

Marine Resin Coating Systems

Weber.floor 4765N Epoxy Paint

Semi gloss, coloured 2-component epoxy resin sealer



Mixing ratio	Parts by weight	A : B	=	1 : 5
	Parts by volume	A : B	=	1 : 4.15
Application time	Temperature	15 °C / 59 °F	20 °C / 68 °F	30 °C / 86 °F
	Time	80 minutes	70 minutes	40 minutes
Application temperature		Minimum 15 °C / 59 °F (room- and floor-temperature)		
Curing time (Accessibility)	Temperature	15 °C / 59 °F	20 °C / 68 °F	30 °C / 86 °F
	Time	24 - 36 hrs.	18 - 24 hrs.	14 - 18 hrs.
Curing		2 - 3 days for mechanical load at 20 °C / 68 °F		
		7 days for chemical resistance at 20 °C / 68 °F		
Further coatings		After 18 - 24 hours, but not longer than 48 hours at 20° C / 68 °F		
Consumption		Approx. 0.25 kg/m ² for each layer		
Amount of coats		2 coats		
Coat thickness		0.5 mm when applied in 2 layers		
Packaging		Hobbock-Combi 25 kg		
Colours		Weber Standard Colours – see chart. All RAL colours upon request!		
Shelf life		12 months (originally sealed) – Protect from frost!		

Usage and Properties

WEBER.FLOOR 4765N EPOXY PAINT is a 2-component, water-emulsified, pigmented epoxy resin sealer.

WEBER.FLOOR 4765N EPOXY PAINT is especially suitable as sealer on steel, aluminum, galvanized steel, concrete, cement screed, magnesia, and mastic asphalt, as well as for the reconstruction of older areas, due to its excellent adhesion on different, even older substrates. The product may easily be applied with a roller, offers high coverage, and due to its consistency the product is pleasant to work with and environmentally sound. The application in 2 layers results in a durable and optically appealing sealing coat. The product cures by drying and chemical cross-linking to a durable, robust film with good adhesion.

WEBER.FLOOR 4765N EPOXY PAINT results in a hard and tough, almost abrasion resistant film, physiologically harmless with good resistance to aqueous solutions, diluted acids and bases, as well as motor oil and fuel oil. The water vapour permeability allows the sealing of substrate sensitive to water as well as excessively damp substrate.

WEBER.FLOOR 4765N EPOXY PAINT results in semi gloss surfaces.

The product has been tested in combination with **WEBER.FLOOR 4764 WATER-BASED PRIMER** according to the AgBB testing standards of the DIBt® and classified as low-emission.

Product Features

- environmentally friendly
- convenient application
- low odour
- tested, low emission quality
- water vapour permeable
- excellent adhesion
- consistent surface finish
- excellent covering properties
- results in appealing surfaces

Testing

External test certificates are available:

- Slip resistance grade R10 possible, according to DIN 51130 and BGR 181.
- AgBB-tested and DIBt®-accredited.
- Water vapour permeability, according to DIN EN ISO 7783-2.
- Tested and approved according to **SOLAS MED IMO 2010 FTP Code**.

Note: Please ask for the tested system structure!

Area of Application

- **WEBER.FLOOR 4765N EPOXY PAINT** is used as sealer on steel, aluminum, galvanized steel concrete, cement-, anhydrite-, and mastic asphalt screed and magnesia coatings.
- As sealer on water vapour permeable coatings.
- Sealing and thin coats for interior areas, like e.g. commercially and industrially used areas, lower decks, garages, storage rooms- & corridors etc.
- Re-working on older epoxy resin substrate.
- Vertical areas and walls.

Build-up of Coats

- Grind the substrate and vacuum off thoroughly.
- Apply base coat with the recommended Primer resin, **WEBER.FLOOR 4764 WATER-BASED PRIMER**. Consumption approx. 0.15 kg/m².
- Apply the first sealing coat **WEBER.FLOOR 4765N EPOXY PAINT**, with a nylon roller. Consumption approx. 0.25 kg/m².
- Apply the second sealing coat **WEBER.FLOOR 4765N EPOXY PAINT**, with a nylon roller using criss-cross strokes. Consumption approx. 0.25 kg/m².

Substrate

The substrate to be coated has to be levelled, dry, free of dust, has to have adequate tensile and compressive strength and be free from weakly-bonded components or surfaces. Materials impairing adhesion, such as grease, oil and paint residues must be removed using suitable methods. Please refer to the advice issued by the trade associations, e.g. the current edition of BEB-worksheets KH-0/U and KH-0/S. The surface to be coated should be prepared mechanically. Diamond grinding is especially recommended for sealing coats, resulting in a smooth surface. Cleaning older substrates is necessary before mechanical preparation. When sealing older synthetic resin surfaces test for sufficient adhesion. Conduct a trial if in doubt.

Mixing

Combi-trading units will be supplied in the correctly measured mixing ratio. Component B has sufficient volume for the entire trading unit. Decant component A into the hardener compound. Blend with a slow speed mixer (200 - 400 r/pm) for at least 2 - 3 minutes, for a material that is homogeneous and free of streaks. If water will be added mix components A + B completely first. Then add water and homogenize once again completely. To avoid mixing errors, it is recommended to empty the resin/hardener-mixture into a clean container and mix briefly once again. Stir up the single components for partial withdrawals and weigh for the exact mixing ratio.

Processing time max. 70 minutes at 20 °C / 68 °F (see chart "Processing time").

Note: End of pot-life is not visible!

Application / Handling

As with all reactive resins the mixture should be processed immediately. Apply with a lint-free velour-sealing-roller and stripping grate. Divide working areas before starting work to avoid multiple applications and shoulders. It is recommended that larger areas will be processed by at least 2 people. One or more workers should apply the material in one direction and another person distributes the fresh sealing material crossways (in a 90°-angle). A 50 cm wide roller should be used on larger areas. The roller for distribution should be soaked with the material and should only be used for distribution, never for the application of the sealer. Always work „fresh-in-fresh“ and ensure an optimum distribution. Avoid ponding due to possible blooming.

Floor- and air-temperature must not fall below 15 °C / 59 °F and/or humidity must not exceed 75 %. The difference in floor- and room-temperature must be less than 3 °C/ 37.4 °F so the curing will not be disturbed. If a dew-point situation occurs adhesion may malfunction, curing may be disturbed, and spotting may occur. Exposure to water has to be avoided for the first 7 days. Curing time applies to 20 °C / 68 °F. Lower temperature may increase, higher temperature may decrease the curing and processing time. If working conditions are not complied with, deviations in the described properties may occur in the end product.

Cleaning

To clean tools and fresh contamination use water immediately. Hardened material can only be removed mechanically.

Claning and maintenance of sealed coatings

For cleaning note the recommendations for care and maintenance. For the warranty of interlayer adhesion do not apply any care products on aqueous sealers within the first 7 days (20 °C / 68 °F).

In special cases, especially with vibrant colours, the cleaning might cause a loss of colour. This can be avoided by laying an additional transparent sealing, **WEBER.FLOOR 4763N EPOXY MATT SEALER**. If necessary, ask for a consultancy.

Storage

Store in dry and at frost-free conditions. Ideal storage temperature is between 10 - 20 °C / 50 - 68 °F. Bring to a suitable working temperature before application. Tightly re-seal opened containers and use the content as soon as possible.

Special Remarks

The product is subject to the hazardous material-, operational safety-, and transport-regulations for hazardous goods. Refer to the DIN-Safety Data Sheet and the information labelled on the containers!

GISCODE: RE 1

Indication of VOC-Content:

(EG-Regulation 2004/42)

Maximum Permissible Value 140 g/l (2010,II,j/wb):

Ready-for-use product contains < 140 g/l VOC.

Technical Data*

Viscosity	Components A + B	Approx. 1000	mPas	DIN EN ISO 3219 (23 °C / 73.4 °F)
Solid content		> 63	%	Weber-Method
Flashpoint		Not flammable		DIN 51755
Density	Components A + B	1.32	kg/l	DIN EN ISO 2811-2 (20 °C / 68 °F)
Abrasion (Taber Abraser)		< 70	mg	ASTM D4060
Diffusion resistance factor		3100 -	-	DIN EN ISO 12572
Diffusion equiv. air layer thickness sd (0.5 mm)		1.6	m	DIN EN ISO 7783-2
Brightness (85°)		20 - 30	-	DIN 67530

(* Values achieved in sampling are average values. Variation in product specification is possible.)

VOC-Contents

The product complies with the high requirements to low VOC-contents, as required for sustainable construction. Therefore these values exceed by far the European Union directive 2004/42/EG (decopaint-directive).

	Reference to*	Max. Value	Actual Content	
Directive 2004/42/EG	Component A	≤ 140	0	g/l
Decopaint-directive	Component B	≤ 140	1	g/l
DGNB German Sustainable Building Council	Components A + B	< 3	0.9	%
climate:active Climate protection initiative of the Austrian Federal Ministry of Agriculture, Forestry, Environment and Water	Components A + B	< 3	0.9	%
LEED Leadership in Energy and Environmental Design	Components A + B	< 100	11	g/l
Minergie Eco® Quality standard of the "Minergie society", Switzerland	Components A + B	< 1 (< 2)	0.9	%

(* According to the decopaint-directive single components are used for the calculation. For the quality rating system for sustainable construction the mixture of both components in the correct mixing ratio is the determining factor.)



All stated information is based on our previous experience and composition. It is not possible to consider every single case. Please seek advice for your special cases. We guarantee the correct and proper quality of our products. We do not assume responsibility for the work not carried out by us since we have no influence on the processing or processing conditions. We recommend that on-site-trials will be conducted. Our "General Terms and Conditions" apply. With appearance of this new data sheet all prior information loses validity.