



# DENSOLID®-FK2 C

**Caution**

- Sharp shot must be used in the blasting process for rust removal (see below).
- The DENSOLID® coating must be applied immediately but **no later than two hours** after surface preparation.
- Do not use jellied material.

**Cartridge Handling**

- Unscrew cartridge plugs and attach the enclosed static mixer.
- Depending on the desired output quantity, cut off the tip of the cartridge up to the mixing helix.
- Insert cartridge into the discharging device (DENSOMIX®) so that it clicks into place.

**Material discharge before each coating**

- Discard the initial flow (approx. 5 ml) until evenly mixed material comes out.
- Discard mixers containing already jellied or hardened material, e.g. after breaks, and attach a new static mixer.

**Curing, inspection**

- The curing time for coating is dependent on temperature (see table).
- Coatings are to be protected against humidity and rainfall until they have become fully non-stick.
- Keep the material temperature at  $>+5^{\circ}\text{C}$  ( $+41^{\circ}\text{F}$ ) during curing.
- Finished coating must be checked for porosity. Test voltage is 8 kV per mm of coating thickness, up to a maximum of 20 kV (DIN EN 10290)

**1. Coating**

- Prior to coating, activate factory coating by briefly touching with a propane gas flame.
- DENSOLID®-FK2 (grey and black) is applied in **two steps**.
- Apply as much DENSOLID®-FK2 C (grey) as possible during pot life to the component to be coated.

**1. Coating**

- Spread applied material with a brush or spatula. Avoid formation of air pockets during this process.

**1. Coating**

- Coating thickness should be no more than 1 mm per layer.
- Cover adjacent factory coating by at least 50 mm.
- The **second layer** of DENSOLID®-FK2 C (black) may be applied as soon as the first layer can no longer be shifted (see table).

**2. Coating**

- It is not necessary to roughen previous coatings if the delay between work cycles is **under eight hours (20 °C)**.
- Prior to coating, ensure that the surface is clean, dry, and free of dust and grease.
- Apply as much DENSOLID®-FK2 C (black) as possible during pot life to the component to be coated.

**2. Coating**

- Spread applied material with a brush or spatula. Avoid formation of air pockets during this process.

**2. Coating**

- Coating thickness should be no more than 1 mm per layer.
- The second layer of DENSOLID®-FK2 C (black) must overlap the first (grey) by at least 10 mm. Stay on the prepared surface area of the factory coating.
- For more than two layers, repeat the process while alternating colors.
- Total coating thickness shall be at least 1.5 mm.

Product	Processing temperature		Relative air humidity (%)	Timings at ambient temperature				Storage temperature °C (°F)	Compatible factory coatings
	Surface °C (°F)	Material °C (°F)		Times	+5 °C (+41 °F)	+20 °C (+68 °F)	+40 °C (+104 °F)		
DENSOLID®-FK2 C	+10 to +50 (+50 to +122) and min. -3 (+5) above dew point	+15 to +30 (+59 to +86) and min. +3 (+5) above dew point	< 80	Pot life	5 min	4 min	3 min	+15 to +30 (+59 to +86) store upright	PE, PP, PU, FBE
				Paintable	30 min	15 min	10 min		
				Non-stick	60 min	30 min	25 min		
				Full cure	24 h	8 h	7 h		
<b>Surface preparation</b>	Remove loose factory coating, even out notches and indentations, and chamfer corners to an angle of $<30^{\circ}$ . Scrub adjacent factory coatings for at least 100 mm in peripheral direction with a #40 abrasive cloth. Surface cleanliness: Blast cleaning min. Sa 2½ (ISO 8501-1); surface roughness 40 µm to 100 µm; dry, and free of grease, dust, etc.								
<b>Safety &amp; environmental protection</b>	General and local environmental and safety standards must be adhered to during installation. Environmental and safety notes on labels and safety data sheets must be followed. Please wear personal protective equipment like safety glasses, safety gloves and fastened work garments must be worn.								