

## E 4310

### Product Description

Two-component acrylic-urethane enamel, with excellent durability and long recoating term.

### Use

Decorative protection of metal surfaces, exploited outside and inside (in transport and construction sphere, for surfaces, operated in aggressive environments as part of approved systems according to ISO 12944).

### Properties

Excellent resistance to weathering, temperature changes, salts, alkaline corrosion, marine environment, spraying with oil compounds, lubricants.

### Colours

RAL

Gloss level: Gloss/Semi gloss/Mat

### Technical properties

| Technical properties | Test method            | Values                      |
|----------------------|------------------------|-----------------------------|
| Solid content        | SR ISO 3251/2003       | min 38%                     |
| Density              | BNS EN ISO 2811-1      | 0,990 ±1,2g/cm <sup>3</sup> |
| Flash point          | ISO 2719:2016          | 27°C                        |
| VOC values           | BNS EN ISO11890-1:2008 | 400g/l                      |

### Recommended thickness of layer

|                       |                                                                            |
|-----------------------|----------------------------------------------------------------------------|
| Dry film              | 30-40µm                                                                    |
| Wet film              | 65-80µm                                                                    |
| Theoretic consumption | 130-140g/m <sup>2</sup> , depending on the required thickness of dry film. |

### Substrates & Surface preparation

To achieve maximum adhesion and durability of the system, the surface preparation must comply with the following requirements:

| Surface        | Minimum                                                                               | Recommended                                                                              |
|----------------|---------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------|
| Ferrous metals | Rust cleaning with sandblasting or blasting, up to Grade St2, according to ISO 8501-1 | Rust cleaning with sandblasting or blasting, up to Grade Sa 2 ½, according to ISO 8501-1 |
|                | Cleaning, drying and no visible surface injuries according to ISO 12944-4 6.1         |                                                                                          |

### Application equipment and Application Conditions

Machine Equipment, conventional and airless spray ( airless-air assistance)

Ambient temperature from 10 to 30 °C

Humidity of the environment , max 65%

### Information on nozzles and pressure for machine application

Conventional Spray                      nozzle - 1.3mm; pressure - 3-4atm;

### Mixing

by weight                                      100g E4310 is mixed with 20g I 3538N

The prepared mixture is left for pre-reaction for about 30 minutes at 20-23 ° C, Thinner D 4300 is added in a ratio according to the chosen application method.

**Pot life of the mixture:**                      The prepared mixture should be used within 3-4 hours at ( t=20°C ).

### Thinning and cleaning of tools:

Conventional spray - up to 5-15% with Thinner D 4300

### Drying and Curing Schedule

| At temperature | 23°C | 80°C  |
|----------------|------|-------|
| Dust dry       | 1h   |       |
| Touch dry      | 8h   |       |
| Full drying    | 14h  | 30min |

The times mentioned in the above table are measured in a laboratory environment at a controlled temperature and air humidity. Depending on different application environments these values may vary.

### Surface Drying - time necessary for touch dry

Time for application of the second layer is 10-15 minutes (wet to wet) at 20-23°C or after complete drying of the previous layer.

In the case of accelerated drying (80°C), a flash of time of 25-30min is needed

### Product compatibility

Acrodur 4310 can be used in combination with the below listed primers:

- For ferrous metals surfaces - with G 3500, G3733, G3100, G3119AcZn;
- For cold and hot galvanized surfaces - with G 3733, G 3119AcZn+ Epoxy primer with MIOX;

For other types of coatings or special requirements, please contact us.

### Packaging

Metal package 15kg ( 18kg )

Hardener I 3538N 1kg

Second package option refers to tinted product.

Depending on the color of the product and the individual requirement of the customer, the packages may vary.

### Storage

The product should be stored in closed, dry and fire-proof warehouses and premises at a temperature of not more than 30 ° C. Do not expose to direct sunlight. Keep out of reach of children!

### Shelf life:

12 months from production date in factory-sealed package.

### Safety

According to safety data sheet (MSDS).





### Curing Schedule

|                     |       |       |         |
|---------------------|-------|-------|---------|
| Ambient Temperature | 5°C   | 10°C  | 23°C    |
| Dry to Handle       | > 8 h | > 5 h | 1,5-2 h |
| Fully dried         |       |       | 24 h    |

The times mentioned in the above table are measured in a laboratory environment at a controlled temperature and air humidity. Depending on different application environments these values may vary.

**Dry to Handle** - time necessary for touch dry

Full mechanical properties are achieved within 7 days after application of the coating.

Application of the second layer or finish coating is recommended to be done after 24 hours.

### Product compatability

Depending on the specific need and the expected result, this product can be used in a system with different finish coatings e.g. G 3500 + E4310 ; G3500+V3100+E3100; G3500+Epoxy with Miox+E4310.

For other types of coatings or special requirements, please contact us.

### Packaging

|                 | net weight | volume |
|-----------------|------------|--------|
| Metal package   | 26kg       |        |
| Hardener I 3500 | 4,4kg      |        |

Depending on the color of the product and the individual requirement of the customer, the packages may vary.

### Storage

The product should be stored in closed, dry and fire-proof warehouses and premises at a temperature of not more than 30 ° C. Do not expose to direct sunlight. Keep out of reach of children!

### Shelf life:

12 months from production date in factory-sealed package.

### Safety

According to safety data sheet (MSDS).



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## V 3102 2K EPOXY COATING 2/1

### Product Description

Two-component high solid epoxy primer/finish designed for direct application on metal surfaces. Contains zinc-phosphate anti-corrosive pigments, providing long term protection and excellent durability in a high aggressive environment.

### Use

For corrosion protection of both new and repaired old metal surfaces. Protecting of metal structures, railings, fences, reservoirs and other suitable for use indoor and outdoor. V 3102 provide anti-corrosive protection, and good abrasion resistance.

### Properties

Anti-corrosion protection  
Quick drying  
Long recoatability term

### Color

RAL  
Gloss level: Semy matt(15-20GU)

### Technical properties

| Technical properties      | Test method       | Values               |
|---------------------------|-------------------|----------------------|
| Solid content(volume) A+B |                   | 66%                  |
| Density A+B               | BNS EN ISO 2811-1 | 1.5g/cm <sup>3</sup> |

### Recommended thickness of layer

|                         |                                                    |
|-------------------------|----------------------------------------------------|
| Dry film                | 80 - 120µm                                         |
| Wet film                | 120 - 180µm                                        |
| Theoretical consumption | 180-270g/m <sup>2</sup> , 5.5-8.3m <sup>2</sup> /l |

Losses during application depend on the type of the coated object, the surface preparation and the equipment used. They must be calculated separately.

**Maximum film thickness per layer 260-280µm WFT, applied with airless**

### Substrates & Surface preparation

To achieve maximum adhesion and durability of the system, the surface preparation must comply with the following requirements:

| Surface               | Minimum                                                                                       | Recommended                                                                              |
|-----------------------|-----------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------|
| <b>Ferrous metals</b> | Rust cleaning with sandblasting or blasting, up to Grade St2, according to ISO 8501-1         | Rust cleaning with sandblasting or blasting, up to Grade Sa 2 ½, according to ISO 8501-1 |
|                       | Cleaning, drying and no visible surface injuries according to ISO 12944-4, ISO 8501, ISO 8504 |                                                                                          |

Ensure surfaces to be coated are clean, dry and free from all surface contamination.

### Application equipment and Application Conditions

Conventional Spray; Airless spray  
Ambient temperature from 10 to 30°C  
Humidity of the environment , max 65%  
Substrate temperature must be at least 3°C above the dew point

### Information on nozzles and pressure for machine application

Conventional Spray      nozzle - 1.8-2.2mm; pressure - 3-4atm;  
Airless                      nozzle - 0.013-0.015; pressure - 180-200bar;

### Mixing

by weight                    1000g V 3102 is mixed with 170g hardener I 3102  
by volume                    4 parts V 3102 to 1 part Hardener I 3102

**Pot life of the mixture:**                    The prepared mixture should be used within 2 hours at ( t=20°C).

### Thinning and cleaning of tools:

Air spraying -                    8-15% with Thinner D 309 NEW  
Airless -                            0-6% with Thinner D 309 NEW

### Curing Schedule

|                     |         |
|---------------------|---------|
| Ambient Temperature | 23°C    |
| Touch dry           | 1,5-2 h |
| Handle dry          | 8 h     |
| Fully dried         | 24 h    |

The times mentioned in the above table are measured in a laboratory environment at a controlled temperature and air humidity. Depending on different application environments these values may vary.

### Product compatability

V 3102 is normally applied directly to blast cleaned steel, however, it can also be applied directly over G 3733 or G 3500 Epoxy primers.

For other types of coatings or special requirements, please contact Policolor-Orgachim technical team.

### Packaging

|                 | net weight | volume |
|-----------------|------------|--------|
| Metal package   | 22kg       |        |
| Hardener I 3102 | 4kg        |        |

Depending on the color of the product and the individual requirement of the customer, the packages may vary.

### Storage

The product should be stored in closed, dry and fire-proof warehouses and premises at a temperature of not more than 30 ° C. Do not expose to direct sunlight. Keep out of reach of children!

### Shelf life:

12 months from production date in factory-sealed package.

### Safety

According to safety data sheet (MSDS).

This Technical Data Sheet is intended to inform Customers of the product concerned. Policolor-Orgachim invites customers to check the quality of the product and carry out trial application before use, to use the product properly, to comply with the application conditions in accordance with the label instructions and technical parameters. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the Technical Data Sheet for this product. Due to the lack of control over the conditions and manner of application, the manufacturer does not guarantee (without prior written confirmation) its durability or any direct or indirect consequential damages caused or related to the way the product is used or laid, in case the product is used for purposes other than the purpose indicated on the label and in this technical data sheet; We guarantee the properties and qualities of the product insofar as this product is not exposed to external factors and impacts that could not be foreseen by us and could not be taken into account in the preparation of this Technical Data Sheet. Policolor-Orgachim will not accept any liability in the above cases unless consent has been given explicitly. Liability is imposed by legal provisions or arising from commercial obligations. As the information contained in this Technical Data Sheet is subject to periodic changes, please make sure, via our web sites or technical team, that this description is the latest and has not been replaced by a new version.

