

1806 FONDO EPOX

ANTICORROSION EPOXY PRIMER



Description and Use

Two-component epoxy-polyamide primer, universal type anti-corrosive product based on zinc phosphate, recoatable with most of the surface coatings.

To be applied on iron, zinc-plated steel, aluminium, stainless steel, light alloys.

Product also suitable for nautical and car refinish use.

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.

GALVANIZED STEEL AND STAINLESS STEEL:

- Remove iron scale and foreign matters. Degrease carefully with organic solvents.

ALUMINIUM AND LIGHT ALLOYS:

- Chromate or phospho-chromate conversion coating; otherwise, mechanical cleaning by sanding followed by degreasing with a solvent.

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

Application

Application method:

- air mix spray gun with nozzle Ø 1.5-1.7 mm and pressure of 3-4 bar.
- airless
- roller
- brush

Product preparation:

Stir thoroughly the Part "A" to achieve even colour and consistency. Then mix with component B code 1871 INDURITORE PER EPOX in the following ratio: 100:20.

Dilute with 1612 DILUENTE PER EPOX:

- for air mix spray gun: 15-20%
- for roller and brush: 10%

Recoating:

From 6 to 36 hours without sanding at a temperature of 20°C. After complete film hardening, surface must be slightly rough by sanding. The temperature significantly affects hardening of the film.

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

Color	see price list
Type of product	two component
Pot-life	4 hours
Specific weight **	1.38-1.64 kg/l
Viscosity **	4000-6000 mPa.s Brookfield rpm 20 s 4
Recommended thicknesses	80-120 µm dry film
Practical cover rate *	3-4 m ² /kg (2 layers)
Air drying (20°C and 65% R.H.)	30-40 minuti, dust free
	4-5 hours, dry to touch
	24-36 hours, through drying
Oven drying (80-100°C)	30 minutes, through drying
Maximum chemical resistance	after 7 days
EU limit values for VOC content (Directive 2004/42/EC)	Category B/c, SB: VOC max 540g/l product VOC < 540g/l
* 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%.
- For professional use only.
- Always read the safety datasheet before use.
- Dispose of contents / container in accordance with national regulations.
- Do not use this product with tinting pastes 1895 4402 GIALLO S GL and 1895 7258 ROSSO S RL.
- 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.

Low temperatures and high humidity during application tend to lengthen drying times and have a negative effect on product performance.

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.technica@impa.it.