

Epox Fondo

Description

Anti-corrosion 2-component epoxy-polyamide base-coat, for general use; it can be overpainted with most of the coating products. Characterized by high coverage and hardness, good filling power, excellent adhesion for direct application on steel, galvanized steel sheets, aluminium, stainless steel, light alloys. It gives the substrate onto which it is applied good resistance to abrasion and excellent resistance to chemical attack and corrosion. Particularly suitable for substrates that require chromatic adjustment before top-coating.

Uses

It is employed as a base-coat for painting light and heavy metal carpentry, industrial bodyworks, agricultural, construction and industrial machinery, metallic furniture, et cetera.

Surface preparation

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

Steel 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.

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.

Aluminium and light alloys: carry out mechanical cleaning by light sandpapering and subsequent degreasing with organic solvent.

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 application, accurately mix the product until uniform colour and consistency are obtained, then pour the content of the hardener and mix thoroughly.

Mix 100 parts of BASE (base vehicle + pigment dispersions) with 20 parts of INDURENTE EPOX FONDO.

Poor mixing and weighing of base and hardener may impair curing and final chemical-physical properties. The prepared mixture has a working time of 4 hours; it is advised not to use the product once catalysis has taken place, as the cured film may poorly adhere to the substrate.

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Like all epoxy products, high environmental 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%.

Dilution

Dilute the perfectly-blended mixture with 5-15% of DILUENTE X for spray applications, or 5-10% for roller or brush applications.

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	2-components epoxy-polyamide base-coat
SPECIFIC WEIGHT	1,370 ± 0,080 kg/l
VISCOSITY	3000 ± 500 cP Brookfield at 23°C (A+B)
GLOSS	Matt
COLOUR	White, RAL colours
RECOMMENDED THICKNESS	50-60 dry µm for each coat
RECOMMENDED COATS	2 coats spaced out by 24 hours
RECOAT TIME	24-48 hours (after that, sandpapering is required)
CATALYSIS RATIO	Component A 100 parts - component B 20 parts (by weight)
POT LIFE AT 23°C	3-4 hours
APPLICATION METHOD	Air-mix spray gun: nozzle Ø 1,5-1,9 mm pressure 3,5-5 atm Airless: nozzle Ø 0,4- 0,5 mm compression ratio 30:1 pressure 130-160 atm (dilution max. 5%) Roller, brush
THEORETICEL YIELD	3-4 m ² /l for 2 coats
DUST-FREE TIME	30-40 minutes
TOUCH-DRY (23°C)	4-5 hours
DEEP-DRY (23°C)	24-36 hours

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The aforementioned technical notions regarding the application and correct use of the product do not imply liability of Alcas Italia S.r.l. for use and application of the products themselves. Due to the unpredictable variability of application conditions, the USER must verify with direct tests the suitability of the product for each peculiar use. We reserve the right to modify the content of this document, without notification. As soon as a new version of these technical data sheet becomes available, this one won't be valid any longer.

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