

OROMEL 644

EPOXY ENAMEL

Reticulate by mixing 2 : 1 by volume with **OROCAT 744** catalyst

Enamel based on polyamide epoxy resin with two components, high resistance to chemicals, fats and oils, excellent hardness and resistance to abrasion. Specially designed for the painting of metallic structures, machinery, as well as for the finishing of industrial floors, changing rooms ... Product for interiors.

Physical parameters	Primer OROMEL 644	Catalyst OROCAT 744
Viscosity (Ford cup n° 4)	120 – 1800"	6000 – 10000 cpoise (Brookfield)
Specific gravity	1,20 – 1,50 g/mL	0,89 – 0,92 g/cc
Solids	65 – 75%	65 - 67%
In-can appearance	Viscous liquid	Viscous liquid
Stability (without opening the can)	12 months at 10 – 25°C	12 months

Characteristics of the mixture	
Mixture ratio	2:1 in volume (OROMEL 644:OROCAT 744)
Mixture viscosity	-"
Mixture specific gravity	1,05 – 1,30 g/mL
Sólidos de la mezcla	65 – 73%
Colour	White and tintometric base (White base P and transparent base TR)
Dry film appearance	Glossy film with good adhesion and resistance
Spreading rate	12 – 15 m ² / L (85 – 105 g/m ²)
Gloss	>90 %
Adhesion	100% (Máx: GT0)
Hardness persoz	>180 s
COV	<500 g/L Directive 2004/42 / EC: Limit value (2010) for this product (subcategory A / i): 500 g / L
Mixture Pot life	4 - 5 hours

Product use information	
Surface	Iron, Cement
Surface preparation	The iron surface will be clean and dry, dripped to Sa 2 ½ and primed with OROPRIMER 485. In the case of cement, it must be dry, clean and unpolished
Product preparation	Do not apply at temperatures below 14°C. Before applying, homogenize the product well with a spatula. Make the mixture with the catalyst (in volume) of 2 parts of OROMEL 644 (Base) with 1 part of OROCAT 744 (Catalyst)
Application method	Brush, Pneumatic gun
Dilution	Up to 20% ORODIS 718.
Application	Apply 1-2 hands 40 – 50 µm

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Drying	Touch drying time: 4 hours Forced drying: 30 min. at 100°C The product does not reach the optimum hardness until after 7 days. The drying time is heavily influenced by the grammage, the type and condition of the support and environmental conditions
Recoatable	<24 hours
Cleaning	ORODIS 718

Application process	Primer	I	Top coat
Iron, Steel	OROPRIMER 485		OROMEL 644
Cement	OROLUR 388		OROLUR 384

Additional information	
Safety	Consult package labelling. For further information, ask for the Material Safety Data Sheet
Storage	1 year

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