1806 FONDO EPOX

ANTICORROSION EPOXY PRIMER



MED

UNI EN ISO 12944-6
CERTIFIED FOR ANTI-CORROSION CYCLES

MICROPLASTICS See warnings

advance HT 3.0

Brush

Roller

Spray

Airless

Description and Use

Two-component epoxy-polyamide primer, universal type anti-corrosive product based on zinc phosphate, recoatable with most of the surface coatings.
Product also suitable for nautical and car refinish use. To be applied on iron, zinc-plated steel, aluminium, stainless steel, light alloys.
It can be coloured using the ADVANCE HT tinting system.
This product is part of a paint system in compliance with the fire protection requirements of marine Equipment Directive MED 2014/90/EU including the requirements and testing standards of Regulation (EU) 2024/1975.

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: do not diluite, nozzle Ø 0.011", pressure of 150-180 bar
- roller
- brush

IMPA S.p.A Unipersonale Via Crevada, 9/E 31020 San Pietro di Feletto (TV), Italy Tel. +39 0438 4548 Fax +39 0438 454915
Società soggetta ad attività di direzione e coordinamento di Fassa S.r.l. - info@impa.it - www.impa.it

Application

Product preparation:
Stir thoroughly the Part “A” to achieve even colour and consistency. Then add in the following ratio:

	By weight
PRODUCT 1806 FONDO EPOX	100
HARDENER 1871 INDURITORE PER EPOX	20
THINNER 1612 DILUENTE PER EPOX	spray: 15-20 brush/paint-roller: 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 batch number shown on the packaging. The batch number is made of eight numeric characters in which the first four digits identify the year and month of production. After expiry, the product must be disposed of in accordance with current regulations.

Technical features

Colour	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 m²/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.	

IMPA S.p.A Unipersonale Via Crevada, 9/E 31020 San Pietro di Feletto (TV), Italy Tel. +39 0438 4548 Fax +39 0438 454915
Società soggetta ad attività di direzione e coordinamento di Fassa S.r.l. - info@impa.it - www.impa.it

Warnings

- **The product contains synthetic polymer microparticles (SPM).**
- **INSTRUCTIONS TO PREVENT THE RELEASE OF SYNTHETIC POLYMER MICROPARTICLES INTO THE ENVIRONMENT**
- **In accordance with Regulation (EU) 2023/2055, please follow the procedures below to prevent environmental release.**
- During use and application, avoid accidental release of the product onto soil, into drains, or household wastewater. Apply the product only to the surfaces to be treated.
- Any remaining product should be stored by tightly sealing the original container. Dispose of the product/container in accordance with national regulations.
- If you wish to reuse the tools used for application, follow these steps to clean them in an environmentally responsible manner.
- The water, solvents or thinners used for cleaning tools, as well as any product residues, MUST NOT be released into the environment or poured down domestic drains.
- Remove as much product as possible from the tools used.
- Soak the tools in hot water or in solvent for at least a couple of hours, then remove them from the container.
- Allow the water in the bucket to evaporate and let the tools dry. For solvent-based products, close the container. Do not release the product into the environment and do not pour it into drains.
- Deliver the container with any remaining product / wash water / solvent / cleaning thinner to an authorised waste collection centre, in accordance with national regulations.
- 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.
- 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.tecnica@impa.it.

IMPA S.p.A Unipersonale Via Crevada, 9/E 31020 San Pietro di Feletto (TV), Italy Tel. +39 0438 4548 Fax +39 0438 454915
Società soggetta ad attività di direzione e coordinamento di Fassa S.r.l. - info@impa.it - www.impa.it