

# OROMEL 649

## FOOD GRADE EPOXY ENAMEL

Mix 2:1 by volume with **OROCAT 749**

Two pack solvent free, high build coating based on epoxy resins. It provides high gloss finish, superior hardness and washability with water and ordinary detergents. Being solvent free, is ideal for use throughout clinical and food industry. It resists continuous temperatures up to 80°C. Sanitary Register 39.01685 / S.S. – 04666.

| Physical parameters              | Base OROMEL 649        | Catalyst OROCAT 749 |
|----------------------------------|------------------------|---------------------|
| Viscosity (Brookfield sp6 10rpm) | THIXO                  | THIXO               |
| Specific gravity                 | 1,70 – 1,80 g/cc       | 1,00 – 1.05 g/cc    |
| Solids content                   | 100%                   | 100%                |
| In-can appearance                | Viscous liquid         | Viscous liquid      |
| Stability                        | 12 months at 10 – 25°C | 12 months           |

| Characteristics of the mixture  |  |
|---------------------------------|--|
| Mix ratio                       | 2:1 by volume (OROMEL 649 : OROCAT 749)  |
| Viscosity of the mixture        | -"   |
| Specific gravity of the mixture | 1,45 – 1,55 g/cc   |
| Solids content                  | 100%   |
| Colour                          | White, Red oxide   |
| Dry film appearance             | High gloss finish with good resistance and excellent hiding power                          |
| Spreading rate                  | 6 – 8 m <sup>2</sup> / L (185 – 265 g/m <sup>2</sup> )                                     |
| Gloss                           | >90%   |
| VOC                             | <<1 g/L Directive 2004/42/CE: Limit value (2010) for this product (sub. cat. A/j): 500 g/L |
| Pot life of mixture             | 1 – 2 hours  |

| Product    | Product code | Brand  | Author                       | Date     | Version | Replaces             | Page | Language |
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| OROMEL 649 | 06R649XXXZZZ | OROPAL | IKI COATINGS – IRURENA GROUP | 23.07.19 | 1       | Any previous version | 1/2  | EN       |

## Product use information

|                     |   |
|---------------------|---|
| Surface             | Iron, Steel, Cement   |
| Surface preparation | Iron must be clean, dry and sandblasted to Sa 2 ½ and cement should be dry, clean and dustless  |
| Product preparation | Never apply at temperatures below 14°C nor humidity above 75%. Stir thoroughly the contents of the container with a spatula. Make the mixture (by volume) 2 parts of OROMEL 649 (Base) to 1 part of OROCAT 749 (Catalyst) |
| Application method  | Brush, Roller   |
| Dilution            | Do not dilute   |
| Application         | Apply 1 coat of 125 – 175 µm dry film thickness   |
| Drying              | Touch drying time: 7 – 9 hours<br>Maximum hardness: 7 days (at 20°C and relative humidity of 60%)<br>Drying time is very influenced by the applied quantity, the environment and the substrate's type and condition.      |
| Recoatible          | <24 hours   |
| Cleaning            | ORODIS 718  |

## Application process

|             | Primer | Top coat   |
|-------------|--------|------------|
| Iron, Steel |        | OROMEL 649 |
| Cement      |        | OROMEL 649 |

## Additional information

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

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