

EPOXY PRIMER 938/E

Two component epoxy primer for light alloys

NATURE AND USE

Two-component epoxy undercoat of excellent quality used to get adhesion on all substrates when considered particularly "difficult". Optimum for new anticorrosion systems, it is indicated also as surface-tolerant coating for 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 are particular Zinc salts to perform an effective anti oxidant protection. The product is fast drying.

Easy to apply overcoating or maintenance painting during at least 18 months without need of any Mechanical preparation of the substrate.

Do not apply in critical humidity and temperature conditions.

The Product complies with ENEL Dco (P17) Specifications.

TECHNICAL DATA



Type of Binder:	Epoxy - Polyamide
Ford Cup 4 Viscosity @ + 25°C:	s 210 ± 30 s A+B
Specific Gravity A+B	Kg/l 1.30 ± 0.05 @ +20°C
Colour:	Red A+B
Solids by Weight:	% 69 ± 2 % A+B
Solids by Volume:	% 55 ± 2 % A+B
Mixing Ratio by Weight:	92.5 parts of Base / 7.5 parts of Hardener
**Pot life @ +20°C:	≥ 6 hours
Max Continuous Service T°C	+70/+80°C (in air, dry conditions)

SUBSTRATE PREPARATION

All types of substrates: All surfaces must be free from residual of greases and contaminants.

After roughening, perform accurate dust removal. Verify that the substrates to coat are always completely free from traces of humidity.

Steel: Sandblasting at grade SA 2,5 according to ISO 8501/1 with minimum roughness profile Rz DIN 30 – 60 µm. When sandblasting is not possible, the substrate should be dry, degreased, perfectly cleaned and free from rust or calamine, mechanically abraded at the minimum grade ST3 according to ISO 8501/1.

Steel already coated: All detaching or not well anchored parts of old paint must be mechanically stripped as well as all rust scraped off. Roughen well the surface to treat to reach the proper adherence between paint and substrate. Eliminate all dust and other residuals from the above operations.

Note: We suggest to verify always in any case and preliminarily the compatibility between old paint and the new one to be applied.

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 and mechanically abrade at ST3 D min. according to ISO 8501/1. The substrate must be accurately de-dusted.

MTDS 01018/ Page 1 of 3

The content of the present technical data sheet is the most complete currently available, based on practical experience and 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 the control of the Company. The user shall determine the suitability of the product for the intended use under his own risk and responsibility. No warranty is impressed or implied. The Company refuses all liability not directly related with defects of the product or consequent to deviations from written instructions.



INDUSTRIE BRUNO STOPPANI R.P.S. S.r.l.

Sede Operativa: Via Industriale 90-119 25020 Capriano del Colle (Bs) – Italy - Phone +39 030 9745116 – Fax +39 030 9745383

sales@industri brunostoppa nipa nts.com - www.industri brunostoppa nipa nts.com

Company with quality management system UNI EN ISO 9001:2015 certified

EPOXY PRIMER 938/E

Two component epoxy primer for light alloys

PRODUCT PREPARATION

Separately homogenize each component in the original supply can. 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.

** The "POT LIFE" time of two components products (time within which it is possible to apply the paint mix of Base and Hardener), is exponentially dropped by the increase of product temperature.

Note: The use of a mix of paint (Base + Hardener) over the POT LIFE time is irreparably compromising all the properties of the coating film.**

APPLICATION DETAILS

Application Method:		Standard Airless Spray with compression ratio 45:1 minimum Conventional spray Roller, Brush
Thinning:	%	0-10 %
Thinner:		Epothinner
Cleaning:		Epothinner
Hardening @ + 20°C:		Surface dry 3 - 5 hours Through dry 10-12 hours
Overcoating @ +20°C:		18 hours Min. / Max. 18 months
Application Ambient Temperature:		Between +5°C and +35°C
Suggested Temperature of the product:		+20 ÷ +30°C
Substrate Temperature:		+5 / +40°C always at least +3/5°C above dew point
Relative Humidity:		≤ 85%
Thickness:		Min. 35 µm - 100 µm dry Max. (DFT)
Theoretical spreading rate	sqm/l	10,5 – 11,5 per coat at the thickness of 50 µm dry (DFT) .

More info by writing to sales@industri brunostoppa nipa nts.com or by calling +39 030 9745116

HANDLING STORAGE AND SAFETY PRECAUTIONS

Warning: All handling and/or use activities of the material and its components must strictly refer to the given indications in the Safety Data Sheet (Base and Hardener). The following advices are stated by common sense and in good faith, they are uncompleted and do not substitute the content of each specific safety data sheet of the product.

Handling: The material must be used only by professional and qualified applicators suitably trained. All the operations involving the use of the product, must be carried on in compliance with all the relevant National Health, Safety & Environmental standards and regulations.

Precautions: When the product is used in enclosed areas (rooms, containers, vessels, etc.) it is imperative to use adequate means providing the necessary air circulation, to be granted during the whole application and coating polymerization time, also to avoid conditions open to potential explosion danger.

All electrical installations must always be grounded. Where explosion hazards exist, the workmen should be required to use only non-ferrous tools and wear conductive non-sparking shoes and clothing. Explosion and flame-proof equipment too are required.

MTDS 01018/ Page 2 of 3

The content of the present technical data sheet is the most complete currently available, based on practical experience and 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 the control of the Company. The user shall determine the suitability of the product for the intended use under his own risk and responsibility. No warranty is impressed or implied. The Company refuses all liability not directly related with defects of the product or consequent to deviations from written instructions.



INDUSTRIE BRUNO STOPPANI R.P.S. S.r.l.

Sede Operativa: Via Industriale 90-119 25020 Capriano del Colle (Bs) – Italy - Phone +39 030 9745116 – Fax +39 030 9745383

sales@industri brunostoppa nipa nts.com - www.industri brunostoppa nipa nts.com

Company with quality management system UNI EN ISO 9001:2015 certified

EPOXY PRIMER 938/E

Two component epoxy primer for light alloys

Storage and transport: Keep far from flames, sparks or heat sources. Do not leave exposed under direct solar action. Store under shelter in original unopened packaging, in cool, dry and ventilated areas, at temperatures between +5°C and +35°C.

Shelf life: **Base** 12 months in the suggested storage conditions (original unopened packaging)
Hardener 12 months in the suggested storage conditions (original unopened packaging)

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

Refer to Material Safety Data Sheet



Access catalogues, data sheets and company presentations

MTDS 01018/ Page 3 of 3

The content of the present technical data sheet is the most complete currently available, based on practical experience and 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 the control of the Company. The user shall determine the suitability of the product for the intended use under his own risk and responsibility. No warranty is impressed or implied. The Company refuses all liability not directly related with defects of the product or consequent to deviations from written instructions.



INDUSTRIE BRUNO STOPPANI R.P.S. S.r.l.

Sede Operativa: Via Industriale 90-119 25020 Capriano del Colle (Bs) – Italy - Phone +39 030 9745116 – Fax +39 030 9745383

sales@industri brunostoppa nipa nts.com - www.industri brunostoppa nipa nts.com

Company with quality management system UNI EN ISO 9001:2015 certified