



SMALTOSISTEM

Data Sheet NS 328.0

Date: 08/01/01

EPOXY FIRST COAT

T523/

EPOX

Colours: all SMALTOSISTEM shades

A two-pack epoxy first coat with good filling power, good corrosion resistance, excellent adhesion to all substrates.

It is used for the protection of industrial structural work, machine tools, industrial products, galvanised metal sheet, and light alloys.

SUBSTRATES

Ferrous metal sheet: sandblasted, well degreased.

Light alloys, galvanised metal sheet, cast iron.

PRODUCT PREPARATION

HARDENING MIXING RATIO: on 100 parts of component A

BY WEIGHT	BY VOLUME	HARDENER
25	35	9925 / 7779
25	35	9926 / 0000
20	30	9926 / 7779

THINNING:

Hardening with **9926/0000** and with **9926/7779**

— **10 – 20%** on 100 parts of base A with nitro thinner **9095/, 9096/, 9097/**

Hardening with **9925/7779**

— **10 – 20%** on 100 parts of base A with thinner **EPOX 9043/**.

POT LIFE:

HARDENER	POT LIFE
9925 / 7779	5 – 6 hours
9926 / 0000	8 – 10 hours
9926 / 7779	5 – 6 hours

APPLICATION METHOD

- Spraying: cup gun, electrostatic, airless, airmix, air-mixed
- Brush
- Roller

Recommended film thickness 60 – 80 dry microns.

DRYING (ALCEA METHOD - ME 81)

AIR DRYING:

	9926/0000	9926/7779	9925/7779
Dust free time	30 minutes	30 minutes	30 minutes
Dry to touch	3 hours	2 hours	2 hours
In depth	8 hours	4 hours	4 hours
Overcoatable	12 hours	12 hours	12 hours

ACCELERATED OVEN DRYING: only by using **9926/000** and **9926/7779** hardeners

- 1 hour at 50-60°C after flash-off of 15-20 minutes in air
- 20 minutes at 80°C only by using **9926/7779** hardener, after same flash-off.

RECOATING

Possible without flatting from 3 to 24 hours.

TECHNICAL DATA *

	AS SUPPLIED	HARDENED	U.M.	METHOD
Specific gravity	1.360 – 1.53	1.283 – 1.391	kg/l	ALCEA - ME14
Ford Visc. 8/20°C	18 – 15"	//	s	ALCEA - ME 16
Dry by weight	70.5 – 74.7%	64.6 – 72.8%	kg/kg	ALCEA - ME 15
Dry in volume	33.7 – 37.4%	33 – 39.1%	l/kg	ALCEA - ME 15
Dry by volume	50 – 52.5%	45.8 – 55.3%	l/l	ALCEA - ME 15
Gloss on 60°	20 – 30		//	ALCEA - ME 60
Theor. spreading for 30 dry microns	11 – 13		sq.m./kg	ALCEA - ME 82
Theor. spreading for 80 dry microns	4 – 5		sq.m./kg	ALCEA - ME 82

NOTES

We recommend for a correct drying to apply the product at temperatures not lower than 15°C and relative humidity not higher than 65-70%.

Epoxy products, if exposed in exterior, tend to yellowing and chalking losing the initial aesthetic characteristics, while the resistance characteristics are not altered.

STOCKING

Warning: The product shall be stored in its original containers, protected from heat sources and within a + 5°C to + 35°C temperature range.

* Since values refer to products made up using a colour mixing system, the values marked with an asterisk are indicative and refer to our product formulas only.

The information contained herein is the result of numerous experiments and provides an excellent guide. However, since application methods and processing techniques differ widely, we cannot guarantee results every time.

This updated fact sheet supersedes all previous editions.

N.B.: For further information you have to consult the t.d.s. FERRO NF 101