GlobalStar INDUSTRIAL

Technical Data Sheet

Date of issue: 06.23
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Name: **Binder Epoxy Gloss**
Definition : **Epoxy two pack top coat**
Code:**2A.1.K1**

Category: **high performances bicomponent paint**
V.O.C limit :500 g/l
V.O.C.ready to use:500 g/l
Product according to 2004/42/CE

NATURE OF THE PRODUCT

Two-pack epoxy-amino top coat to be mixed before use.

GENERAL USES

Product for general use on steel, zinc plated iron, aluminum, plastics, light alloys[1]. Fit for coats of automatic machine tools and manufacturing machine. It can be used also as top coat in painting cycles for artefacts to be immersed. Not recommended for external use

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. The product shows direct adhesion on metals[2] without a previous primer application. Because of the big variety of substrates is always better to perform some preliminary tests before. Eventual suggested primers for this product are: Acrylic Primer Epoxy primer 2I.3.K1.

- **Ferrous surfaces**. SA2 1/2 sandblasting or very careful mechanical abrasion followed by degreasing using thinners, then proceed with the direct application of the product or, if preferred with the application of a primer and then the top coat.
- **Aluminum.** Chromate or phosphorous chromate treatment or in alternative sanding procedure followed by degreasing using thinners. Then proceed with the direct application of the product or, if preferred with the application of a primer and then the top coat.
- **Galvanized sheet.** Delicate sanding (with scotch brite paper) followed by degreasing using thinners. Then proceed with the direct application of the product or, if preferred with the application of a primer and then the top coat.

PREPARATION OF THE PRODUCT

	code	name	By Weight	By Volume
Component A	2A.1.K1(TINTED	Binder epoxy Gloss	100 parts	100 parts
Component B	0B.025	Epoxy Hardener	40 parts	60 parts
Component B	0B.120[3]	Hardener epoxy standard	30 parts	45 parts

Carefully mix until an even color and consistency are obtained. Diluted with 10-15% of our thinner 0G.006 (to obtain a viscosity of 22-26" Ford 4).

APPLICATION

Spray gun: nozzles of 1,8-2,2 mm. diameter and 1-2 atm. pressure.

Airless. nozzle 0,09 inches, 120-150 bar

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[1] Given the variety of alloys on sale, we recommend carrying out a few preliminary adhesion tests.
[2] If it is necessary to improve the corrosion resistance of the painted artefact, we suggest to apply a primer.
[3] With this hardener, depending on temperature and relative humidity, you can obtain a film with lover gloss level due to haze.

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Roller or brush:	Only for small surfaces

TECHNICAL DATA

PRODUCT TYPE:	Two pack product			
FILM APPEARANCE (ASTM D 523):	glossy 85±5 gloss			
COLOURS:	By request (the binder. 2A.1.K1 has to be used in a ratio 75/25 with the tintometric system tinters)			
SPECIFIC WEIGHT (ISO 2811):	A: 1,45 kg/l (± 0,08)			
SUPPLY VISCOSITY	100KU +/-5 @ 25			
SOLID ON VOLUME:	48% (± 3%) A+B			
SOLIDS CONTENT:	62% (± 5%) A+B			
DRYING AT 20℃	Dust dry:	30-40’	Touch dry:	5-6 hours
	Total hardening:	36 hours	Forced drying[4]	45’ at 60℃
	Maximum chemical resistance:	After 7 days		
RECOMMENDED COATS:	One crossed coat.			
THICKNESS[5]:	50-60 m.			
THEORETIC YIELD[6]:	8 m^2/kg			
POT-LIFE AT 20°C:	8 hours at temperature of 20°C. At higher temperatures, pot-life decreases.			
REPAINTING:	Within 24 hours or, after the complete hardening of the film, it is better a light sanding before overcoating			
STORAGE STABILITY:	Two years in closed packs, in a cool, dry place, away from any sources of heat			

[4] Baking the product can change the final gloss result, it could result more matt, and also the final colour can result more yellow.
[5] Considering a dry film.
[6] The theoretical yield has been calculated for the thickness suggested and over plane and regular