



zandleven coatings

MONOPOX[®] ALUMINIUM

epoxy

A two components high build epoxy coating pigmented with aluminium.

- A big watersealing capacity
- An excellent adherence on blasted and smooth steel
Application as primer directly on steel, as sealer on zinc dust coating layers and as finish layer in an epoxy coating system.
- Resistant against aliphatic and aromatic solvents
Limited resistance against chemicals as result of the aluminium pigment.
- Application and hardening is possible at relatively high humidity up to 90%.
- Limited resistance against chemicals as result of the aluminium pigment

Product information

Finish	Metallic gloss
Colour	Aluminium
Mass density	approx. 1.0 kg/L (mixed product, depending on colour)
Solids content by volume	approx. 58 volume % (mixed product, depending on colour)
VOC	approx. 375 gr./L (volatile organic compound)
Recommended film thickness	40-120 µm d.f.t. per layer 70-200 µm w.f.t. per layer (undiluted)
Theoretical spreading rate	At 60 µm d.f.t. 8.0 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 32°C Hardener 2V4 30°C Thinner FGM 631 26°C
Dry temperature resistance	120°C
Durability	At least 12 months, provided that it has been stored in closed original packing at a dry and cool spot.

Drying times

For d.f.t. up to 60 µm

Dust dry

Transportable

Complete hardening

Recoat able:

Minimum interval

Maximum interval

30°C	20°C	10°C
1½ hour	2 hour	2½ hours
8 hours	16 hours	24 hours
3 days	7 days	12 days
6 hours	8 hours	16 hours
Two weeks		
Film thickness, ventilation, temperature and relative humidity are of great influence on the drying times.		



Ganzlin



Application instructions

Mixing ratio	Volume: Base – hardener 2V4 82:18 Weight: Base – hardener 2V4 80:20
Mixing instructions	Base and hardener should be mixed and applied at temperatures above 5 °C. At lower temperatures extra thinner is needed, which gives a slighter resistance against sagging and which will delay hardening.
Induction time	At 20 °C not necessary At 10 °C at least 10 minutes
Pot life after mixing	20 litre packing: approx. 16 hours at 10 °C approx. 8 hours at 20 °C approx. 5 hours at 30 °C
Application conditions	<p>During application and hardening the temperature should be above 5 °C to attain maximum resistance against chemical and mechanical influences.</p> <p>Application at lower temperatures (down to -5 °C) is possible, however hardening will take considerable more time and complete resistance will be achieved much later.</p> <p>The surface should remain free from water and ice and the temperature of the surface should at least be 2 °C above dew point.</p> <p>During application and hardening in closed or small spaces, it is necessary to refresh the air continually to remove the solvent vapours, this because of drying, health and safety.</p>

Usage information

Type of thinner
Recommended thinner
(depending on application and equipment)
Nozzle orifice
Nozzle pressure
Maximum attainable d.f.t.
Cleaning of tools

Airless-spray	Airspray	Brush/roller
FGM 631	FGM 631	FGM 631
0 – 15 vol. %	5 – 20 vol. %	0 – 5 vol. %
0.38 – 0.48 mm 0.015 – 0.019 inch	1.5 – 2.0 mm	
150 – 180 bar	3 – 4 bar	
100 µm	80 µm	60 µm
Thinner FGM 631		

Surface conditions

Steel

New steel:
Acraton HS-U, Monopox SF-HB, Monopox ZF-Universal, Monopox Metalcoat ZL 70, Monopox micro-zinc or Monopox LG micro-zinc can be used as a primer.

Repair and maintenance:
Clean the surface thoroughly with a suitable cleaning preparation or by steam cleaning.

Remove salts and other water-soluble impurity by spraying with clean tap-water under high pressure.

Remove rust a.o. by (water)blasting Sa 2½ or derust mechanical until St. 2-3.

Apply the recommended paint system on a clean surface.

- Mechanical or hand derusting gives less quality than (water)blasting and will result in less protection of the applied paint system.



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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 phenomena.

Discoloration or loss of gloss or other surface defects, can occur during drying and curing by condensation and or early water spotting.

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 Aluminium	1895 m ³ /L	70 m ³ /L
Thinner FGM 631	3995 m ³ /L	160 m ³ /L

MAC = Maximum Accepted Concentration

LEL = Lower Explosion Limit

Also consult the safety information sheets

Pretreatment / Labelling / 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 5 General guidelines for the application of Acraton plastics
- A 6 Pretreatment of construction steel

These data have been drawn up to the best of our knowledge and were correct at the date of issue. However we cannot accept full responsibility, because the choice of products and circumstances during elaboration of the systems fall outside our judgement. This documentation sheet will not automatically be replaced in case of modification.
The English language text is a translation. In case of doubt the Dutch language original text has to be consulted as the authoritative text.

