

OROMEL 647

EPOXY ENAMEL

Mix 5:1 by weight with **OROCAT 790** or **OROCAT 749**

Two pack epoxy gloss enamel. Product of high hardness and solvent resistance. Especially suitable as a coating for grease, oil and liquid fuels deposits, in general. Thanks to its high solids content, allows the application of thicknesses above 100µm. Good adherence on steel and concrete substrates.

Physical parameters	Base OROMEL 647	Catalyst OROCAT 790
Viscosity (Brookfield sp6 10rpm)	40000 – 50000 cpoise	1500 – 3000 cpoise
Specific gravity	1,75 – 1,80 g/cc	0,98 – 1,02 g/cc
Solids content	95%	93 – 96%
In-can appearance	Viscous liquid	Viscous liquid
Stability	12 months at 10 – 25°C	12 months

Characteristics of the mixture	
Mix ratio	5:1 by weight (OROMEL 647 : OROCAT 790 or OROCAT 749)
Viscosity of the mixture	-"
Specific gravity of the mixture	1,55 – 1,60 g/cc
Solids content	93 – 96%
Colour	White
Dry film appearance	Glossy finish with good coverage and resistance
Spreading rate	4 – 5 m ² / Kg (170 – 220 g/m ²)
Gloss	>80%
Adhesion (traction)	>2 MPa
Persoz hardness	>200 s
Pot life of mixture	30 – 40 minutes

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Product use information

Surface	Iron, concrete
Surface preparation	Iron surfaces must be deoxidized, dry and degreased. Concrete surfaces must be dry, well cured, without saltpetre or fungi.
Product preparation	Never apply at temperatures below 10°C. Stir thoroughly the contents of the container with a spatula. Make the mixture (by weight) 5 parts of OROMEL 647 (Base) to 1 part of OROCAT 790 (Polyamide catalyst) or OROCAT 749 (Aliphatic polyamine catalyst)
Application method	Brush, Roller, Airless spray
Dilution	Up to 10% with ORODIS 718
Application	Apply 1 coat of 100 – 120 µm dry film thickness Before use: Homogenize the product and temper it. Do not apply at temperatures below 10°C.
Drying	Touch drying time: 5 – 7 hours Total drying time: 7 – 10 days Drying time is very influenced by the applied quantity, the environment and the substrate's type and condition.
Recoatable	24 hours
Cleaning	ORODIS 718

Application process

	Primer	Top coat
Iron	OROPRIMER 490	OROMEL 647
Concrete		OROMEL 647

Additional information

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

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