

1911 FONDO EPOX BASIC

TWO-COMPONENT EPOXY PRIMER



Industry



Two-component



Spray



Airless

Description and Use

Universal two-component epoxy-polyamide product. Re-coatable with most of the surface coatings.

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

Product preparation:

Stir thoroughly the Part "A" to achieve even colour and consistency. Then mix with component B INDURITORE PER EP BASIC code 1951 in the ratio 100:20 by weight.

Dilute with 1612 DILUENTE PER EPOX by weight at 5-15%.

Recoating:

between 24 and 48 hours from application. After complete film hardening, surface must be slightly rough by sanding.

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.

Technical features

Colour	see price list
Type of product	two component
Appearance of the dry film	matt
Pot-life	3 hours
Specific weight **	1.41-1.61 kg/l
Viscosity **	10000-15000 mPa.s Brookfield rpm 10 s 5
Recommended thicknesses	80-100 µm dry film
Practical cover rate *	3-4 m²/kg (2 layers)
Air drying (20°C and 65% R.H.)	50-60 minuti, dust free
	4-5 hours, dry to touch
	24-36 hours, through drying
Oven drying (80-100°C)	30 minutes, through drying
Recoatible	between 24 and 48 hours
Maximum chemical resistance	after 7 days
* 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.	

Table of products with expiry date

Product name	Code	Expiry date in months
FONDO EPOX BASIC	1911	24
INDURITORE PER EP BASIC	1951	12

Warnings

- **Exclusively for use not restricted from Directive 2004/42/EC.**
- For industrial use only.
- 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.
- Like all this kind of products, high humidity and low temperatures during application can damage the features and drying of the film.
- 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.

Do not apply when the temperature is below + 8°C (47°F) and the relative humidity exceeds 80%.

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.