

VITRETHANE 410



Two Pack High Build Epoxy Coating

Technical Data Sheet Number 045

PRODUCT DESCRIPTION	A & I Coatings VITRETHANE 410 is a high solid high build epoxy coating with excellent adhesion properties.				
USES & BENEFITS	Long term protection to concrete and steel for a wide range of industrial applications: <ul style="list-style-type: none"> • Factories/Warehouses • Chemical plants • Steel in extreme environments • Aircraft hangars • Repaints / maintenance • Food processing plants and abattoirs • Pulp and paper plants • Tank exteriors • Effluent water treatment plants 				
	<u>Benefits</u> <ol style="list-style-type: none"> 1. Excellent adhesion 2. Can be used as a self priming and porosity equaliser coat. 3. Tough, strong coating 4. Can be used for immersion in water or sewerage 	<u>Limitations</u> <ol style="list-style-type: none"> 1. Not recommended for immersion in acids, alkalis or solvents 2. Not to be applied to thermoplastic coatings 3. Will chalk when continuously exposed to sunlight & UV light. The chalking in no way impairs the coating performance 4. Not to be applied to a warming slab in case of out gassing 5. Temperature at time of application should be at least 10°C. 6. Humidity should be less than 75% 			
PHYSICAL PROPERTIES	Vehicle Type	Two component epoxy			
	Hardener	Amine			
	Mixing Ratio	3 :1(Part A : Part B) by Volume			
	Pot Life	Approx. 1 hour@20°C			
	Finish	Gloss			
	Theoretical Coverage	5-7 m ² /L/coat @ 140µm/coat			
	Volume Solids	85%			
	Recommended DFT	250-350 microns			
	Colour	N35 Light Grey and other pastel colours to medium colour range			
	Pigmentation	Titanium dioxide and other organic pigments			
	Primer Required	No, dependant on substrate. Contact A & I Coatings technical team for specifications			
	Usual No. of Coats	2 (dependant on substrate)			
	Product Weight	1.4Kg/Litre			
VOC Content	150 grams/Litre.(APAS)				
ENGINEERING DATA	Abrasion Resistance	Excellent			
	Chemical Resistance	Acid – Good. Alkali – Good. Not resistant to strong oxidising acids, phenols or amines. Contact A & I Coatings for specific recommendations			
	Dry Heat Resistance	Up to 120°C			
	Solvent Resistance	Good			
	Durability	Excellent, but will chalk under UV exposure without damage to the integrity of the coating			
CURING DATA	Substrate Temp.(°C)	Touch Dry	Hard Dry	Full Cure	Recoat max
	25 °C	4 – 6 Hrs	18 Hrs	7 Days	18 – 24 Hrs
	Note	Maximum recoat varies with the environment and the topcoat used.			

APPLICATION DATA	Mixing	Power stir Pack A, then blend with Pack B to correct ratio. Power stir the roughly for at least two minutes prior to use. Only mix required amount and use within the stated pot life. Allow to stand for 15 minutes after mixing A & B. Thin if required for flow. In cool weather, stir and let stand for a few minutes and then restir. This will eliminate the likelihood of amine bloom.
	Application	Apply evenly with a 10 – 13mm nap roller, or by brush or airless spray, taking care to apply at specified coverage rate. Primer coat may be thinned 20% with V122 Epoxy Thinners.
	Cleaning	Use V122 Epoxy Thinners.
	Thinning	If necessary with V122 Epoxy Thinners.
SURFACE PREPARATION	All Surfaces	All surfaces to be structurally sound and free of contamination, particularly salt deposits. Loose or flaking paint must be removed by abrasive blast cleaning, power tool cleaning or sanding, to AS 1627. Oil, grease, dirt etc must be removed with detergent and water blasting or solvent cleaning to AS1627.1. Primers should be abraded as necessary.
	Concrete	Allow new concrete to cure for 28 days prior to coating. Surface must be sound, dry, free from all loose material, laitance, old coatings, dust and surface contaminants (e.g. oil, grease, chemicals, release/curing agents etc.). Smooth or contaminated surfaces must be mechanically treated by abrasive blasting or grinding to achieve a clean anchor pattern for best adhesion. Oily surfaces must be detergent cleaned and water blasted. In some instances acid etch and water blasting may be adequate to form a 'key' for sufficient adhesion. Please note that moisture content in the concrete must be no greater than 4% prior to application of the V410.
	Repaints	All surfaces should be free from oil, grease, loose paint and other contaminants. Though Vitrethane 410 may give good adhesion, a test patch is always necessary before use.
	Steel	Degrease the surfaces and remove all weld spatter and flux. Grind sharp edges and corners. For best results abrasive blast clean to specified/recommended AS 1627-1 to 9. Apply A & I Coatings specified primer depending on corrosive environment with a high solid epoxy as a barrier coat. Please consult A & I Coatings Technical team for particular specifications.
WORK STOPPAGES	General	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with A & I Coatings recommended cleaner. Once units of paint have been mixed they should not be resealed and it is advised that after prolonged stoppages work recommences with freshly mixed units.
	Clean Up	Clean all equipment after use with A & I Coatings recommended cleaner. It is good work practice to periodically flush out spray equipment during the course of the working day. Frequency of cleaning will depend upon amount sprayed, temperature and elapsed time, including and delays.
PACKING & STORAGE	Packing	Available in 4 or 10L packs. For availability of other sizes, contact A & I Coatings.
	Storage	12 months if stored in sealed containers away from heat & moisture. Subject to re-inspection thereafter.
HEALTH & SAFETY	All applicable statutory regulations must be observed in the application of this product. Users must first read the Material Safety Data Sheet for Vitrethane 410. Users should familiarise themselves with all the safety aspects of the product prior to use. Please ensure the current Technical Data Sheet is consulted prior to specification or application of A & I Coatings products. If the surface intended to be painted differs from the specification, please consult the A & I Coatings Technical team on 1800 819 585.	

All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation. Note: The figures quoted for pot life and drying/curing times are not definitive. They are dependent on onsite conditions, such as volume of material mixed, ambient and substrate temperatures, weather and ventilation. DISCLAIMER Since the use and application of this product is beyond our control, we cannot be held responsible for product field performance. The information presented above is the result of our considerable experience with this product but is not to be construed as a performance warranty. For additional information, phone our Customer Service Centre on 1800 819 585.

May 2019 - THIS DATA SHEET SUPERSEDES THOSE PREVIOUSLY ISSUED.