

1803 EPOX LUCIDO

GLOSS EPOXY ENAMEL



Industry



Two-component



Spray



Airless

Description and Use

Two-pack epoxy-polyamide coating featuring good elasticity and abrasion resistance.

If outside exposed it will chalk like all epoxy products; this phenomena doesn't affect the resistance features.

Recommended for painting machine-tools, metal furnishings, etc.; suitable to protect surfaces placed in industrial premises (like chemical plants) and in contact with chemical weapons such as solvents, mineral oils, gasoline, diluted acids, sodium hydroxide, ammonia, etc.

It can be coloured using the ADVANCE HT tinting system.

Substrate preparation

IRON SURFACES:

- Sand-blasting SA2.5 grade or careful mechanical cleaning followed by solvent degreasing, then apply a first coat of primer FONDO EPOX code 1806.

GALVANIZED STEEL AND STAINLESS STEEL:

- Remove iron scale and foreign matters. Degrease carefully with organic solvents and apply FONDO EPOX code 1806 before the enamel EPOX LUCIDO.

ALUMINIUM AND LIGHT ALLOYS:

- Chromate or phospho-chromate conversion coating; otherwise, mechanical cleaning by sanding followed by degreasing with a solvent. Then apply the primer as above described.

In case of applications over existing paints make an adhesion test.

Application

Application method:

- air mix spray gun with nozzle \varnothing 1.5-1.7 mm and pressure of 1.5-2.5 bar.
- airless

Product preparation:

Stir thoroughly the Part "A" to achieve even colour and consistency.

Then mix with the Part "B" INDURITORE PER EPOX code 1871 in the ratio of 100:25 by weight.

Dilute with 1612 DILUENTE PER EPOX:

- 15-20% for air mix spray gun
- 0-5% for airless spraying

Storage life

If stored in a cool, dry place, away from sources of heat and sheltered from sunlight, in its sealed original packaging, the product has a shelf life of 24 months. Check the product's shelf life by referring to the production lot shown on the packaging. The lot number comprises of eight numeric characters in which the first four digits identify the year and month of production. Once the product has expired, it must be disposed of in accordance with current legislation.

Technical features

Colour	see price list
Appearance of the dry film	glossy
Gloss	> 90 gloss (Gardner 60°)
Type of product	two component
Pot-life	4 hours
Viscosity **	2000-3000 mPa.s Brookfield rpm 20 s 4
Recommended thicknesses	60 µm dry film
Practical cover rate *	5-6 m ² /kg per two coats
Air drying (20°C and 65% R.H.)	30-40 minuti, dust free
	5-6 hours, touch dry
	24-36 hours, through drying
Oven drying (80-100°C)	30 minutes, through drying
Maximum chemical resistance	after 7 days
AFNOR NF T 36-005 classification	Family I - Category 6b1
* The cover rate is calculated on the suggested thickness and applied on plane and regular surfaces.	
** May change according to the colour.	
The data are measured at a temperature of 20°C.	

Warnings

- Do not apply when the temperature is below + 8°C (47°F) and the relative humidity exceeds 80%.
- Like all this kind of products, high humidity and low temperatures during application can damage the features and drying of the film.
- Do not use this product with tinting pastes 1895 4402 GIALLO S GL and 1895 7258 ROSSO S RL.
- For industrial use only.
- Exclusively for use not restricted from Directive 2004/42/EC.
- Always read the safety datasheet before use.
- For use with aluminium pastes, contact the paint mixing service.
- Dispose of contents / container in accordance with national regulations.
- It is recommended to acquire all the material required to finish the work of the same batch.
- The information provided on this technical datasheet is based on our technical and practical knowledge and experience. The technical data refer to the average characteristics of the basic product and are determined under controlled laboratory conditions. The variability of the raw materials available on the market and the tinting of the product can lead to slight deviations in the declared values, in the colour and in the aesthetic effects obtained. It is therefore necessary for the purchaser/user to personally verify, before application, the suitability of the product for the intended use, in particular when different batch numbers of the same material are used in the same work/site.

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. For further technical information about specific systems and/or special applications, please contact our TECHNICAL SERVICE at assistenza.tecnica@impa.it.