

Name **BINDER EPOXY SEMIGLOSS STRUCTURED**  
Definition: **Epoxy two pack top coat**  
Code: **2A.6.K1**

Category: **high performances bicomponent paint**

V.O.C. limit : 500 g/l

V.O.C (ready to use): **410 g/l**

Product according to 2004/42/CE

## NATURE OF THE PRODUCT

Two-pack epoxy-amino top coat

## GENERAL USES

Product for general use on steel, zinc plated iron, aluminum, plastics, light alloys<sup>1</sup>. Fit for coats of automatic machine tools and manufacturing machine. Not recommended for external use

## 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.

The product shows direct adhesion on metals<sup>2</sup> without a previous primer application. Because of the big variety of substrates is always better to perform some preliminary tests before.

Eventual suggested primers for this product are: Epoxy Primer serie 2I.3,.

- **Ferrous surfaces.** SA2 1/2 sandblasting or very careful mechanical abrasion followed by degreasing using thinners, then proceed with the direct application of the product or, if preferred with the application of a primer (2I.3) and then the top coat.
- **Aluminum.** Chromate or phosphorous chromate treatment or in alternative sanding procedure followed by degreasing using thinners. Then proceed with the direct application of the product or, if preferred with the application of a primer ( 2I.3) and then the top coat.
- **Galvanized sheet.** Delicate sanding (with scotch brite paper) followed by degreasing using thinners. Then proceed with the direct application of the product or, if preferred with the application of a primer ( 2I.3) and then the top coat.

### PREPARATION OF THE PRODUCT

	code	name	By Weight	By Volume
Component A	2A.6.K1(TINTED)	Epoxy S.G Structured	100 parts	100 parts
Component B	0B.120	Activator Epoxy Standard	20 parts	33 parts
Component B	0B.150	Act. Epoxy Extra Fast	20 parts	33parts

Carefully mix until an even color and consistency are obtained. Normally to obtain a good embossed effect it is suggested to apply a first film of product diluted with 10-15% of our thinner 0G.006 (to obtain a viscosity of 24-26" Ford 4), then within 24 hours apply a film of product not diluted with the apposite spray gun for embossed.

<sup>1</sup> Given the variety of alloys on sale, we recommend carrying out a few preliminary adhesion tests.

<sup>2</sup> If it is necessary to improve the corrosion resistance of the painted artefact, we suggest to apply a primer.

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## **APPLICATION**

Spray gun: nozzles of 1,8-2,2 mm. diameter and 1-2 atm. pressure.  
Airless .

Spry gun  
for  
Embossed: use nozzles of 1.7-2.5 mm diameter and 3-4 atm pressure

Roller or brush: Only for small surfaces

## **TECHNICAL DATA**

**PRODUCT TYPE:** Two pack product

**FILM APPEARANCE**  
(ASTM D 523): semigloss 75±5 gloss

**COLOURS:** By request

**SPECIFIC WEIGHT (ISO 2811):** 1,53 kg/L (± 0,05).  
5000-7000 CPs

**SUPPLY VISCOSITY (DIN 53211):**

**SOLID ON VOLUME:** 50% (± 3%) A+B

**SOLIDS CONTENT:** 73% (± 5%) A+B

<b>DRYING AT 20°C</b>	Dust dry:	30-40'	Touch dry:	5-6 hours
	Total hardening:	36 hours	Forced drying <sup>3</sup>	45' at 60°C

Maximum chemical resistance: After 7 days

**RECOMMENDED COATS:** One diluted coat of product followed, after 2-3 hours, by a not diluted coat with apposite gun for embossed

**THICKNESS<sup>4</sup>:** 70-80 m

**THEORETIC YIELD<sup>5</sup>:** 4-5 m<sup>2</sup>/kg

**POT-LIFE AT 20°C:** 8 hours at temperature of 20°C. At higher temperatures, pot-life decreases.

<sup>3</sup> Baking the product can change the final gloss result, it could result more matt, and also the final color can result more yellow.

<sup>4</sup> Considering a dry film.

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

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**REPAINTING:**

Within 24 hours or, after the complete hardening of the film, it is better a light sanding before overcoating

**STORAGE  
STABILITY:**

Two years in closed packs, in a cool, dry place, away from any sources of heat.