

## DUASOLID 50

### DESCRIPTION

A two component oxirane ester paint containing active anti-corrosive pigments.

### PRODUCT FEATURES AND RECOMMENDED USES

- ◆ Used as a single coat or as a topcoat in oxirane ester based systems on steel surfaces exposed to abrasion and chemicals in severe climatic conditions.
- ◆ Excellent durability.
- ◆ Environmentally more friendly and for users more safe alternative than epoxy and polyurethane paints.
- ◆ High volume solids.
- ◆ High film build properties, up to 100 µm / one coat.
- ◆ Suitable for earth moving machines, haulage and lifting equipment, forklifts, agricultural machinery, electric appliances, pumps and other steel structures, equipment and machinery.

### TECHNICAL DATA

**Volume solids** approx. 65 ± 2 %.

**Specific gravity** approx. 1.5 kg / l

**Mixing ratio and product codes**  
Base 2 parts by volume 527-series  
Hardener 1 part by volume 008 7675 (55904), other hardeners: see page 2

**Pot life** 8 hours (23 °C)

### Recommended film thicknesses and theoretical coverage

Recommended film thicknesses approx.		Theoretical coverage approx.
dry	wet	
60 µm	95 µm	10.6 m <sup>2</sup> /l
100 µm	160 µm	6.4 m <sup>2</sup> /l

Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated.

### Drying times

DFT 80 µm	<b>+ 23 °C</b>
Dust dry, after	30 - 60 min
Touch dry, after	4 - 6 h
Dry to handle, after	8 - 12 h
Recoat with other Duasolid 50 paints, after	a few min
Through dry at increased temperature after 45 min / 80 °C.	

Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation.

**Finish** Varies depending on the used hardener. See page 2.

**Colours** RAL, NCS, SSG, BS, MONICOLOR NOVA and SYMPHONY colour cards. TEMASPEED tinting.

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## APPLICATION DETAILS

<b>Surface preparation</b>	Oil, grease, salts and dirt are removed by appropriate means. (ISO 12944-4)  <u>Steel surfaces:</u> Blast clean to grade Sa2½. (ISO 8501-1) If blast cleaning is not possible, phosphating is recommended for cold rolled steel to improve adhesion.  <u>Primed surfaces:</u> Oil, grease, salt and dirt are removed from the surface by appropriate means. Repair any damage to the primer coat. Note the overcoating time of primer. (ISO 12944-4)
<b>Primer</b>	DUASOLID PRIMER and DUASOLID 50.
<b>Finish</b>	DUASOLID 50.
<b>Application conditions</b>	All surfaces must be dry. The temperature of the ambient air, surface or paint itself should not fall below +10 °C during application or drying. Relative humidity should not exceed 80 %. The surface temperature of the steel should remain at least 3 °C above the dew point.
<b>Mixing components</b>	First stir base and hardener separately. The correct proportions of base and hardener must be mixed thoroughly before use. Use Temaspeed Squirrel Mixer for mixing.
<b>Application</b>	By airless, conventional or electrostatic spray. At airless spray application the paint can be thinned if necessary to a viscosity of 20 s DIN 4. Airless spray nozzle tip "0.013 - 0.015", pressure ratio at least 30:1 and nozzle pressure 160 - 200 bar. Atomization air pressure 2 - 4 bar. At conventional spray application the viscosity should be 20 - 40 s DIN 4 and at electrostatic spraying 20 s DIN 4.  Properties and gloss of DUASOLID 50 will vary according to the used hardener:  Hardener 008 7675 (55904) gloss abt. > 70 mixing ratio 2:1 Hardener 008 7670 (55953) gloss abt. >70 mixing ratio 2:1 Hardener 008 7665 (55911) gloss abt. 60 mixing ratio 2:1 Hardener 008 7667 (55917) gloss abt. 10 mixing ratio 2:1 Hardener 008 7672 (55939) gloss abt. 40 mixing ratio 2:1 Hardener 008 7666 (55907) gloss abt. > 70 mixing ratio 8:5 Hardener 008 7668 gloss abt. < 10 mixing ratio 2:1  Avoid hot spray!
<b>Thinner</b>	Thinner 1048 or Thinner 1112.
<b>Cleaning of equipment</b>	Thinner 1048 or Thinner 1112.
<b>VOC</b>	The Volatile Organic Compounds amount is 320 g/litre of paint mixture. VOC content of the paint mixture (thinned 15 % by volume) is 399 g/l.
<b>HEALTH AND SAFETY</b>	Containers are provided with safety labels, which should be observed. Further information about hazardous influences and protection are detailed in individual health and safety data sheets. A health and safety data sheet is available on request from Tikkurila Oy.