

Technical Data

Jotacote 418



Product description

Jotacote 418 is a high-build, amine cured epoxy coating with high resistance to a wide range of chemicals and solvents.

Recommended use

Protection of steel and concrete in aggressive locations. Excellent lining for a wide variety of chemical and petrochemical commodities.

Film thickness and spreading rate

	Minimum	Maximum	Typical
Film thickness, dry (µm)	100	250	150
Film thickness, wet (µm)	145	360	215
Theoretical spreading rate (m ² /l)	7	2,8	4,7

Approvals

APAS approved to specification 0145/1, 0212, 2973 and 2973F, S & T.

Physical properties

Colour	Light grey, White
Solids (vol %)*	70 ± 2
Flash point	21°C ± 2 (Setaflash)
Gloss	Semigloss
Gloss retention	Poor
Water resistance	Excellent
Abrasion resistance	Very good
Solvent resistance	Very good
Chemical resistance	Excellent
Flexibility	Limited

*Measured according to ISO 3233:1998 (E)

Surface preparation

All surfaces should be clean, dry and free from contamination. The surface should be assessed and treated in accordance with ISO 8504.

Bare steel

Cleanliness: Blast cleaning to min. Sa 2 ½ (ISO 8501 1:2007). Roughness: using abrasives suitable to achieve Grade Medium G (50 - 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

The temperature of the substrate should be minimum 5°C and at least 3°C above the dew point of the air, temperature and relative humidity measured in the vicinity of the substrate. However when product is applied between 5°C-10°C then substrate should be min 5°C above dew point. Good ventilation is usually required in confined areas to ensure proper drying. The coating should not be exposed to oil, chemicals or mechanical stress until fully cured.

Application methods

Spray	Use airless spray
Brush	Recommended for stripe coating and small areas, care must be taken to achieve the specified dry film thickness.

Application data

Mixing ratio (volume)	4 parts Comp. A (base) to be mixed thoroughly with 1 part Comp. B (curing agent)
Pot life (23°C)	2 hours (Reduced at higher temp.)
Thinner/Cleaner	Jotun Thinner No. 17
Guiding data airless spray	
Pressure at nozzle	15 MPa (150 kp/cm ² , 2100 psi)
Nozzle tip	0.46-0.69 mm (0.018-0.027")
Spray angle	40-80°C
Filter	Check to ensure that filters are 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	5°C	10°C	23°C	40°C
Surface dry	4 h	2 h	1 h	30 min
Through dry	36 h	24 h	12 h	6 h
Cured ²	15 d	10 d	5 d	3 d
Dry to recoat, minimum	36 h	24 h	12 h	6 h
Dry to recoat, maximum ¹	4 d	3 d	2 d	1 d

1. The surface should be dry and free from any contamination prior to application. If the maximum dry to recoat time is exceeded, please contact your local Jotun office for more information.
2. To achieve full chemical resistance a substrate temperature of at least 10°C is needed.

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 418 2 x 150 µm (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

16 litres Comp. A (base) in a 20 litre container and 4 litres Comp. B (curing agent) in a 4 litre container.

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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ISSUED 6 DECEMBER 2007 BY JOTUN
THIS DATA SHEET SUPERSEDES THOSE PREVIOUSLY ISSUED