray. Application by other techniques, it may be necessary to apply multiple coats in order to achieve the total specified dry film thickness.

Safety description

See safety data sheet

Ventilation rules

Minimum required quantity of air to comply with:					
	MAC	10 % LEL			
Monopox Metal sealer	1640 m³/L	74 m³/L			
Thinner FGM 631	3995 m³/L	160 m³/L			
Thinner WTD 107	4085 m³/L	168 m³/L			

MAC = Maximum Acceptable Concentration

LEL = Lower Explosion Limit

Also consult the security information sheets

Pretreatment / Labeling / Technical Terms (downloadable from www.zandleven.com)

A 1 Labeling of paint products in the European Community

A 2 Physical data

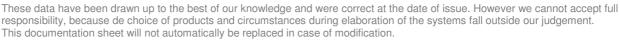
A 3 Persistency list for Monopox HB systems

A 4 General guidelines for steel preservation

A 6 Pretreatment of construction steel







The English language text is a translation. In case of doubt the Dutch language original text has to be consulted as the authoritative text.

