



IRATHANE 255EP

PRODUCT INFORMATION

Description	A two component 100% solids ambient temperature applied elastomeric coating system specifically developed to replace Irathane 255XD. Used in combination with the appropriate Irathane primers it can be used for a range of high build applications.	Features	High build makes the product suited to application on surfaces at any angle. Primer options mean it can be used on a range of substrates.
Recommended Applications	Ideal for coating or repairing dredging hoses, rubber pump casings and impellers and many other rubber coated or lined parts where post curing is not a possibility.	Package Size	4.0L 0.75L

PRODUCT DATA

Physical Properties	Colour	Resin (P) is Clear Hardener (C) is Grey Mixed product is Grey 1.13 : 1 1.30 : 1
	Mix Ratio by Volume	
	Mix Ratio by Weight %	65%
	Solids by Volume Pot	
	life at 15°C (Mins) Pot	120 minutes
	life at 25°C (Mins) Pot	100 minutes
	life at 35°C (Mins) Wet	40 minutes
	film build (mm)	As required
Performance Properties	Tensile Strength (MPa) BS6903 Part A2	TBA
	Elongation (%)BS6903 Part A2	TBA
	Temperature resistance (°C)	Maximum 65
	Coverage (approximate)	1.6 L/m ² /mm dft
	Cured Hardness (Shore A) BS6903 Part A57	83-85





Irathane 255EP

APPLICATION INFORMATION

Surface Preparation	<p>Proper surface preparation is essential to achieve the full potential of the system. Consult the relevant method statement for the application / substrate in question.</p> <p>Product should only be applied in conditions where the Temperature is >3°C above the dew point and Relative Humidity is <85%</p>
Mixing	<p>Prior to commencing use of the product ensure that the two components are stored a temperature of no lower than 20°C, a temperature of around 25°C is preferable and can be achieved by means of indirect heating with water or in a heated room.</p> <p>Agitate the Hardener prior to use. Transfer all of the Hardener into the Resin and mix thoroughly using a variable speed mixer with a spiral or jiffy type mixer paddle taking care not to mix air into the product. Minimum mixer speed should be 800 rpm. Mix the product for 2 minutes, scrape the sides of the container with a long bladed spatula to ensure there is no unmixed product then mix for a further 1 minute.</p> <p>DO NOT BREAK DOWN KITS</p>
Application	<p>Product should be applied by trowel to both horizontal and vertical surfaces.</p> <p>Review the appropriate method statement for detailed application instruction.</p>
Cure	<p>Cure times are quoted in the table below.</p>

	Substrate Temperature		
	10°C	20°C	30°C
Cure Walk on @ 5mm (Hours)	5	3	2
Cure Light Duty @ 5mm (Days)	1-2	1-2	1-2
Cure 80% @ 5mm (Days)	4	3	2
Cure 100% @ 5mm (Days)	8	6	4
Recoat Time minimum (Hours)	4	3	2
Maximum without reactivation (Hours)	16	8	6
Solvent wipe + UU55 & overcoat	16-36	8-24	6-12
Abrade + Solvent wipe + UU55 & overcoat*	>36	>24	>12

*Irabond RU80 will be required after a solvent wipe on a rubber substrate

Clean Up	<p>All equipment should be thoroughly cleaned directly after use using MEK or suitable alternative where possible.</p>
Shelf life & Storage	<p>A shelf life of 12 months from date of shipment can be expected when stored at room temperature (22°C) in their original containers.</p>
Precautions	<p>For complete safety and handling information, please refer to Material Safety Data Sheets prior to using this product.</p>
Warranty	<p>IrathaneFutura will replace any material found to be defective. Because the storage, handling and application of this material is beyond our control we can accept no liability for the results obtained.</p>

