

FONDO EPOX 2K HS

1913.

Two-component, anti-corrosion epoxy primer

10/06/21 rev.02

Description and use

Two-pack epoxy-polyamide primer. Universal type anti-corrosion product, based on zinc phosphate, recoatable with most of the surface coatings. To be applied on iron, galvanised steel plate, aluminium, stainless steel, light alloys. The high content of zinc phosphate ensures excellent protection against corrosion and rust; it is recommended for use on structures and artifacts subjected to severe chemical and environmental stresses. **Certified product for anticorrosive cycles according to UNI EN ISO 12944-6.**

Technical data

Colour	:	Ral 7035
Type of product	:	2K with IND X FONDO EPOX 2K HS code 1889
Pot-life	:	2 hours
Dry film appearance	:	matt
Practical cover rate*	:	3 ÷ 4 m ² /kg with per two coats
Storage life	:	24 months in original sealed container.

	Value	Unit	Internal method
Specific gravity	1.40 ÷ 1.44	kg/l	IP PS PC
Viscosity part "A"	6000 ÷ 11000	mPa.s Brookfield rpm 20 s 4	IP VI BK

*The cover rate is calculated on the suggested thickness and applied on plane and regular surfaces.
NB: Data recorded @ 20°C (68°F) and 65% RH.

Application note

- Substrate preparation :
- In case of applications over existing paints make an adhesion test.
 - IRON SURFACES: sand-blasting SA2.5 grade or careful mechanical cleaning followed by solvent degreasing.
 - GALVANIZED STEEL AND STAINLESS STEEL: remove iron scale and foreign matters. Degrease carefully with organic solvents.
 - ALUMINIUM AND LIGHT ALLOYS: mechanical cleaning by sanding followed by solvent degreasing.
- Product preparation :
- Stir thoroughly the component A to even colour and consistency. Then mix with component B in the ratio indicated below; afterwards mix carefully with the quantity of thinner indicated below:**

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	<i>BY WEIGHT</i>	<i>BY VOLUME</i>
PRODUCT 1913 FONDO EPOX 2K HS	100	3
HARDENER 1889 IND X FONDO EPOX 2K HS	20	1
THINNER 1612 DILUENTE EPOX	15 ÷ 20% for traditional spray	

Application method : - air mix spray gun with nozzle \varnothing 1.8 ÷ 2.0 mm and pressure of 3 ÷ 5 bar
- airless spraying

Recommended thickness : 80 ÷ 120 μ m dry film.

<i>DRYING TIME</i>	<i>Dust free</i>	<i>Touch dry</i>	<i>Through drying</i>
Air drying @ 20°C (68°F) - 65% RH	30 ÷ 40 minutes	4 ÷ 5 hours	24 ÷ 36 hours
Oven @ 80÷100°C (176÷212°F)			30 minutes

Maximum chemical resistance : after 7 days

Recoating : From 24 hours to 10 days without sanding with two-component products. After complete film hardening, the surface to be painted must be roughen. At high temperatures the recoating time is considerably reduced.

NOTE: As all this kind of products, high humidity and low temperatures during the paint application can damage the features and the drying of the film.

Do not apply when the temperature is below + 8°C (46.4°F) and the relative humidity exceeds 80%.

Warnings

FOR INDUSTRIAL USE ONLY

Exclusively for use not restricted from Directive 2004/42/EC.

Always read the safety datasheet before use.

Dispose of contents/container in accordance with national regulation.

Information provided in this technical data sheet is based upon our best experience and technical knowledge; it does not absolve the users from carrying out tests and preventive checks in order to verify the suitability for use. For further technical information about specific systems and/or special applications, please contact our TECHNICAL SERVICE.

This note replaces all the previous ones. Please, make sure to have the latest issue. The above mentioned data are meant to facilitate our customers in the use of our products. IMPA is not responsible for applications of products carried out beyond its direct control.

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