

1913 FONDO EPOX 2K HS

TWO-COMPONENT, ANTI-CORROSION EPOXY
PRIMER



Industry



Two-component



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.

To be applied on iron, galvanised steel plate, aluminium, stainless steel, light alloys.

The high content of zinc phosphate ensures excellent protection against corrosion and rust.

It is recommended for use on structures and artifacts subjected to severe chemical and environmental stresses.

Certified product for anticorrosive cycles according to UNI EN ISO 12944-6.

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:

- Mechanical cleaning by sanding, followed by solvent degreasing.

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

Application

Application method:

- air mix spray gun with nozzle Ø 1.8-2.0 mm and pressure of 3-5 bar
- airless: do not dilute, nozzle Ø 0,011", exit pressure of the product 150–180 bar

Product preparation:

Stir thoroughly the Part "A" to achieve even colour and consistency. Due to the high content of solid substances, it is recommended to use a paddle mixer to ensure the product is uniform. Then add in the following ratio: (see Table 1)

Table 1	By weight	By volume
PRODUCT 1913 FONDO EPOX 2K HS	100	3
HARDENER 1889 INDURITORE PER FONDO EPOX 2K HS	20	1

Dilute with 1612 DILUENTE PER EPOX at 15-20% by weight or volume for traditional spray and mix carefully.

Recoating:

From 24 hours to 10 days without sanding with two-component products.

After complete film hardening, the surface to be painted must be roughen.

At high temperatures the recoating time is considerably reduced.

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
FONDO EPOX 2K HS	1913	36
INDURITORE PER FONDO EPOX 2K HS	1889	12

Technical features

Colour	Ral 7035
Type of product	two component
Pot-life	2 hours
Appearance of the dry film	matt
Specific weight	1,40-1,44 kg/l
Viscosity	6000-11000 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
* 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

- 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.
- 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.

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.