

1836 FONDO FINITURA ACRILICO SEMI OPACO DTM

TWO-PACK ANTICORROSION PRIMER-FINISH,
ADHESION TO IRON, GALVANISED STEEL PLATE AND
ALUMINIUM



Industry



Two-component



Spray

Advantages

- semi-matt
- Direct adhesion
- Anticorrosion

Description and Use

Semi-matt base-finish based on acrylic resin and isocyanic adduct.

It is suitable for products in general, iron, galvanized steel, aluminum, PVC, fiberglass, when a good anticorrosive power is to be obtained with a high aesthetic appearance finish and when excellent resistance to the exterior is required.

It has a good solidity at high temperatures (90/100°C) for a continuous service of three hours.

The light colors (pure white) if submitted for long periods at such temperatures, could present a slight yellowing.

It can be coloured using the ADVANCE HT tinting system.

Substrate preparation

IRON SURFACES:

- Remove any trace of rust, iron scale, grease and moisture by sand-blasting SA2.5 grade; otherwise, carry out a careful mechanical cleaning followed by solvent degreasing.

GALVANIZED STEEL:

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

ALUMINIUM:

- Chromatising or phosphochromatising treatment; otherwise, slight matting with sandpaper followed by organic solvent degreasing.

PVC:

- Clean and degrease with DILUENTE ANTISILICONE cod. 1618, then pass a rag soaked with DILUENTE EXTRA PU cod 1611, wait until the surface becomes opaque and then apply FONDO FINITURA ACRILICO SEMI OPACO DTM.

FIBERGLASS:

- Slight matting with sandpaper, then clean and degrease with DILUENTE ANTISILICONE cod. 1618, wait for the surface to dry and then apply the FONDO FINITURA ACRILICO SEMI OPACO DTM.

GLASS:

- The substrate must be perfectly cleaned using suitable products, the surface must be dry and free of chemical residues.

Application

Application method:

- Air spray gun (conventional) with nozzle Ø 1.4-1.6 mm and pressure of 2.0-3.0 bar.
- airless: dilute to 5 %, nozzle Ø 0.009-0.011", exit pressure of the product 140 – 160 bar
- airmix: dilute to 7.5 %, nozzle Ø 0.009", exit pressure of the product 130 – 140 bar, auxiliary air pressure 3.5 –4.0 bar

Product preparation:

Stir thoroughly the product to achieve even colour and consistency. Then add in the following ratio:

	By weight
PRODUCT 1836 FONDOFINITURA ACRILICO SEMI OPACO DTM	100
HARDENER 1873 INDURITORE PER ACRILICI/PU ININGIALLENTE or 1882 INDURITORE PER ACRILICI/PU ININGIALLENTE RAPIDO	15
THINNER 1653 DILUENTE PER ACRILICI or 1611 DILUENTE EXTRA PU or 1624 DILUENTE LENTO UNIVERSALE IND	10-15

Preparation of the product for applications on glass	By weight
PRODUCT 1836 FONDOFINITURA ACRILICO SEMI OPACO DTM	100
HARDENER 1873 INDURITORE PER ACRILICI/PU ININGIALLENTE or 1882 INDURITORE PER ACRILICI/PU ININGIALLENTE RAPIDO	15
ADDITIVE 1901 ADDITIVO AGGRAPPANTE PER VETRO	10
THINNER 1653 DILUENTE PER ACRILICI or 1611 DILUENTE EXTRA PU or 1624 DILUENTE LENTO UNIVERSALE IND	0-5

Recommended thicknesses:

Apply the product in two coats with an interval of 10 minutes between the two coats.

- On ALUMINUM, GALVANIZED SHEET, FIBERGLASS AND PVC apply a wet thickness of about 120 – 150 µm to have a dry thickness of about 50 – 60 µm.
- On IRON SURFACES apply a wet thickness of about 200 µm to have a dry thickness of about 100 – 120 µm.

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 12 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. Once the product has expired, it must be disposed of in accordance with the current legislation.

Technical features

Colour	see price list
Type of product	two component
Pot-life	90 minutes. At higher temperatures, pot life decreases
Specific weight *	1.33-1.59 kg/l
Gloss	35-40 gloss (Gardner 60°)
Application viscosity**	60 - 70 sec. cup FORD 4
Theoretical cover rate * (referred to a dry thickness of about 70 µm)	5 m²/kg (2 coats)
Air drying (20°C and 65% R.H.)	10 minutes, dust-free
	2-3 hours, dry to touch
	24 hours, through drying
Oven drying (60°C)	5-10 minutes, flash off
	60 minutes, through drying
AFNOR NF T 36-005 classification	Family I - Category 7b1
** May change according to the colour.	
* The cover rate is calculated on the suggested thickness and applied on plane and regular surfaces.	
The data are measured at a temperature of 20°C.	

Warnings

- For industrial use only.
- Exclusively for use not restricted from Directive 2004/42/EC.
- Always refer to the safety data sheet for the relevant products.
- 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. The recipient/product/thinner or cleaning solvent must be disposed of 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.technica@impa.it.