

OROMEL 649

FOOD-GRADE EPOXY

Crosslink by mixing 2:0.65 by volume with **OROCAT 749** catalyst

Two-component 100%-solids epoxy enamel. Gloss product, high hardness and chemical strength. Can be easily washed using water and detergents. Especially suitable for painting clinical and food-grade elements, thanks to its solvent-free composition and low migration to oils and wines. Withstands continuous temperatures up to 80°C.

Physical parameters	Base OROMEL 649	Catalyst OROCAT 749
Viscosity (Brookfield sp6 10 rpm)	TIXO	TIXO
Specific weight	1.70 – 1.80 g/ml	1.00 – 1.05 g/cc
Solids	100%	100%
Appearance in the container	Viscous liquid	Viscous liquid
Stability (unopened)	12 months at 10 - 25°C	12 months

Mixing characteristics		
Mixing ratio	2:0.65 by volume (OROMEL 649: OROCAT 749)	
Viscosity of the mixture	-	
Specific weight of the mixture	1.45 – 1.55 g/ml	
Mix solids	100%	
Colour	White, red rust	
Dry film appearance	Gloss finish with high coverage and strength	
Coverage	6 – 8 m ² /l (185 – 265 g/m ²)	
Gloss	>90%	
COV	<<1 g/l	Limit value (2010) according to Directive 2004/42/EC for this product (sub. cat. A/j): 500 g/l
Pot life of the mixture	1 – 2 hours	

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OROMEL 649	06R649XXXZZZ	OROPAL	IRURENA GROUP	03.01.24	1	All of the above	1/2	EN

Using the product

Substrate	Iron, steel, cement
Preparing the substrate	The iron must be clean, dry and degreased to Sa 2½, and the cement must be dry, clean and free of dust
Preparing the product	Do not apply at temperatures below 14°C or humidity above 75%. Use a spatula to mix the product thoroughly before applying. Mix with the catalyst (by volume), 2 parts OROMEL 649 (base) to 0.65 parts OROCAT 749 (catalyst).
How to apply	Brush, roller
Diluting	Not diluted
Application	1 coat of 125 - 175 µm dry Before use: Mix the product and temper it. Do not apply at temperatures below 14°C.
Drying/curing	Touch dry: 7 – 9 hours Maximum hardness: 7 days (at 20°C and 60% relative humidity) Drying time is highly influenced by weight, type and condition of the substrate, and environmental conditions.
Repainting	<24 hours
Cleaning	ORODIS 718

Recommended system

Primer

Finish

Iron, steel		OROMEL 649
Cement		OROMEL 649

Further information

Safety	See package labelling. Ask for the Material Safety Datasheet for more information.
Shelf life	1 year

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