

TECHNICAL DATA SHEET

Date of issue: 24/05/2006

Last updating:n°10 28/05/2020



Name:	EPOFIX	Category:	B/C
Definition:	Epoxy primer-intermediate	V.O.C. ready to use:	540 g/l
Code:	29.3	Product according to	2004/42/CE

NATURE OF THE PRODUCT

Two pack epoxy enamel to be mixed before use. Contains anticorrosive pigments based on zinc phosphate.

GENERAL USES

Universal corrosion-resistant primer-intermediate, recoatable with most painting products.

It can be applied on: iron, aluminum, galvanized sheet, light alloys¹, cement, concrete, or, as an intermediate, on epoxy or inorganic zinc rich primers or other kinds of primers that need an intermediate prior to top coat application.

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, then degreasing with solvents.
- Aluminium: mechanical cleaning of the substrate by sanding, then degreasing with solvents.
- Plastics: By adding the additive 03.028, the product has good adhesion on various types of plastic supports.²
- Concrete: the concrete casting should be aged for 4 weeks and it must not have grout formations that must be removed by shot peening.

PREPARATION OF THE PRODUCT

	Code	Name	By weight	By volume
Component A	29.3	Epofix	100 parts	100 parts
Component B	02.120	Eporex standard	20 parts	33 parts
As an alternative	02.150	Eporex quick	20 parts	33 parts
As an alternative	02.V50 ³	<u>Epoxy vinyl hardener</u>	20 parts	33 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 15-20% to obtain a viscosity of 24-30" Ford 4.

APPLICATION⁴

Spray gun: nozzles of 1,4-1,7 mm. diameter and 3-5 atm. pressure.

Airless. nozzle 9/20 inches, 180-240 bar

¹ Given the variety of alloys on the market, we recommend making preliminary adhesion tests.

² Preliminary tests are always recommended to ensure correct adhesion to the support.

³ **With this hardener the system becomes an epoxy-vinyl system, it means epoxy system with vinyl modification. This allows over-coating of the primer even after different weeks from the application with no need of sanding or scratching of the primer.**

⁴ Minimum application temperature: higher than +10°C. In high humidity conditions (over 70%), matt-white haze phenomena may occur on the painted surface with slight delay in hardening time. However, this phenomenon does not compromise the typical features of the film.

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Electrostatic	After using a suitable quantity (at least 20%) of thinner 07.006
Brush/roller	Only for large surfaces ⁵

TECHNICAL DATA

PRODUCT TYPE: Two pack product

APPEARANCE (ASTM D 523): Matt <20 gloss.

COLOURS: By request (the binder 29.3.K1 has to be used in a ratio 80/20 with the tinting system tinters). We do have also the following ready colours: grey 29.3.70121, 29.3.R7035 and white 29.3.90130.

SPECIFIC WEIGHT (ISO 2811): $1,65 \pm 0,08$ g/cm³ for A component

SUPPLY VISCOSITY: 6000-9000 CPs

SOLID ON VOLUME: A + B 48 % ($\pm$ 2%)

SOLIDS CONTENT: A + B 64 % ($\pm$ 3%)

DRYING AT 20°C

- Dust dry: 30-40 minutes
- Touch dry: 4-5 hours
- Total hardening: 26-36 hours
- Forced drying: 30-40 minutes at 60°C
- Maximum chemical resistance: After 7 days

RECOMMENDED COATS: Minimum one crossed coat

THICKNESS: 50-60 μ m

THEORETIC YIELD: 7 m²/kg

POT-LIFE AT 20° C: 8 hours. At higher temperatures, pot-life decreases (for catalysis with 02.120, with 02.150 the pot life is 4 hours)

SALT SPRAY TEST (ASTM B 117): 350 hours, 500 hours for a cycle with 60 μ m 29.3, 60 μ m polyurethane top coat series 68.1

CERTIFICATION EN ISO 12944-6: The product, in its white version **EPOFIX 29.3.90130**, combined with acrylic (**50.1 series**) or polyurethane (**67.1 or 68.1 series**) top coat, complies with EN ISO 12944-6 'Corrosion protection of steel structures by protective paint systems', class C4M, suitable for industrial environments and coastal areas with moderate salinity (final thickness 180 μ m).

IMPACT TEST (ASTM D 2794): 10 kg direct, 10 kg reverse on scratched iron.

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

RESISTIVITY: 450 ± 50 kOhm.⁶

TEMPERATURE RESISTANCE It resists until 200°C, there can be only a change in the color

CHEM. RESIST .⁷ (UNI EN ISO 12720):

⁵ You may need Antifoam additive 03.009 in order to avoid bubble formation whilst using these tools.

⁶ Generally, a product with a resistivity below 600 kOhm is suitable for electrostatic gun application.

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Hydrochloric acid-HCl solut. 10%	vote 5	7 days
Nitric acid-HNO ₃ solut. 10%	vote 3	4 days
Sulphuric acid-H ₂ SO ₄ solut. 10%	vote 5	7 days
Acetic acid solut. 10%	vote 3	1 day
Ammonia solut. 30%	vote 5	7 days
Sodium hydroxide solut. 10%	vote 5	7 days
Acetone	vote 4	7 days
Cyclohexanone	vote 2	5 days
Solvesso 100	vote 4	7 days
Ethanol	vote 4	7 days
Engine oil 15W40	vote 4	7 days

REPAINTING:

With **02.120**: minimum 8 hours, maximum 5 days. With **02.150**, minimum 2 hours, maximum 72 hours (at 20°C, at lower temperatures we recommend longer repainting time). Over this time, we recommend scratching before overpainting. With **02.V50** minimum 1 hour then the primer can be overpainted even after 1 month without scratching, it has to be clean but not scratched. With this hardener, the primer turns from epoxy primer to epoxy-vinyl primer.

STORAGE STABILITY:

Two years stored in closed pack, in a cool, dry place, away from any sources of heat.

⁷ The quality of chemical resistance goes from a value of 5 (means optimum) to 1 (means not good). For further information please contact Siro's technical service.