



TECHNICAL DATA

Revised Date: 06/2009
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FLEXSHIELD 4484 EPOXY

Product Description

A high viscosity, amido-amine cured, two component epoxy. Formulated to provide increased tolerance to marginally prepared substrates. Easily applied by airless spray or brush.

Features

- Surface tolerant
- Easily applied using airless spray or brush

Recommended Uses

- As a surface tolerant epoxy for use with a wide range of topcoats or as a two to three coat stand alone system.

Typical Properties

Solids by Volume	86% ± 1
Volatile Organic Compounds	<1.5 lb/gal (<181 g/l)
Theoretical Coverage	1396 ft ² /gal @ 1 mil
Recommend DFT per	8 mils
Number of Coats	1
Mix Ratio (by volume)	1 : 4
Shelf Life @ 60-90°F (16-32°C)	Part A 12 months Part B 12 months
Temperature Resistance	180°F (dry)
Color	Call

Ordering Information

Packaging:	5 gal kits
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APPLICATION INFORMATION

FLEXSHIELD 4484

Surface Preparation

Remove all oil, grease or other contaminants from the surface to be coated in accordance with SSPC-SP 1.

Steel: For mild environments Hand Tool or Power Tool clean in accordance with SSPC-SP 2 or SSPC-SP 3 to produce a rust scale free surface

For more severe environments, abrasive blast to a Commercial Finish in accordance with SSPC-SP 6 and obtain a 1 to 2 mil anchor pattern.

Previously Painted: Apply to tightly adhering existing coatings that have been lightly sanded or abraded to dull any gloss and roughen the surface.

Mixing

Power mix Component A and Component B separately then combine at a 1 "A" to 4 "B" ratio and power mix to a smooth consistency

It is strongly recommended that only full kits be mixed.

Thinning

DO NOT THIN

Pot Life

Material Temperature	Time
75°F (24°C)	4 hours

Application Conditions

	Normal	Minimum	Maximum
Material	75-90°F (24-32°C)	65°F (18°C)	100°F (38°C)
Surface	75-90°F (24-32°C)	45°F (7°C)	110°F (43°C)
Ambient	75-90°F (24-32°C)	45°F (7°C)	110°F (43°C)
Humidity	30-50%	0%	85%

Surface temperature must be 5°F (3°C) above the dew point.

Application Equipment

Airless:

Pump Ratio	56:1 min	Tip Size	.025 - .031"
Material Hose	3/8" ID min 100' max	Tip Pressure psi	2500 - 3000

Roller: Short to medium nap with phenolic core.

Use MEK or similar solvent for clean up.

Cure Time

These times are based on a 30-50% RH. Excessive film thickness, cooler temperatures or inadequate ventilation will require longer cure times and could result in premature failure.

Surface Temperature

	75°F
Recoat (min)	Tack Free
Recoat (max)	30 days
Full cure	14 days

- If the material has exceeded its maximum recoat time or full cure time contact ITW Futura Coatings for recommended recoating procedures.
- May chalk in sunlight and atmospheric exposures. Remove all chalk prior to recoating.

Safety Information

- Read the Material Safety Data Sheet (MSDS) and container labels for detailed health and safety information.
- Do not apply material in enclosed areas without adequate air exchange and ventilation.
- All application personnel must use respirators rated for organic vapors, or in confined spaces wear fresh air respirators or fresh air hoods.
- Wear protective clothing, gloves and eye protection.
- Breathing fumes or contact with the skin may cause severe allergic reactions.
- **This product is intended for industrial use by properly trained professional applicators only.**

Storage Conditions

- Coatings need to be protected from moisture contamination. Store drums and pails in a dry location at 55-90°F (13-32°C).
- Materials **must** be kept above 55°F (13°C).

ITW FUTURA COATINGS, 1685 GALT INDUSTRIAL BLVD., ST LOUIS, MO, (314) 733-1110

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