

## DESCRIPTION

Variopox Topcoat XD is a general-purpose epoxy system based on solvent free epoxy resins and modified polyamine adduct hardeners and UV stabilisers.

## PRINCIPAL CHARACTERISTICS

- Suitable as general-purpose epoxy for casting or coating wooden surfaces at increased film thickness such as tabletops;
- Low yellowing;
- Good resistance to various household chemicals;
- Good resistance to immersion in (salt) water;
- Suitable for coating EPS foam;
- May be recoated with Double Coat, Double Coat Dubbel UV or Double Coat Karaat.

## COLOURS AND GLOSS

Transparent - High gloss

## BASIC PROPERTIES (AT 23 °C AND 50% R.H.)

|                        |  |
|------------------------|--|
| Density                | : approx. 1,1 g/cm <sup>3</sup> (mixed product)  |
| Solid content          | : approx. 100 % (volume)   |
| Recommended d.f.t.     | : 0,2 – 5,0 mm, depending on application, see additional information                             |
| Dust dry after         | : approx. 4 hours  |
| Full cure after        | : approx. 5 days, see additional information   |
| Recoating interval     | : min. 24 hours, see additional information<br>max. unlimited, provided clean and dry and sanded |
| Shelf life             | : separate components, stored cool and dry in original packaging, minimum 12 months              |
| Flash point (DIN53213) | : base component >100 °C<br>hardener 112 °C  |

## SPREADING RATE

Depending on application : approx. 0,2 - 4,0 m<sup>2</sup>/kg (approx. 0,3 – 3,6 m<sup>2</sup>/l)  
The practical spreading rate depends on a number of variables, such as: shape and size of object to be painted, the condition and profile of the substrate, the method of application, climatologic conditions and skill of labour.

## SUBSTRATE CONDITION AND TEMPERATURE

|                |   |
|----------------|---|
| Wood           | : clean and dry, free from any contamination and loose particles, moisture content maximum 12%, pre-treated with Variopox Injection resin and sanded with grit paper P120 and degreased with Double Coat Degreaser; |
| Other surfaces | : clean and dry, in good condition, free from any contamination, old layers of paint and loose particles, sanded with grit paper P120-180;  |

During application and curing a minimum temperature of 15 °C is allowed. The temperature of the substrate should be minimum 3 °C above dew point.

## INSTRUCTIONS FOR USE

Before use, mix base and hardener components thoroughly. Pour the mixture in an empty can and mix again. Let the mixture rest for 5 minutes so that any air bubbles can escape.

Make sure that the surface to be treated is horizontal when Variopox Topcoat XD is cast in a thicker layer. This gives an equal layer thickness. Pour the mixture slowly over the surface and spread it with a spatula or flat brush.

Ensure that the surface is completely free of pores. A pore can lead to an air bubble or pinhole. For this reason, we always recommend a first layer of Variopox Injection Resin. You can remove any air bubbles by gently heating the surface during curing.

Mixing ratio : 67,0 base : 33,0 hardener (by weight)  
 67,0 base : 33,0 hardener (by volume)  
 Do not prepare more material than can be applied within the pot life of the mixture.

Induction time : none at 20 °C  
 Pot life : 30 minutes at 25 °C  
 40 minutes at 20 °C  
 50 minutes at 15 °C  
 The potlife depends on the total volume of the mixture.

Application with:

|                 |  |
|-----------------|--|
|                 | Brush/roller                                     |
| Type thinner    | n.a.   |
| % of thinner    |  |
| Nozzle orifice  | n.a.   |
| Nozzle pressure | n.a.   |
| Cleaning        | Double Coat Brush thinner, Double Coat Degreaser |

**ADDITIONAL INFORMATION**

- Recoating and curing Variopox Topcoat XD:

|  | 15 °C     | 20 °C     | 25 °C     |
|--|-----------|-----------|-----------|
| Minimum, with Variopox Topcoat XD, after sanding with grit paper P120  | 36 hours  | 24 hours  | 24 hours  |
| Minimum, with Double Coat DC008, Double Coat Dubbel UV or Double Coat Karaat, after sanding with grit paper P180                           | 14 days   | 14 days   | 14 days   |
| Maximum, with Variopox Topcoat XD, Double Coat DC008, Double Coat Dubbel UV or Double Coat Karaat, after sanding with grit paper P120-P180 | unlimited | unlimited | unlimited |
| Fully cured after  | 7 days    | 5 days    | 5 days    |

- Recommended film thickness  
 The recommended film thickness is for each layer and depends on the application method. We recommend a film thickness of maximum 5 to 10 mm for each layer. A thicker layer can lead to additional heat development during curing, which can influence the transparency.
- Pot life  
 Do not continue application when the pot life is about to end. As the reaction between base and hardener has progressed, a poor adhesion will be the result.

- Viscosity

| Component                            | Viscosity | Unit  | Method          |
|--------------------------------------|-----------|-------|-----------------|
| Variopox Topcoat XD base             | 900       | mPa.s | DVII+ S2 20 rpm |
| Variopox Topcoat XD hardener         | 220       | mPa.s | DVII+ S2 50 rpm |
| Variopox Topcoat XD set <sup>1</sup> | 560       | mPa.s | DVII+ S2 20 rpm |

<sup>1</sup> Immediately after mixing base with hardener

- Mechanical properties

| Property                | Value | Unit | Test method |
|-------------------------|-------|------|-------------|
| • Tensile strength      | 38.6  | MPa  | ISO 527-3   |
| • Elongation at break   | 7.7   | %    | ISO 527-3   |
| • HDT                   | 42    | °C   | ISO 75-2    |
| • Flexural strength     | 79.4  | MPa  | ISO 178     |
| • Modulus of elasticity | 2830  | MPa  | ISO 178     |
| • HDT                   | 42.7  | °C   | ISO 75-2    |
| • Shore D at 23 °C      | 80    |      |             |
| • Shore D at 50 °C      | 40    |      |             |

Samples prepared according to DIN 53451, 120 x 15 x 10 mm, measured after 7 days curing at 23 °C

- Application at lower temperatures:

Curing at temperatures lower than 15 °C will result in a sticky layer on top of the cured resin. This will negatively affect adhesion of following coatings.

- Outdoor use

Variopox Topcoat XD contains UV stabilisers and will result in a surface which will give less yellowing. The outdoor durability may be extended with the application of several layers of Double Coat DC 008, Double Coat Dubbel UV or Double Coat Karaat. In that case we recommend a recoating interval of at least 14 days between the last coat of Variopox Topcoat XD and the first layer of Double Coat. Sand the last coat of Variopox Topcoat XD with gritpaper P180 followed by degreasing with Double Coat Degreaser.

### SAFETY INFORMATION

See the corresponding Material Safety Data Sheet for detailed instructions on safety, disposal and health.

Date: August '20  
338-99999

*Disclaimer*

*Although the information and recommendations are presented in good faith and believed to be correct at date of issue, De IJssel Coatings B.V. makes no representations as of the completeness or accuracy thereof. In no event De IJssel Coatings B.V. will be responsible for damages of any nature whatsoever resulting from the use of this information.*