

TECHNICAL BULLETIN

Imperia Durakoat

PRODUCT DESCRIPTION:

It is a high clarity two component clear system specially designed for Moulding & Casting on suitable framework. The only available version is a clear coat.

PERFORMANCE BENEFITS:

- A specially designed Epoxy clear having finest clarity.
- It can be moulded/ casted up to 1.2 cm in depth in one step, also can be applied by conventional spray application.
- It is a VOC free (very low) product.
- Compatible with Imperia gold tinter as well as Berger wood keeper wood stains.
- No added lead, mercury and chromium.

RECOMMENDED USE:

Applicable for finishing of furniture, mould, table top, wooden crafts, non-porous plywood etc.

TECHNICAL DATA (TYPICAL INDICATIVE VALUES)

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|--|--|
| Product | Imperia Durakoat |
| Specific Gravity, gm/Lt | 1.14 ± 0.03 |
| Minimum Overcoat Interval | Over night |
| Shelf Life for base in months for the originally packed tightly closed condition maintained below 25°C | 24 |
| Shelf Life for hardener in months for the originally packed tightly closed condition maintained below 25°C | 24 (Hardener may turned slight yellow & may impart on final colour of the casting if inert nitrogen blanket removed or not maintained) |

PRODUCT DESCRIPTION & PRODUCT CODE

| Product Description | Product code | Base: Hardener (By Volume) |
|---------------------------|--------------|----------------------------|
| Imperia Durakoat Base | 0H0001 | 5:2 |
| Imperia Durakoat Hardener | 0H0KB3 | |

RECOMMENDED APPLICATION:

Sand the seasoned wooden surface using emery paper (180) along the grains. Repeat the sanding smoothly with finer grade of emery paper (220/320) and then wipe off the loose dust particles.

Apply the coatings as follows:

| Product | Application Method | Thinner | Application Viscosity (Secs) | Recoating Period (hrs) |
|---|-------------------------|---------|------------------------------|---|
| 345991+345KB3 (Imperia Epoxy Block Primer) | Spray/Cloth Application | NA | 14-17 Secs | 2-3 Hrs. (should not exceed 24 hrs.) |

TOPCOAT:

| Product | Application method | No. of coats | Recoating Period (hrs) |
|---|--------------------|---|------------------------|
| Imperia Durakoat Base+ Imperia Durakoat Hardener | Moulding/Casting | As per required thickness (Maximum 1.2-1.3 cm casting thickness allowed for each time of casting) | 24 |
| Imperia Epoxy Durakoat Base+ Imperia Epoxy Durakoat Hardener | Spray application | 2 | 48 |

APPLICATION INSTRUCTIONS:

Moulding/Casting application

Step 1: Mix the Imperia Durakoat Base & Hardener in the recommended mixing ratio & stir gently so that undesirable foam generation can be minimized.

Step 2: Keep it for 5 minutes at rest to facilitate the release of air bubble generated due to the stirring.

Step 3: Pour the mixed Imperia Durakoat in the suitable framework by filtering through 220 mesh at maximum pouring thickness upto 1.2-1.3 cm for each time of casting & let it dry for 24 hours. Same Pouring process can be repeated several times depending upon required thickness. For opaque coloured epoxy finish Berger Imperia Gold colorants can be used & for Semi transparent colour Berger Wood Keeper Wood stain can be used.

STEP 3: FOLLOW THE SANDING & POLISHING SCHEDULE BELOW TO GET THE BEST POSSIBLE FINISH.

Step-1: Dry sanding with 220 grit emery using sanding machine

Step-2: Wet sanding with 320 grit emery

Step-3: Wet sanding with 400 grit emery

Step-4: Wet sanding with 600 grit emery

Step-5: Wet sanding with 800 grit emery

Step-6: Wet sanding with 1000 grit emery

Step-7: Wet sanding with 1200 grit emery

Step-8: Wet sanding with 1500 grit emery

Step-9: Wet sanding with 2000 grit emery

Step-10: Buffing with Buffing cream

Step-11: Polish the finish article with suitable polishing cream

NB:

1) For moulding application of Imperia Durakoat desired temperature should be in between 20-35°C to get the best possible finish. Imperia Durakoat should not be applied below 10°C.

2) An air blower can be used to facilitate the release of excess foam generated during handling of the product.

3) If any article or object is placed in the moulded article it must be properly coated with Imperia Durakoat itself separately by brush & spray especially in case of porous substrate or object (e.g. Wood). Otherwise it will lead to bubbling due to the porosity of the placed article.

FOR SPRAY APPLICATION

Step 1: Sand the seasoned wooden surface using emery paper (180) along the grains. Repeat the sanding smoothly with finer grade of emery paper (220/320) and then wipe off the loose dust particles.

Step 2: Apply 2 coats of Imperia epoxy block primer by using lint free cloth or conventional spray application method & Let it dry for 3-4 hour.

Step 3: Apply 2 Coats of Imperia Durakoat by spray application method with minimum 48 hours coating interval & let it dry for 48 hours.

POST APPLICATION INSTRUCTIONS:

The base and hardener should be preserved with tightly closed respective containers and preferably be consumed within one week of its use. During application, masking of the adjoining area to be done in order to avoid the dust. For removing stains and spray dust on adjoining metal and tile surfaces, PU thinner can be used.

STORAGE & HANDLING:

| | | |
|---|-------------|---|
| 1 | Storage | Store in cool and dry place. Keep away from source of ignition. Keep container tightly closed, Keep out of children reach and away from food. |
| 2 | Disposal | Do not pour left over product down the drain or any water course. Dispose in accordance with local regulation. |
| 3 | Flash Point | <150°C |

SAFETY INFORMATION:

| | | |
|---|-------------------|--|
| 1 | Fire hazard Class | Flammable |
| 2 | Safety Precaution | <p>Kindly refer to the MSDS for Berger Imperia Durakoat. Ensure good ventilation during storage, application & drying of product. Wear protective clothes & gloves. Smoking is prohibited while painting. A suitable dust nose pad should be worn when rubbing the surface. Avoid inhaling the vapour.</p> <p>Wear eye protector during application. In case of contact with eyes, rinse immediately with plenty of water.</p> |
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