

Epox Smalto

Description

Two-component solventborne epoxy finish, with high hiding and filling power. Excellent adhesion for direct application on iron, galvanized steel, aluminium, stainless steel, light alloys. It forms extremely hard films and gives the substrate onto which it is applied good resistance to abrasion and excellent resistance to chemical attack in industrial environments, to prolonged contact with water, to corrosion and steam. It resists to acids, alkalis, detergents, grease and oils. Exposed outdoors, it will display chalking (typical of these products); that, however, does not impair final resistance properties. Available in glossy or satin version.

Uses

It is employed for painting metal carpentry, machine tools, chemical and thermal installations, industrial machinery, metal furniture, et cetera.

Surface preparation

In order to obtain excellent results, it is of prime importance to accurately clean the substrate.

Iron surfaces: remove any trace of rust, mill scale, grease and humidity by sandblasting (grade SA 2,5), or accurately clean by mechanical means and degrease with solvent, then apply 1-2 coats of EPOX FONDO.

Galvanized steel sheet: carry out phospho-degreasing or alkaline degreasing, or accurately remove any slag and oxidation by sandpapering and subsequent degreasing with organic solvent, then apply 1-2 coats of EPOX FONDO.

Aluminium and light alloys: carry out chromate or phospho-chromate conversion coating or, alternatively, clean the surface by lightly sandpapering and degreasing with organic solvents, then apply 1-2 coats of EPOX FONDO.

Once the surface to be painted has been chemically or mechanically cleaned, do not allow the metal to stay unprotected for longer than 12 hours without applying a temporary protective coating or a coat of anti-rust paint, in order to prevent the formation of oxidation that could impair the lifetime of the top-coats.

Application

Apply 2 coats of product (appropriately diluted) by brush, roller or spray. Before applying, accurately mix the product until uniform colour and consistency are obtained, then pour the content of the hardener and mix until completely blended.

Mix 100 parts (by weight) of BASE (base vehicle + pigment dispersions) with 15 parts (by weight) of INDURENTE EPOX SMALTO.

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Poor mixing and weighing of base and hardener may impair curing and final chemical-physical properties.

Allow the mixture to stand for 5-10 minutes before applying (at very low temperatures, allow few more minutes)

The prepared mixture has a working time of 1-1,5 hours; it is advised not to use the product once catalysis has taken place, as the cured film may poorly adhere to the substrate. Stir the product during application.

Like all epoxy products, high humidity and low temperatures during the application may impair cure and performance of the film.

Do not apply at temperatures below 8°C and with relative humidity higher than 80%. Do not apply onto surfaces colder than 10°C or whose relative humidity is higher than 3%. Avoid application on surfaces directly exposed to sun. Protect the surface from rain and wind for at least 48 hours from the application.

Dilution

Dilute the perfectly blended mixture with 5-15% of DILUENTE X.

Cleaning tools

With DILUENTE N immediately after use.

Storage

12 months in sealed container, away from sources of heat, in a cool and ventilated place, repaired from frost.

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Technical data

PRODUCT	Epoxy top-coat
SPECIFIC WEIGHT	1,050 ± 0,050 kg/l
VISCOSITY	2000 ± 500 cP Brookfield at 23°C (base + hardener)
GLOSS	Glossy = 80 ± 5 g.u. (60°) Satin = 40 ± 5 g.u. (60°)
COLOUR	White, RAL colours
RECOMMENDED THICKNESS	60-70 dry µm for each coat
RECOMMENDED COATS	2 coats spaced out by 24 hours
RECOAT TIME	Within 48 hours; later than that, sandpapering is required
CATALYSIS RATIO	Component A 100 – component B 25 (by weight)
POT LIFE AT 23°C	1-1,5 hours
APPLICATION METHOD	Air-mix spray gun: nozzle Ø 1,5-1,7 mm spray pressure 3-4 atm Airless: nozzle Ø 0,4- 0,5 mm compression ratio 30:1 pressure 130-160 atm (dilution max. 5%) Brush, roller
THEORETICAL YIELD	4-5 m ² /l for 2 coats
DUST-FREE TIME	30 minutes
TOUCH-DRY (23°C)	2-3 hours
DEEP-DRY (23°C)	24 hours
WALKABLE	24-36 hours
MAXIMUM CHEMICAL RESISTANCE	After 7 days

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