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**INVIRApoxy**

**DESCRIPTION:** A high quality, low VOC polyamide epoxy formulated for interior use with electrostatic hand guns. **INVIRApoxy** is unequalled for a combination of adhesion, toughness and chemical resistance. Specially formulated for projects that demand low V.O.C. coatings. Contact you local air quality authorities for restrictions.

**USES:** **INVIRApoxy** is the preferred finish for metal office furniture, partitions, school lockers and machinery of all kinds. It is also an excellent finish for most plastics, formica, prepared porcelain, concrete floors, wood and fiberglass. For electrostatic application to non-metal surfaces, consult your Perfection Electrostatic Paint representative or distributor.

**APPLICATION:** **INVIRApoxy** is specially formulated to spray without adjustment with the Ransburg #2 handgun. Application by other types of electrostatic equipment requires only a slight viscosity adjustment. The electrical conductivity (polarity) of the product is factory adjusted.

**SURFACE PREPARATION AND LIMITATIONS:** It is imperative that all surfaces be properly prepared in order to achieve the adhesion and performance that this product is designed to give. Always follow proper cleaning procedures. Be sure to observe and follow the mixing instructions and induction period (**30 minute induction time**) as outlined on the can label. Failure to follow these instructions may result in sub-standard performance of this product. Be sure to observe and follow all safety precautions as printed on the label. Polyamide epoxies are not formulated for exterior use. While the integrity of the film will remain, loss of gloss and mild chalking will occur within 6 months.

**APPEARANCE:** High Gloss (90° reading on 60° gloss meter). Semi-Gloss (55°-65° on a 60° gloss meter). Satin (20° reading on a 60° gloss meter).

**COVERAGE:** 350-400 sq. ft. per gallon. To achieve maximum durability 3 wet mils must be applied. Note: All colors are lead-free. Dark and bright colors produce far less hiding power than pastels. Coverage on these colors may be as low as 250 sq. ft. per gallon.

**DRY TIMES:** At 70° - To touch – 1 hours. To handle – usually not less than 4 hours. To recoat – not less than 4 hours for full coat. If first pass is only a “tack coat” then full coat may be applied in 15-30 minutes. If recoated after 24 hours, sanding is required to assure intercoat adhesion. Full cure producing a maximum adhesion and durability – 7 days. Pencil hardness is 2H. Bake schedules to full cure - 140°F – 2 hours, 250°F – 30 minutes, 300°F – 10 minutes. Optimum coating temperature for application is 70°- 77°.

**Temperature Restrictions:** Surface of painted part and air temperature must remain over 60°F+ prior to application and for at least 3 hours after coating application.

**FLASH POINT:** 105° F

**MIX RATIO:** 1 part A to 1 part B (catalyst)

**THINNING** (not necessary) Oxsol

**COLORS AVAILABLE:** Full Range

**PRIMER RECOMMENDED:** **INVIRApoxy** can be self-priming on clean, non-rusted metal. Metal primer recommended -- **Universal INVIRaprime**. Priming is necessary for all bare metal surfaces, contact your Perfection representative for all other surfaces.

Type	Gloss	Dry Time				Solids		Coverage	VOC	Thinner	Clean Up
		Recoat	Handle	Force See	Cure 7	Wt	Vol				
Epoxy Polyamide	See Above	Recoat 4 hrs.	Handle 4 Hrs	Force See Above	Cure 7 Days	71.0	51.8	Approx. 375 sq. ft. per gal.	2.8Lbs. Per Gallon or 340 grams per liter Max.	Not necessary	Oxsol

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