

# TECHNICAL DATA SHEET

Date of issue: 29/09/2010

Last updating:n°2 07/02/2017



|                                        |                               |                             |                |
|----------------------------------------|-------------------------------|-----------------------------|----------------|
| <b>Name:</b>                           | <b>EPOFIX WB EXTRA</b>        | <b>Category:</b>            | <b>A/d</b>     |
| <b>Definition:</b>                     | <b>Waterbase epoxy primer</b> | <b>V.O.C. limit:</b>        | <b>130 g/l</b> |
| <b>Code:</b>                           | <b>29W5</b>                   | <b>V.O.C. ready to use:</b> | <b>45 g/l</b>  |
| <b>Product according to 2004/42/CE</b> |                               |                             |                |

## NATURE OF THE PRODUCT

Two-pack water base epoxy primer.

## GENERAL USES

Product for general use on steel, zinc plated iron, aluminium, plastics, light alloys<sup>1</sup>.

## APPLICATION METHOD

## PREPARATION OF SURFACES

Waterbase products, because of the very low content of organic solvents, have a lower wetting action on surfaces than traditional solvent base products.

This means that presence of grease and oils on the surfaces, is absolutely not allowed.

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.

- 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 and then the top coat.
- Aluminium. 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 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 and then the top coat.
- Plastics: On plastics the product can be applied at direct adhesion. We suggest anyway some preliminary test due to the big variety of plastics present on the market.

## PREPARATION OF THE PRODUCT

|             | Code    | name                  | By weight | By volume |
|-------------|---------|-----------------------|-----------|-----------|
| Component A | 29W5    | Epofix WB extra       | 100 parts | 100 parts |
| Component B | 02W.020 | Cat. for epofix extra | 35 parts  | 50 parts  |

Carefully mix until an even colour and consistency are obtained. For airless applications no dilution is requested or maximum 5% dilution, for standard airmix application dilute with water in a percent of 10% to obtain a viscosity of 20-30" Ford 8 .

## APPLICATION

|              |                                                        |
|--------------|--------------------------------------------------------|
| Spray gun:   | nozzles of 1,4-1,6 mm. diameter and 3-5 atm. pressure. |
| Airless.     | nozzle 9/20 or 11/20 of inches, 120-150 bar            |
| Brush/roller | Ok, especially in applications on concrete             |

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

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## TECHNICAL DATA

**PRODUCT TYPE:** Two pack product

**APPEARANCE (ASTM D 523):** Matt ( $\leq 10$  gloss).

**COLOURS:** Available in ral 7035, pale gray

**SPECIFIC WEIGHT (ISO 2811):**  $1,68 \pm 0.08$  kg/l (comp. A)

**SUPPLY VISCOSITY :** 65-95" cup Ford 8

**SOLID ON VOLUME:**  $39\% \pm 2\%$  comp. A

**SOLIDS CONTENT:**  $59\% \pm 2\%$  comp. A

|                       |                     |          |                 |             |
|-----------------------|---------------------|----------|-----------------|-------------|
| <b>DRYING AT 20°C</b> | - Dust dry:         | 30'-1h   | - Touch dry:    | 2-3 hours   |
|                       | - Total hardening : | 12 hours | - Forced drying | 30' at 60°C |

- Maximum chemical resistance: After 7 days

**RECOMMENDED COATS:** One crossed coat and half

**THICKNESS<sup>2</sup>:** 60-80  $\mu\text{m}$

**THEORETIC YIELD<sup>3</sup>:** 6-8  $\text{m}^2/\text{kg}$

**POT-LIFE AT 20° C:** 2 hours at temperature of 20° C. At higher temperatures, pot-life decreases. Do not apply the product when pot life is over. It will cure at the same, but the adhesion can be compromised.

**SALT SPRAY TEST (ASTM B 117):** At least 500 hours with a cycle primer plus topcoat with 120-140 $\mu\text{m}$  of dried film. 80-100 $\mu\text{m}$  of dried film alone, can reach 500 hours

**IMPACT TEST (ASTM D 2794):** 36 kg direct on scratched iron

**ADHESION (ASTM D 3359):** B=5 on surfaces treated like above reported.

**REPAINTING:** Within 2-3 hours it can be overcoated with water or solvent based topcoats. over 12 hours from the application, it is better a light sanding before over coating

**STORAGE STABILITY:** Two years for A and B component, stored in closed packs, in a cool, dry place, away from any sources of heat. Keep to a temperature  $> 5^\circ\text{C}$

<sup>2</sup> Considering a dry film.

<sup>3</sup> The theoretical yield has been calculated for the thickness suggested and over plane and regular surfaces.