

TECHNICAL DATA SHEET

Date of issue: 18/09/2007

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SIRO S.r.l.

Via Meucci, 5 - Z.I. Selve
35037 Teolo - Padova
Tel. 049.990.11.22
Fax 049.990.15.36
e-mail: vendite@siropaints.com
www.siropaints.com

Name:	EPOFIX HS	Category:	primer
Definition:	Epoxy primer	V.O.C. ready to use:	540 g/l
Code:	29.5	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, aluminium, galvanised 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.
- Aluminium: 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	29.5	Epofix HS	100 parts	100 parts
Component B	02.003	Eporex HS type	20 parts	40 parts

Carefully mix until an even colour and consistency are obtained. For airless applications no dilution is requested, for standard airmix application dilute with 07.006 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

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 03.009 in order to avoid bubble formation whilst using these tools.

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APPEARANCE (ASTM D 523):	Semimatt, 35±8 gloss.										
COLOURS:	On request (by using binder 29.5.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	<table><tbody><tr><td>- Dust dry:</td><td>30-40 minutes</td></tr><tr><td>- Touch dry:</td><td>8 hours</td></tr><tr><td>- Total hardening:</td><td>26-36 hours</td></tr><tr><td>- Forced drying:</td><td>30-40 minutes at 60°C</td></tr><tr><td>- Maximum chemical resistance:</td><td>After 7 days</td></tr></tbody></table>	- 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
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- 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.										
SALT SPRAY TEST (ASTM B 117):	350 hours alone. 500 hours considering the primer 29.0 (80 µm) and the polyurethane topcoat 68.1 (60 µm).										
IMPACT TEST (ASTM D 2794):	10 kg direct, 10 kg inverse on sanded iron.										
ADHESION (ASTM D 3359):	B=5 on surfaces treated like above reported.										
RESISTIVITY:	450 ± 50 Kohm ⁶										
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.