Technical Data Sheet

DUOPOL® EP D253
Epoxy Micaceous Iron Oxide Paint

Product Description
Two-pack epoxy micaceous iron oxide paint with very good resistance to mechanical effects and industrial atmospheres. Excellent corrosion protection thanks to the high content of micaceous iron oxide. Ideal intermediate coating for C5 h/vh systems according to ISO 12944. Sustained thermal resistance up to 140 °C dry heat.

Areas of Application
Thanks to its fine surface, Duopol EP D253 is excellently suited as an intermediate coat under polyurethane and fluoropolymer top coats without the need for sanding at film thicknesses of 40 - 50 µm.
Top coat for steel and industrial installations in indoor areas. Duopol EP D253 tends to chalk and to change color if exposed outdoors.

Application and addition of thinner
Conventional and airless spraying, brushing and rolling.

For a better spray mist absorption when applying to large areas or at warm temperatures, the use of thinner V109 is recommended.

The pigment in form of tiny plates may cause irregular effects if applied by roller or brush.

Do not apply at temperatures below + 10 °C. Surface temperature must be at least 3 °C above dew point to prevent moisture condensation during application.

Overcoatable with itself or topcoats after 12 hours (@ 15 - 20 °C / DFT ≤ 100 µm) intermediate drying time.

Application method	Thinning	Nozzle
Conventional spraying	ca. 15 - 20 % V2/V109 on 25 - 35 sec. DIN 4	1.8 – 2.5 mm
Airless spraying	ca. 5 % V2/V109 on 45 - 50 sec. DIN 4	narrow 215/218 medium 415/418 wide 615/618
Brushing and rolling	with 0 - 5 % V2/V109	

Special note
Our data are based on standard climate 23/50. The information contained in this technical data sheet is based on general technical standards and is meant for specialists. Any changes in the recommended operating procedures or specified environmental conditions may influence the results significantly. Our guarantee covers only the quality of the material delivered. We do not undertake any responsibility for the application. In case of doubt, we recommend contacting our Technical Service. Our products are under constant development. Therefore, note the date of the technical data sheet and ask for the latest edition (also available directly from our website).

Safety measures
Duopol EP D253 contains solvents and is combustible, therefore protect from heat and keep away from naked flames. Sufficient air circulation must be provided. Do not inhale vapours. All regulations regarding work hygiene and operational measures must be observed.

Technical Data

Binder	two-pack epoxy resin
Pigmentation	Micaceous iron oxide
Finish	Flat
Colour	Silver grey (DB 701), dark grey (DB 703), other colors upon request). Depending on application method, the colors may differ from the original. To avoid any differences of color on the same object, use only material with same batch number.
Substrate	two-pack primers, e.g. - Duopol Steelguard C80 - Biladur EP C90 - Duopol Z60 / Z60L - Hempel Multi Prime The substrate must be dry, free of grease and dust.
Thinner	V109/V2 (The use of other thinners may lead to defects and loss of quality).
Packaging	Pigment: 8 / 24 kg disposable containers Hardener: 1 / 3 kg disposable containers
Storage	Pigment 12 months, hardener 6 months in original, unopened containers stored at a temperature of 20 °C.
Waste disposal	Residues and expired material are considered as special refuse and must be treated as such, VeVa-Code 08 01 11.

Components	2
Hardener	H200
Mixing ratio	8 : 1 wt.-parts
Potlife	approx. 5 hours at 20 °C
Drying (23 °C)	Dust-dry approx. 30 min. Dry to touch approx. 3 hours Transportable approx. 16 hours Drying times depend on film thickness, substrate and air temperatures.
Forced drying	possible, e.g. 30 min. at 80 °C

Solids content	by weight : approx. 74 % by volume: approx. 61 %	mixture, DB 703
Density (20 °C)	approx. 1.5 kg/l	
Theoretical consumption	approx. 150 g/m² @ 60 µm	

	Duopol EP D253	**Hardener H200**	**V2**	**V109**
VOC value	23 %	46 %	100 %	100 %

(replaces issue 04.17) 01.23

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