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Name **BINDER EPOXY PRIMER**  
Definition: **Epoxy primer-intermediate**  
Code: **2I.3.K1**

Category: **B/C**  
V.O.C (ready to use): **540 g/l**  
Product according to 2004/42/CE

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### **Nature of this product:**

Two pack epoxy enamel to be mixed before use. Contains anticorrosive pigments based on zinc phosphate.

### **General Uses**

Universal corrosion-resistant primer-intermediate, recoat able with most painting products.

It can be applied on: iron, aluminum, galvanized sheet, light alloys<sup>1</sup>, cement, concrete, or, as an intermediate, on epoxy or inorganic zinc rich primers or other kinds of primers that need an intermediate prior to top coat application.

## **APPLICATION METHOD**

### **Preparation of Surfaces**

The cleaning of the application surface should be total and painstaking and it is a fundamental and necessary condition to obtain positive result of the painting cycle.

This means that presence of grease, oils, dirt, rust and calamine on the surfaces, is absolutely not allowed.

- **Ferrous surfaces:** SA2 sandblasting or perfect mechanical cleaning of the substrate by sanding to remove rust and calamine, followed by degreasing with surfactants aqueous solutions or solvents.
- **Galvanized sheet:** accurate sanding by using scotch brite coarse grain, then degreasing with solvents.
- **Aluminum:** mechanical cleaning of the substrate by sanding, then degreasing with solvents.
- **Plastics:** By adding the additive 0C.028, the product has good adhesion on various types of plastic supports.<sup>2</sup>
- **Concrete:** the concrete casting should be aged for 4 weeks and it must not have grout formations that must be removed by shot peening.

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<sup>1</sup> Given the variety of alloys on the market, we recommend making preliminary adhesion tests.

<sup>2</sup> Preliminary tests are always recommended to ensure correct adhesion to the support.

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### Preparation of the product

	code	name	By Weight	By Volume
Component A	2I.3.K1(TINTED)	Binder Epoxy Primer	100 parts	100 parts
Component B	0B.120	Hardener Epoxy Standard	20 parts	33 parts
As an alternative	0B.150	Hardener Epoxy Quick	20 parts	33 parts
As an alternative	0B.V50 <sup>3</sup>	Epoxy Vinyl Hardener	20 parts	33 parts

Carefully mix until an even color and consistency are obtained. For airless applications no dilution is requested, for standard air mix application dilute with 0G.006 at 15-20% to obtain a viscosity of 24-30" Ford 4-

### Application<sup>4</sup>

Spray gun: nozzle of 1,4-1,7 mm diameter and 3-5 atm pressure.  
Airless. nozzle 9/20 inches, 180-240 bar  
Electrostatic After using a suitable quantity (at least 20%) of thinner 0G.006  
Brush/roller Only for large surfaces<sup>5</sup>

- <sup>3</sup> With this hardener the system becomes an epoxy-vinyl system, it means epoxy system with vinyl modification. This allows over-coating of the primer even after different weeks from the application with no need of sanding or scratching of the primer.
- <sup>4</sup> Minimum application temperature: higher than +10°C. In high humidity conditions (over 70%), matt-white haze phenomena may occur on the painted surface with slight delay in hardening time. However, this phenomenon does not compromise the typical features of the film.
- <sup>5</sup> You may need Antifoam additive 0C.009 in order to avoid bubble formation whilst using these tools.

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### Technical data

<b>Product Type</b>	Two pack product	
<b>Colors:</b>	By request (the binder 2I.3.K1 has to be used in a ratio 80/20 with the tinting system tinters). We do have also the following ready colors: grey2I.3.70121, 2I.3.R7035 and white 2I.3.90130.	
<b>Film Appearance:</b>	Matt <20 gloss.	
<b>Specific Weight</b> (ISO 2811):	1,51 ± 0,08 g/cm <sup>3</sup> for A component	
<b>Supply Viscosity:</b>	6000-9000 CPs	
<b>Solid on Volume:</b>	A + B 48 % (± 2%)	
<b>Solid Content:</b>	A + B 64 % (± 3%)	
<b>Drying at 20°C</b>	Dust dry:	30-40 minutes
	Touch dry:	4-5 hours
	Total hardening:	26-36 hours
	Forced Drying	30-40 mins at 60°C
	Maximum chemical resistance:	After 7 days
<b>Recommended coats:</b>	Minimum one crossed coat.	
<b>Thickness:</b>	50-60 µm	
<b>Theoretic Yield:</b>	7 m <sup>2</sup> /kg	
<b>Pot-Life at 20°C:</b>	8 hours. At higher temperatures, pot-life decreases (for catalysis with 0B.120, with 0B.150 the pot life is 4 hours).	

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**Repainting:**

With 0B.120: minimum 8 hours, maximum 5 days. With 0B.150, minimum 2 hours, maximum 72 hours (at 20°C, at lower temperatures we recommend longer repainting time). Over this time, we recommend scratching before overpainting. With 0B.V50 minimum 1 hour then the primer can be overpainted even after 1 month without scratching, it has to be clean but not scratched. With this hardener, the primer turns from epoxy primer to epoxy-vinyl primer

**Storage Stability:**

Two years stored in closed pack, in a cool, dry place, away from any sources of heat. One year for A component, 6 months for B component in closed packs, in a cool, dry place, away from any sources of heat.

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