

OROMEL 644

EPOXY ENAMEL

Catalyzed at 2:1 ratio by volume with **OROCAT 744**

Two-pack enamel based on epoxy polyamide resins. High chemical, grease and oil resistance. Excellent hardness and abrasion resistance. Designed specially for painting steel structures, and machinery It can also be used as finishing for industrial floors... Interior use.

Physical parameters	Base OROMEL 644	Catalyst OROCAT 744
Viscosity (Brookfield sp6 10rpm)	120-180" (Ford coup n° 4)	6000-10000 cPoise (Brookfield sp6 10rpm)
Specific gravity	1,07 – 1,09 g/cc	0.94-0.96 g/cc
Solids content	60-63%	65-67%
In-can appearance	Viscous liquid	Viscous liquid
Stability	12 months at 10 – 25°C	12 months

Characteristics of the mixture	
Mix ratio	2:1 by volume (OROMEL 644 : OROCAT 744)
Viscosity of the mixture	-"
Specific gravity of the mixture	1,05 – 1,08 g/cc
Solids content	65-73%
Colour	White, and tinting machine converters(White and TR colourless base)
Dry film appearance	High gloss finish with good resistance and excellent hiding power
Spreading rate	12 – 15 m ² / L (85 – 105 g/m ²)
Gloss	>90%
Adherence	100%
Persoz Hardness	> 180s
VOC	<500 g/L Directive 2004/42/CE: Limit value (2010) for this product (sub. cat. A/j): 500 g/L
Pot life of mixture	4-5 hours

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Product	Product code	Brand	Author	Date	Version	Replaces	Page	Language
OROMEL 644	06R644XXXZZZ	OROPAL	IRURENA GROUP	03.01.24	1	Any previous version	1/2	EN

Product use information

Surface	Iron, Steel, Cement, Concretet
Surface preparation	Iron must be clean, dry and sandblasted to Sa 2 ½, use OROPRIMER 485 as primer and cement should be dry, clean and dustless and not polished.
Product preparation	Never apply at temperatures below 14°C nor humidity above 75%. Stir thoroughly the contents of the container with a spatula. Make the mixture (by volume) 2 parts of OROMEL 644 (Base) to 1 part of OROCAT 744 (Catalyst)
Application method	Brush, Roller, spray
Dilution	20-30% with ORODIS 718
Application	Apply 1-2 coats of 40 – 50 µm dry film thickness
Drying	Touch drying time: 4 hours Maximum hardness: 7 days (at 20°C and relative humidity of 60%) Drying time is very influenced by the dry film weight, type and state of the substrate and weather conditions.
Recoatable	<24 hours
Cleaning	ORODIS 718

Application process

	Primer	Top coat
Iron, Steel	OROPRIMER 485	OROMEL 644
Cement	OROLUR 388	OROLUR 384

Additional information

Safety	Consult package labelling. For further information, ask for the Material Safety Data Sheet
Storage	1 year

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