

PRODUCT DESCRIPTION

Two-component polyamide cured epoxy coating providing the pinnacle of industrial protection against severe chemical and mechanical abuse.

FEATURES AND RECOMMENDED USE

- Outstanding resistance to chemicals, solvents, and water
- Excellent adhesion and abrasion resistance
- Specified for chemical plants and effluent treatment facilities
- Heavy marine and industrial application

TECHNICAL DATA

Colour Range	Industrial Shades
Finish	Smooth Solid
Mix Ratio (By Volume)	Base : Hardener = 4 : 1
Specific Gravity	0.95 - 1.45 (Mixed)
Recommended DFT / Coat	40 - 60 µm
Theoretical Coverage	8.0 - 10.0 sq.mtr/ltr @ 50 µm
Drying Time at 30°C	Surface Dry: 2 hours Hard Dry: 16 hours Full Cure: 7 Days
Pot Life at 30°C	6 Hours

The data given is for guideline only. The physical values are subject to normal manufacturing tolerances, colour and testing variances. The actual drying time/ overcoat interval may be shorter or longer, depending on film thickness, ventilation, humidity, temperature etc. The information provided above is at 30°C and 65% relative humidity.

DIRECTIONS FOR USE

Surface Preparation

General Metal:

- Surfaces must be dry, clean and free from contaminants.
- Ensure removal of dirt, oil and all other contaminants. Oil and grease should be removed as per SSPC-SP1 solvent cleaning.
- Surface should be checked and treated in accordance with ISO 8504 prior to priming.

Primed Surfaces:

- Suitable epoxy, PU, or alkyd primer/undercoat; dry & free from all surface contamination.
- IKKA EPOXY FINISH (4:1) must be applied within the specified over-coating interval of the primer.

Application Conditions

- Substrate temperature should be at least 3°C above dew point but not above 50°C.
- Relative humidity should be below 85% to prevent blushing or adhesion loss.
- Good ventilation is required in confined areas to ensure proper curing and solvent evaporation.

Mixing

Mix base and hardener in 4:1 ratio. Allow 15 minutes induction time before thinning.

Application Details

Air Spray	Thin 20-25% with Epoxy Thinner. Can be baked at 80°C for 30 mins to force cure.
Brush / Roller	Suitable for stripe coating.
Cleaning	Do not allow the product to remain in hoses or spray equipment. Clean all equipments immediately after use with Epoxy Thinner.

STORAGE & REGULATORY

Pack Size: As per standard Drona packaging (1L, 4L, 10L, 20L).
Shelf Life: At least 12 months @ 30°C for original unopened pack (36 months for architectural), subject to inspection thereafter.
Store in a cool, dry place away from direct

MATERIAL SAFETY & HANDLING

General Precautions: As a general safety measure, inhalation of solvent vapours or paint mist and contact of liquid paint with skin & eyes should be avoided. Forced ventilation should be provided when applying paint in confined spaces or stagnant air. Even when ventilation is provided, appropriate respiratory, skin, and eye protection are always recommended when spraying.