

Name **EPOXY PRIMER HIGH SOLIDS**
Definition: **Epoxy primer**
Code: **2I.5.K1**

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

NATURE OF THE PRODUCT

Two pack epoxy enamel to be mixed before use.

GENERAL USES

HS epoxy primer for general use: it can be overcoated with most of top coats. It can be applied on iron, aluminum, galvanized iron and light alloys¹ surfaces, concrete.

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, followed by degreasing with solvents.
- **Aluminum:** accurate mechanical sanding, followed by degreasing with thinners.
- **Concrete:** the concrete casting should be aged for 4 weeks and it must not have grouts. In case grouts are present, they must be removed by shot peening procedure.

PREPARATION OF THE PRODUCT

	Code	name	By weight	By volume
Component A	2I.5.K1	Epoxy Primer HS	100 parts	100 parts
Component B	0B.003	Activator for Epoxy HS	20 parts	40 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 5-10% to obtain a viscosity of 24"-30" Ford 4.

APPLICATION²

Spray gun: nozzles of 1,4-1,7 mm diameter and 3-5 atm pressure.
Airless: nozzle 0,09 inches, 180-240 bar
Electrostatic gun: suitable
Brush/roller: only for large surfaces³

0 TECHNICAL DATA

PRODUCT TYPE: Two pack product

¹ We recommend carrying out few preliminary adhesion tests, given the variety of alloys on sale.

² Minimum application temperature: above + 10 ° C. In conditions of high atmospheric humidity (over 70%), matt-whitish bloom may appear on the painted surface with a slight delay in the hardening time. However, this phenomenon does not compromise the typical characteristics of the film.

³ You may need Antifoam additive 0C.009 in order to avoid bubble formation whilst using these tools

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APPEARANCE (ASTM D 523):	Semi matt, 35±8 gloss.	
COLOURS:	On request (by using binder 2I.5.K1 in a 80/20 binder/tinter ratio with the tinters of the solvent base tinting system)	
SPECIFIC WEIGHT (iso 2811):	1.90 ± 0.08 g/cm ³ for comp. A	
SUPPLY VISCOSITY:	6500-9500 CPs SOLID	
ON VOLUME:	A + B 50 % (± 2%)	
SOLIDS CONTENT:	A + B 76 % (± 3%)	
DRYING AT 20°C	Dust dry:	30-40 minutes
	Touch dry:	8 hours
	Total hardening:	26-36 hours
	Forced drying:	30-40 minutes at 60°C
	Maximum chemical resistance: After 7 days	
RECOMMENDED COATS:	Minimum one crossed coat	
THICKNESS ⁴:	60-100 µm	
THEORETIC YIELD ⁵:	4-6 m ² /kg	
POT-LIFE AT 20° C:	6 hours. At higher temperatures, pot-life decreases.	
REPAINTING (at 20°C):	Within 36 hours. Over 36 hours we recommend sanding the surface before overcoating it.	
STORAGE STABILITY:	Two years stored in closed packs, in a cool, dry place, away from any sources of heat.	

⁴ Considering a dry film.

⁵ The theoretical yield has been calculated for the thickness suggested and over plane and regular surfaces.

⁶ Generally a product with a resistivity less than 600 kohm is suitable for application with an electrostatic gun.