1200 ZINCANTE EPOX 2K

TWO-COMPONENT EPOXY ZINC-BASED PRIMER

Advantages

→ Two-component
→ For anticorrosion cycles

Description and Use

Two-component epoxy zinc-based primer with metallic zinc content higher than 80% dry film and polyamide hardener.
Used to protect against long-term corrosion of steel structures located in rural, urban, industrial and marine environments.
Suitable as base primer in high thickness cycles to be coated with primer or epoxy intermediates.

Substrate preparation

All surfaces to be painted must be clean, dry and free from any kind of contamination such as dust, oils and greases. Clean with a suitable solvent.
The application must be made on sandblasted iron to the minimum grade SA 2.5 according to the standard ISO 8501-1: 2007 or SSPC-SP6 with a recommended surface profile of 40-60 microns. Paint as quickly as possible to avoid any form of oxidation of the sandblasted surface.
To avoid condensation, apply to a clean and dry surface with a temperature at least 3°C (37.4°F) above the dew point. The surface temperature must be between 5°C (41°F) and 35°C (95°F).

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

Application method:
- air mix spray gun with nozzle Ø 1.8-2.0 mm and pressure of 3-5 bar
- airless: dilute to 5-10%, nozzle Ø 0.011", pressure of 150-180 bar
- roller
- brush (for small parts or areas that are difficult to reach with spray application)

Product preparation:
Due to the nature of the product, component A requires careful homogenization to achieve even colour and consistency.
Then mix part A with component B code 1888 INDURITORE PER ZINCANTE EPOX 2K using the following ratios.
dilute with 1612 DILUENTE PER EPOX at 20-30%.
It is necessary that the spray application is carried out by taking the material from a container kept under agitation, to prevent the zinc from settling excessively, due to its high specific gravity.
The application must be performed with temperatures between 5°C (41°F) and 35°C (95°F). Temperatures below 5°C (41°F) and high humidity slow down the hardening process.

Components	By weight	By volume
1200 ZINCANTE EPOX 2K	100	3
1888 INDURITORE PER ZINCANTE EPOX 2K	10	1
1612 DILUENTE PER EPOX	20-30%	

Recommended thicknesses:
Apply a minimum dry thickness of 50-70 microns to ensure excellent anticorrosive resistance.
On average, to obtain this thickness it is necessary to apply a wet thickness of about 90-100 microns.
Avoid a thickness greater than 90 µm dry as an excessive thickness will lead to a decrease in product adhesion.

Recoating:
Minimum 12 hours at 20°C (68°F), with no time limit.
However, it is recommended to roughen the surface if the recoating time exceeds 30 days.
Do not recoat with alkyd enamels.

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 in months specified in the table of products with expiry date. 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.

Table of products with expiry date		
Product name	**Code**	**Expiry date in months**
ZINCANTE EPOX 2K	1200	24
INDURITORE PER ZINCANTE EPOX 2K	1888	12

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

Technical features

Colour	dark grey
Type of product	two component
Appearance of the dry film	matt
Pot-life	2 hours
Specific weight	3.19-3.25 kg/l
Viscosity	35000-70000 mPa.s Brookfield rpm 10 s 9
Recommended thicknesses	min. 50-70 µm dry film
Practical cover rate *	2.5-3.5 m²/kg with 50-70 µm dry film
Air drying (20°C - 65% RH)	15-20 minutes, dust free
	1-3 hours, touch dry
	8-12 hours, through drying
Air drying (10°C - 75% RH))	25-30 minutes, dust free
	2-6 hours, touch dry
	15-20 hours, through drying
* 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

- Like all this kind of products, high humidity and low temperatures during application can damage the features and drying of the film.
- Not recommended for use on structures placed in environments with continuous action of both acidic and alkaline chemical agents.
- For industrial use only.
- Exclusively for use not restricted from Directive 2004/42/EC.
- Always read the safety datasheet before use.
- 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 can lead to slight deviations in the declared values. 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.

Do not apply when the temperature is below + 5°C (41°F) and the relative humidity exceeds 80%.

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