

## DESCRIPTION

Variopox Topcoat XD-D 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 when exposed to direct sunlight;
- Good resistance to various household chemicals;
- Good resistance to immersion in (salt) water;
- Slow curing with long potlife;
- May be recoated with Double Coat, Double Coat Dubble 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.	: 10 – 100 mm, depending on application, see additional information
Dust dry after	: approx. 36 hours
Full cure after	: approx. 7 days, see additional information
Recoating interval	: min. 48 hours, see additional information 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 hardener 112 °C

## SPREADING RATE

Depending on application : approx. 0,01 – 0,09 m<sup>2</sup>/kg (approx. 0,01 – 0.10 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-D 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.

Mixing ratio : 71,4 base : 28,6 hardener (by weight)  
68,0 base : 32,0 hardener (by volume)

Induction time : none at 20 °C  
Pot life : 4 hours at 25 °C  
5 hours at 20 °C  
7 hours 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-D:

	15 °C	20 °C	25 °C
Minimum, with Variopox Topcoat XD-D, after sanding with grit paper P120	72 hours	48 hours	48 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-D, Double Coat DC008, Double Coat Dubbel UV or Double Coat Karaat, after sanding with grit paper P120-P180	unlimited	unlimited	unlimited
Fully cured after	9 days	7 days	7 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 10 to 100 mm for each layer. Thick layers are possible without affecting 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-D base	900	mPa.s	DVII+ S2 20 rpm
Variopox Topcoat XD-D hardener	220	mPa.s	DVII+ S2 50 rpm
Variopox Topcoat XD-D set <sup>1</sup>	560	mPa.s	DVII+ S2 20 rpm

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

- 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-D 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-D and the first layer of Double Coat. Sand the last coat of Variopox Topcoat XD-D 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.

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#### *Disclaimer*

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