

## Munkadur® Classic – Technical Data

Chemical Basis:	Epoxy Resins	(2-components)
Specific Weight:	base:	1.47 kg/ltr.
	hardener:	1.82 kg/ltr.
	mixture:	1.63 kg/ltr.
Hardness:	218 N/mm <sup>2</sup> or >90 to Buchholz	
Heat Conductivity:	0.25 kcal/m/h/°C or 2.9 W/cm x K at 10 °C	
Adhesive Strength:	24 N/mm <sup>2</sup>	
Pot Life:	20 minutes at 18 °C depending on the volume (exothermic reaction)	
Drying Time:	24 hours at 18 °C	
Mechanical Loading:	after 48 hours at 18 °C	
Full Curing Time:	8 days at 18 °C	
Mixing Ratio:	1 : 1 (by weight) 1,25 : 1 (by volume)	
Application:	one coat (hot airless spraying) no primer Temp. base: 80 °C Temp. hardener: 70 °C Temp. vessel: > 15 °C Rel. humidity: max. 80 %	
Thickness:	average 500 – 700 µm	
Pre-Treatment:	shotblasting to SA 3, surface roughness 40 – 80 µm	
Temperature Resistance:	40 °C water, higher temp. by testing	
Surface Roughness of Munkadur in Rz/Ra:	0.5 – 1 µm / 0.07 – 0.15 µm	
Chemical Resistance:	see separate compatibility list	
Consumption:	approx. 1.5 kg/qm (depending on size of the tank as well as the ambient temperature)	