

C4 coating system

Coating type:	Primer: 2-component epoxy resin coating (2K-epoxy), solvent-based
	Single-coat product: 2 pack polyurethane coating (2K-PUR), solvent-based
Characteristics:	Anti-corrosion coating for high corrosion stress (to C4 M in accordance with DIN EN ISO 12944-2), very good corrosion protection, moderate chemical resistance, very good scratch and impact resistance, good UV stability, very good gloss and colour fastness, high weather resistance, long-lasting temperature resistance (dry heat) up to 120° C
Colour:	Epoxy resin primer: light grey Polyurethane top coat: According to RAL card or customer's request e.g. NCS British standard
Scope of application:	externally: Industrial areas with moderate and high humidity and aggressive atmospheres, coastal areas with moderate salinity. internally: Industrial areas with high humidity and aggressive atmospheres, buildings with almost constant condensation and high level of contamination, boathouses above seawater
Protection period:	(L) Low up to 7 years (M) Medium 7 – 15 years

Processing information

Dry layer thickness:	100 µm Epoxy primer 80 µm PUR top coat 180 µm Total layer thickness
Ambient temperature:	at least + 15° C, not below 0 °C, not above 40 °C
Relative humidity:	max. 80%
Object temperature:	at least + 10° C and min. 3° C above the dew point
Processing time for primer	approx. 1 to 2 hours (depending on temperature)
Processing time for top coat:	approx. 4 to 6 hours (depending on temperature)
Primer can be painted over:	after approx. 5 hours
Curing time:	Primer:
Degree of dryness at 100 µm DFT	Dust-dry after approx. 2 hours Ready for installation / non-sticky after approx. 4 hours
(A temperature that is 10° C lower than this doubles the drying time!)	Top coat:
	Ambient temperature + 5 °C + 10 °C + 20 °C
	Degree of dryness 1 (dust-dry) ≤ 60 min. ≤ 45 min. ≤ 30 min.
	Degree of dryness 3 (non-sticky) 3 – 4 hours 2 - 3 hours 1 - 2 hours
	Degree of dryness 6 (grip-dry) approx. 8 hours approx. 6 hours 3 - 4 hours