

TECHNICAL DATA SHEET

Trade name: **EPOXY FOND**

Serie: **451**

Date of issue: **june 2000**

Revision: **june 2017**

DESCRIPTION

Medium-low thickness, epoxy anticorrosive primer. Many fields of use: industrial vehicles, agricultural equipments, machine tools, industrial products, etc.

TECHNICAL DATA

• Codes	Base product	451...
	Hardener	451005 (see notes)
	Thinner	909000
• Mixing ratio	By weight	100 : 20
	By volume	100 : 33
• Pot-life	Hours	8
• Solids by volume	%	49 ± 2
• Specific gravity	g/l	1350 ± 50
• Film thickness	Micron	50
• Theoretical coverage	m ² /l	9.8
	m ² /kg	7.2
• Aspect		matt
• Temperature resistance	°C	100
• Shelf life	Months	12

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- Surface preparation**

New steel: sandblasting near to white grade metal Sa 2½.
 Oxidized steel without millscale: hand or mechanical brushing grade St 3.
 Galvanized steel and light alloys: mechanical roughening with scotch brite or light sandsweeping and careful degreasing.
- Application conditions**

Temperature	°C	5 ÷ 40
Relative humidity	%	0 ÷ 85
- Application methods**

	Conventional spray	
Fluid tip orifice size	Inches	0.070
Air pressure	kg/cm ²	3.5 ÷ 5
Thinning by weight	%	5 ÷ 10
	Airless	
Fluid tip orifice size	Inches	0.018 ÷ 0.021
Fluid pump		30 : 1
Fluid pressure	kg/cm ²	150 ÷ 170
Thinning by weight	%	0 ÷ 5
	Brush	
Thinning by weight	%	0 ÷ 5
	Roller	
Thinning by weight	%	0 ÷ 5
- Drying time**
(T. 20°C – R. H. 60%)

Touch dry (hrs)	Hard dry (hrs)	Overcoating time	
		Min (hrs)	Max (hrs)
30' ÷ 1	18 ÷ 24	8 ÷ 12	-
- Recommended primers and topcoats**

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- Notes**

450003 fast hardener at 20% by weight.
 451005 hardener at 20% by weight.
 451006 hardener at 20% by volume.
 451007 fast hardener at 20% by weight.
 451008 epoxy-polyamine hardener at 15% by weight.

This sheet gives the technical data based on our best technical and practical experience. However, due to the variable environment conditions or individual application systems we cannot bear any direct or indirect liability or give any guarantee for the use of our products. The customer has to verify the product's suitability for the requested use. For more technical information and details please contact our technical service.

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