

EPOXY PRIMER 938/E

Epoxy Primer/Undercoat for Light Alloys

NATURE AND USE Two component epoxy undercoat of excellent quality to get adhesion on all "difficult substrates. Optimum for new anticorrosion systems, it is also indicated as surface-tolerant coating in the industrial maintenance systems. Applied at low thickness, Epoxy primer 938/E has exceptional performances of adhesion on light alloys, stainless steel, aluminium, hot galvanized sheet iron, etc..

The product can easily be over-coated with subsequent coats of suitable and compatible coatings. The pigments consist of particular Zinc salts to perform an effective antioxidant protection. The product is fast drying.

Easy to perform recoat applications or maintenance painting application during at least 18 months without need of mechanical Preparation of the substrate to be coated. Do not apply in critical humidity and temperature conditions.

The Product complies with ENEL Dco (P17) Specifications.

| TECHNICAL DATA | | | BASE | HARDENER |
|----------------|----------------------------------|----------|--|-----------|
| | | | Epoxy | Polyamide |
| | Type of binder | | | |
| | Viscosity Ford Cup 4 at + 25°C : | | 210 ± 30 sec. (A+B) | |
| | Specific gravity: | Kg/l | 1,30 ± 0,05 (A+B) | |
| | Colour : | | Red (A+B) | |
| | Mixing ratio: (by weight) | | 92,5 parts of Base + 7,5 parts of Hardener | |
| | Pot-life: | (+20°C) | ≥ 6 h | |
| | Solids content by Weight | | 69 ± 2% (A+B) | |
| | Solids content by Volume | | 55 ± 2% (A+B) | |
| | Max Continuous Service T°C | | +70/+80°C (in air, dry conditions) | |

SUBSTRATE PREPARATION **All Substrates** : Free from residual of grease, oils and any contaminant. After roughening , the substrate must be accurately de-dusted. All substrates must always be perfectly free from moist and dust traces.
Steel : Sandblasting at SA 2,5 minimum according to ISO 8501/1, medium roughness profile 40-70 µm Rz DIN . When it is not possible to perform sandblasting, the substrate must be perfectly clean, dry, degreased and free from rust or calamine residuals, then cleaned/mechanically abraded at ST3 D according to ISO 8501/1.
New hot galvanized iron sheet : dry, perfectly degreased, lightly roughened (or pickled or seasoned).
Galvanized steel already coated : Abraded to remove possible rust traces.
Aluminium : dry, degreased and lightly abraded or chemically treated.
Concrete : clean, dry, seasoned, free from laitance, weak concrete, efflorescence and detaching oil
Substrates with old coatings : remove all non adhering coating, than clean /mechanically abrade at ST3 D min. according to ISO 8501/1. The substrate must be accurately de-dusted.

PRODUCT PREPARATION Separately homogenize each component in the original can received. Mix in the right mixing ratio Base and Hardener, stirring the mix for 5 minutes to get complete homogenization, then pour into the dedicated tank of the applying equipment. Let the mix rest 5 minutes before starting its application.

| | | | |
|----------------------------|----------------------------|-------------------|--|
| APPLICATION DETAILS | Application: | | brush, roller, conventional spray, airless |
| | Thinning: | % | 0-10 % |
| | Thinner: | | Epothinner |
| | Tools cleaning: | | Epothinner |
| | Drying (at+ 20°C): | | surface dry 3 - 5 h; through dry 10-12 h |
| | Recoat interval (+25°C): | | 18 h minimum / max 18 months |
| | Application temperature: | °C | Between +10°C / max +40°C |
| | Product Temperature | °C | between +10° and +35°. |
| | Substrate Temperature : | °C | between +5° C and +40° C (always +3/+5°C above the dew point) |
| | Relative humidity: | % | <85 % |
| | Thickness: | | Min 35 µm - 100 µm Max DFT |
| | Theoretical spreading rate | m ² /l | 10,5 – 11,5 per coat at the thickness of 50 microns . |

HANDLING STORAGE AND SAFETY PRECAUTIONS **Handling**: Use individual protections: gloves, glasses and mask
Storage: Keep at room temperature in the sealed original cans (Min +5°C / Max +40°C).
Keep far from flames sparks or heat sources

Shelf life : 12 months in the original sealed cans, properly stored.
Safety precautions: FLAMMABLE. Use only in a well ventilated place.

Refer to Material Safety Data Sheet.

Product for professional use only and exclusively for the uses not regulated under CE Directive 2004/42/CE.

MTDS 04 012/1

INDUSTRIE BRUNO STOPPANI R.P.S. S.r.l. - Sede Legale Via Creta 72 25124 BRESCIA

Sede Operativa : Via Industriale 119 25020 Capriano del Colle Bs, TEL.0039 0309745116 r.a. FAX 0039 030 9745383

Mail: sales@industribrunostoppaipaints.com sales@ibspaints.com www.industribrunostoppaipaints.com

Azienda con sistema di gestione qualità UNI EN ISO 9001:2008 certificato da Certiquality - Certificato Nro 2134



The content of the present technical data sheet is the most complete currently available. It is based on practical experience and is given in good faith. Should any change be necessary, the present data sheet will be updated without prior notice.
The applying conditions of use differ according to environmental conditions and subjective application factors outside our control of the Company. The user shall determine the suitability of the products for the intended use. On request more detailed recommendations are available from the Company. No warranty is impressed or implied.
The Company refuses all liability not directly related with defects of the product or when differing from written instructions