



## TECHNICAL DATA SHEET - IRATHANE 255EP

Revised: 05/2018

### PRODUCT 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.

### 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.

### 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.

### PACKAGE SIZE

4.0L  
0.75L

### PRODUCT DATA

PHYSICAL PROPERTIES	
COLOUR	Resin (P) is Clear Hardener (C) is Grey Mixed product is Grey
MIX RATIO BY VOLUME	1.13 : 1
MIX RATIO BY WEIGHT	1.30 : 1
% SOLIDS BY VOLUME	65%
POT LIFE AT 15°C (Mins)	120 minutes
POT LIFE AT 25°C (Mins)	100 minutes
POT LIFE AT 35°C (Mins)	40 minutes
WET FILM BUILD (mm)	As required (maximum per coat 15mm)

PERFORMANCE PROPERTIES	
TENSILE STRENGTH (MPa) BS6903 PART A2	10 – 15 MPa
ELONGATION (%) BS6903 PART A2	300 - 350%
TEMPERATURE RESISTANCE (°C)	Maximum 65
COVERAGE (approximate)	1.6 L/m <sup>2</sup> /mm dft
CURED HARDNESS (SHORE A) BS6903 PART A57	83-85

**APPLICATION INFORMATION**
**SURFACE PREPARATION**

Proper surface preparation is essential to achieve the full potential of the system. Consult the relevant method statement for the application / substrate in question.

Product should only be applied in conditions where the Temperature is >3°C above the dew point and Relative Humidity is <85%.

**MIXING**

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.

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.

**DO NOT BREAK DOWN KITS.**
**APPLICATION**

Product should be applied by trowel to both horizontal and vertical surfaces.

Review the appropriate method statement for detailed application instruction.

**CURE**

Cure times are quoted in the table below.

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**

All equipment should be thoroughly cleaned directly after use using MEK or suitable alternative where possible.

**SHELF LIFE & STORAGE**

A shelf life of 12 months from date of shipment can be expected when stored at room temperature (22°C) in their original containers.

**PRECAUTIONS**

For complete safety and handling information, please refer to Material Safety Data Sheets prior to using this product.

**WARRANTY**

ITW Performance Polymers 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.

**DISCLAIMER**

All information on this data sheet is based on laboratory testing and is not intended for design purposes. ITW Performance Polymers makes no representations or warranties of any kind concerning this data.

For further product information or technical assistance please call +353 61 771 500.