

Munkadur® TW Bfree - Technical Data

Chemical Base:	Epoxy Resins	(2-components)
Specific Weight:	base:	1.229 kg/ltr.
	hardener:	1.524 kg/ltr.
	mixture:	1.361 kg/ltr.
Colour:	base:	blue
	hardener:	blue white
	mixture:	light blue
Pot Life:	approx. 40 minutes at 18 °C (depending on the volume and temperature)	
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: 60 °C Temp. hardener: 70 °C Temp. vessel: min. 10 °C Rel. humidity: max. 80 %	
Thickness:	Ø: approx. 550 µm	
Pre-Treatment:	shotblasting according to SA 2 ½ - 3, surface roughness in Rz: > 40 µm	
Also manually cold applicable:	yes, at min. 18 °C (repairing areas)	
Temperature Resistance:	40 °C water, higher temp. by testing ΔT max. 20 °C	
Surface Roughness of Munkadur in Rz/Ra:	1.5 - 2 µm / 0.2 - 0.3 µm	
Consumption:	approx. 1.2 kg/m ² (depending on size of the tank as well as the ambient temperature)	