

Technical Data

JOTACOTE 412



Product description

A high build, solvent free, two pack cycloaliphatic amine adduct cured epoxy coating.

Recommended use

Protection of steel, concrete and masonry surfaces in hygienic locations such as food processing plants, potable water storage tanks and storage of edible products suitable for use as a tank lining for a wide range of petroleum products - contact Jotun for specific recommendations.

Film thickness and spreading rate

	Minimum	Maximum	Typical
Film thickness, dry (µm)	200	500	250
Film thickness, wet (µm)	200	500	250
Theoretical spreading rate (m ² /l)	5	2	4

Physical properties

Colour	Black, Red oxid and White
Solids (vol %)*	100 ±
Flash point	>100°C (Setaflash)
Gloss	Glossy
Water resistance	Excellent
Abrasion resistance	Very good
Solvent resistance	Very good
Chemical resistance	Very good
Flexibility	Good

*Measured according to ISO 3233:1998 (E)

Surface preparation

Bare steel

Cleanliness: Blast cleaning to min. Sa 2 ½ (ISO 8501-1:1988) or for maintenance UHPWJ to WJ2 (NACE No.5/SSPC-SP 12). Roughness: using abrasives suitable to achieve grade Fine to Medium G (30-85 µm, Ry5) (ISO 8503-2)

Other surfaces

The coating may be used on other substrates. Please contact your local Jotun office for more information.

Condition during application

For steel substrate: The temperature of the substrate should be minimum 10°C and at least 3°C above the dew point of the air, temperature and relative humidity measured in the vicinity of the substrate. For Concrete: The moisture content in the concrete should not exceed 4 % (by weight).

The coating should not be exposed to oil, chemicals or mechanical stress until fully cured.

Application methods

Spray	Use airless spray
Brush	Recommended
Roller	Recommended

Application data

Mixing ratio (volume)	2 parts Comp. A (base) to be mixed thoroughly with 1 part Comp. B (curing agent).
Pot life (23°C)	1 hour (reduced at higher temperature).
Thinner/Cleaner	Jotun Thinner No. 4 / Jotun Thinner No. 17
Guiding data airless spray	
Pressure at nozzle	Pressure at nozzle: 25 - 35 MPa (3600 - 5000 p.s.i.)
Nozzle tip	0.53 mm - 0.65 mm (0.021" - 0.026")
Spray angle	40° - 80°
Filter	Min. 60 mesh recommended, check to ensure filter is clean.

Drying time

Drying times are generally related to air circulation, temperature, film thickness and number of coats, and will be affected correspondingly. The figures given in the table are typical with:

- * Good ventilation (Outdoor exposure or free circulation of air)
- * Typical film thickness
- * One coat on top of inert substrate

Substrate temperature	10°C	23°C	40°C
Surface dry	15 h	6 h	1.5 h
Through dry	30 h	12 h	4 h
Cured	15 d	7 d	4 d
Dry to recoat, minimum	30 h	12 h	4 h
Dry to recoat, maximum	96 h	48 h	18 h

The given data must be considered as guidelines only. The actual drying time/times before recoating may be shorter or longer, depending on film thickness, ventilation, humidity, underlying paint system, requirement for early handling and mechanical strength etc. A complete system can be described on a system sheet, where all parameters and special conditions could be included.

Typical paint system

Jotacote 412 **2 x 250 microns** **(Dry Film Thickness)**
Other systems may be specified, depending on area of use

Storage

The product must be stored in accordance with national regulations. Storage conditions are to keep the containers in a dry, cool, well ventilated space and away from source of heat and ignition. Containers must be kept tightly closed.

Handling

Handle with care. Stir well before use.

Packing size

13.3 Ltr. component A, 6.7 Ltr.. component B
2.67 Ltr. component A, 1.33 Ltr. component B.

Packing may vary from country to country according to local requirements.

Health and safety

Please observe the precautionary notices displayed on the container. Use under well ventilated conditions. Do not breathe or inhale mist. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water and medical attention sought immediately.

For detailed information on the health and safety hazards and precautions for use of this product, we refer to the Material Safety Data Sheet.

DISCLAIMER

The information in this data sheet is given to the best of our knowledge based on laboratory testing and practical experience. However, as the product is often used under conditions beyond our control, we cannot guarantee anything but the quality of the product itself. We reserve the right to change the given data without notice.

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Jotun is a World Wide company with factories, sales offices and stocks in more than 50 countries. For your nearest local Jotun address please contact the nearest regional office or visit our website at www.jotun.com

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