

OROMEL 634

EPOXI ENAMEL

Crosslinking by mixing 4: 1 by weight with **OROCAT 734** catalyst

2 component epoxy water paint, with excellent mechanical and chemical properties. Formulated based on polymeric emulsions that allow a relatively fast drying and a good curing reaction up to temperatures of 10°C. Recommended for indoor use, outdoor yellowing due to UV rays. Allows the application of thicknesses greater than 100 microns.

Physical features	Base OROMEL 634	Catalyst OROCAT 734
Viscosity	150 – 300" (cup Ford nº 4)	1800 – 2200 cpoise (Brookfield sp4 100 rpm)
Specific weight	1,35 – 1,70 g/mL (dep. color)	1,12 – 1.17 g/cc
Solids	55 – 70% (depends color)	>99%
Appearance of the can	Viscous liquid	Viscous liquid
Stability (without opening the can)	12 months at 10 – 25°C	12 months

Characteristics of the mixture	
Relation of the mixture	4:1 by weight (OROMEL 634:OROCAT 734)
Viscosity of the mixture	-"
Specific weight of the mixture	1,25 – 1,60 g/mL (depends color)
Solids of the mixture	60 – 75% (depends color)
Color	White. Other colors, consult
Appearance dry film	Semi-gloss finish with low odor
Efficiency	6 – 8 m ² / Kg (145 – 170 g/m ²)
Gloss	60 – 80%
Adherence	100% (Máx: GT0)
VOC	<140 g/L Limit value (2010) according to directive 2004/42 / EC for this product (subcategory A / j): 140 g / L
Persoz hardness	>210 s
Pot life of the mixture	90 minutes

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OROMEL 634	06R634XXXZZZ	OROPAL	IKI COATINGS – IRURENA GROUP	25.09.18	1	Any previous version	1/2	EN

Product use	
Support	Cement, Concrete, Steel
Support preparation	Cement or concrete surfaces must be dry, well set, without stains, saltpetre, sands or fissures. In the case of steel, it will be dry, degreased and free of rust. The surfaces to be applied may be slightly damp (8% maximum), but not wet.
Product preparation	Do not apply at temperatures below 10°C, or with humidity greater than 80%. Before applying, homogenize the product well with a spatula. Make the mixture with the catalyst (by weight) of 4 parts of OROMEL 634 (Base) with 1 part of OROCAT 734 (Catalyst). Never add water to the catalyst directly.
Application system	Brush, Roller, Airless Gun
Dilution	Up to 10% with water (the first hand)
Application	1 first hand diluted to 10% with water so that it penetrates well, and 1 - 2 more hands of undiluted finish at 60 - 70 µm.
Drying/curing	Touch dry: 2 – 3 hours Total dry: 7 days The drying time is greatly influenced by the grammage, the type and condition of the support and the environmental conditions.
Repainted	<24 hours
Cleaning	WATER

Recommended system	Primer	Topcoat
Cement, concrete	OROMEL 634	OROMEL 634
Steel	OROLUX 210 OROPRIMER 485	OROMEL 624

Additional information	
Security	Consult package labeling. For more information request the Safety Sheet.
Storage time	1 year

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