FEA05 EPOFILLER 2K IND

GENERAL CHARACTERISTICS AND USE

2K epoxy primer. Fast drying. Excellent filling power. Good adhesion on steel, zinc plate and Alluminium. Suitable for coating metal items in industrial painting systems and for industrial bodywork and for protecting metal structures installed in standard environment. Product with VOC conforming to the category limits set by Directive 2004/42/CE

SURFACE PREPARATION

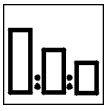



Steel: the surfaces should be sanded or, better still, sand-blasted down to the white metal. Any calamine should be completely removed. Degrease with V09 Antisil.
In the case of continuous processes where sanding is impossible, or if the articles are polluted on the surface by rolling lubricants (oils, stearates, soaps), they must be washed in a several stages plant with suitable detergents.

Electrolytic galvanized steel: Degrease with V09 Antisil.

Hot-dip galvanized steel: Degrease with V09 Antisil, followed by sanding or brisk surfacing with wire wool.

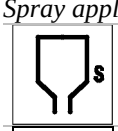
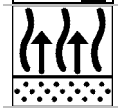
PRODUCT PREPARATION



	weight	volume	Pot life at 20°C
FEA05 Epofiller 2K Ind	1,000	1,000	
Hardener CE006/CE008	185	350	8 h
Thinner DE001	200-300	250-350	

COATING SYSTEM

Spray application

	Application viscosity at 20°C TF 4	20-25 s
	Nozzle diameter	1.6-1.9 mm normal; 1.4-1.8 mm HVLP
	Air pressure	3.5-4.5 bar normal; 2-2.5 bar HVLP
	Flash-off at 20°C	15 min
Recommended final thickness (2 coats)		50-70 µm
Theoretic yield at 50 µm		8 m^2/l – 5 m^2/Kg
V.O.C.		2004/42/IIB (c)(540) 500

It is advised not to apply at temperatures below 10° C.

Electrostatic spray application

When catalyzed and thinned as described above, the product can be applied by means of suitable electrostatic systems.

DRYING

In air at 20°C



Touch dry	2-3 h
Through dry	24 h

Stove dried at 60°C



Stove drying at 60°C 45-60 min

OVER-COATING PRODUCTS
Overpaintable with all kind of paints

The technical information and suggestions given are the result of our experience and tests. We ensure that our products provide fade-free quality. However, we assume no responsibility for the results obtained as the conditions in which the product is used are beyond our control. You are therefore advised to conduct tests in the real coating and use conditions prior to actual production.


Consult the safety literature: FEA05