TWO-COMPONENT EPOXY COATING
2400 (A&B COMPONENTS)

A special two-component epoxy coating provides excellent mechanical, chemical and humidity resistances. Once fully cured, this coating forms a strong film exhibiting outstanding adhesion, hardness and flexibility. This product complies with National Iranian Standard ISIRI-2920. (Certificate No. 8635360914)

USES AND SUITABALE PRIMERS

Recommended Uses	Intermediate and top-coat for steel structures, brushed sandblasted Primed steel surfaces, and maintenance operations.
Suitable Primers	Epoxy Primer and 2400 can be over-coated by itself.

CHEMICAL COMPOSITION

Type of Binder	Epoxy – Polyamide
Number of Component(s)	2 Components
Curing Mechanism	Chemical Reaction
Flash Point	28°C (82°F)

Solid Content After Mixing	Silver	Other Colours
By Weight	74 ± 1%	77 ± 1%
By Volume	60 ± 2%	60 ± 2%

PHYSICAL PROPERTIES

Finish	Glossy
Colour	White, Black, Red, Green, Blue, Yellow,Silver.
Specific Gravity after Mixing	(Silver) 1.25 ± 0.05 gr/cm³ | (Other Colours) 1.45 ± 0.05 gr/cm³

APPLICATION DETAILS

Surface Preparation: All oil, grease, dirt and other contaminants must be removed from the surface. Sandblast according to Swedish Standard (IS 5900) Sa 2 ½ or wire brush St.2 followed by applying a suitable primer is recommended.

Mixing Ratio: Component A: 100 Parts by weight Component B: 2400-B or RTB-9000 20 Parts by weight

Mixing Instructions: Mix component A thoroughly with a suitable mixer, then add component B slowly and mix well for 5 minutes. Keep the mixture for 10 additional minutes prior to thinning down to allow for the pre-reaction time. Do not thin down each component separately.

Pot Life: 6 Hours at 25°C

Theoretical Consumption: 110-120 gr/m² @ 50 Microns DFT

Paint Application

Methods	Airless Spray	Air Spray	Brush	Roller
Nozzle Size	0.009" – 0.013"	1.80 mm or1.60 mm	---	---
Pump Ratio	1 / 45	---	---	---
Air Pressure	4 – 6 Bar	3 – 5 Bar	---	---
Thinning	7 – 10% T-445	15 – 20% T-445	3 – 5% T-445	3 – 5% T-445

Film Thickness

	Recommended	Minimum	Maximum
Wet Film Thickness (µm)	85	40	125
Dry Film Thickness (µm)	50	25	75

Drying Time

Dust Free Time	Tack Free Time	Dry to Handle	Fully Cured	Recoating Interval
20 – 40 Minutes	2 – 3 Hours	16 – 24 Hours	10-14Days	Min. 16 Hours Max. 10 Days

**Drying time calculated at 25°C according to ASTM test method D-1640 for 100 µm WFT*

Application Limits

Relative Humidity	Min. ---	Max. 80%
Temperature	Min. +5°C	Max. +40°C
Substrate Temperature*	Min. +5°C	Max. +45°C

**Please note that the substrate temperature should be at least 5°C above the dew point*

Recommendations:
-Should the recoating interval have expired, please refer to the procedures outlined in the Ronass Instruction Leaflet.
-Clean tools thoroughly before and immediately after use with T-445.

PACKING, STORAGE AND SAFETY

Packing: Component A(Epoxy): 4 Litres Containers (4 kgs. Net) and Component B(Hardener): 1 Litres Containers (0.8 kgs. Net)

Storage Conditions: To be stored in cool and dry conditions in original sealed containers.

Shelf Life: At least 18 months after delivery in original sealed containers and proper storage conditions with temperature of 25°C.

Safety: This product contains organic solvents and flammable materials. Keep away from sparks, fires, electrical cables and equipments, direct sunshine and out of children's reach.

Protect skin, eyes, and avoid prolonged breathing of solvent vapor during application. Use with adequate ventilation.