

REPOKIM

Series 0758

2K, epoxy-based primer and intermediate coat



TECHNICAL FEATURES

2K primer mainly composed of epoxy resins and special fillers with good adhesion to metal supports and high filling power. The product is over-coatable with 1K and 2K enamels. It can be used as intermediate coat in zinc-based coating systems.

APPLICATION FIELD

Product ideal as a 2K epoxy primer for coating metallic carpentry and machine tools where a high filling effect is requested.

GENERAL INFORMATION

System: Two pack - 2K

Nature: Solvent-based

Packages: 20 kg

Colors ready in stock: Grey Ral 7035

Suitable Substrates: Iron, Cast iron, Galvanized surfaces, Light alloys, Aluminum, Sandblasted Iron - Sandblasting Sa 1-2, Sandblasted Iron - Sandblasting Sa 2,5-3, Hot-dip galvanization
Overcoatable with: Epoxy, acrylic and polyurethane enamels

SUBSTRATE PREPARATION

The surface pre-treatment process, to be carried out prior to the application of the coating product, is of considerable importance in order to obtain and guarantee optimal and long-lasting results and performance over time. The substrate must be perfectly clean, dry, degreased and free from rust and/or calamine. It is also advisable to make sure that the substrate is free from particles and other paints that are not perfectly adherent or incompatible with the coating of paint that will be applied. For the purpose of a correct and complete preparation, it is recommended to consult, where necessary, the explanatory notes attached to the technical data sheet, the painting manual and the technical assistance service of the Research & Development Laboratory. The explanatory notes, specifically, depending on the type of surface and the result to be obtained, indicate different pre-treatment methods such as degreasing, manual and mechanical cleaning using special equipment, mechanical preparations (scraping, sanding, tapping, brushing), light or accurate sandblasting, shot blasting, shot peening and wet sandblasting (or hydro sandblasting). In case of particularly difficult surfaces, such as bright galvanized sheet metal, stainless steel, thermosetting powders, pre-coated sheets, the preparation with mechanical preventive treatment such as mild sandblasting, sanding and/or brushing is necessary

APPLICATION

Application conditions

The application of the coating product is subject to various factors such as environmental conditions (among which it is necessary to mention temperature, humidity and ventilation), geometry and laboriousness of the products to be painted, surface profiles and thicknesses to be applied. The application system to be used is of particular importance as, depending on the type of system, various parameters may vary including the transfer efficiency of the coating product, the overspray, the aesthetic appearance obtained, the sagging stability of the product and the ease or complexity of application. For these reasons, prior to applications on systems and lines of considerable scope, it is advisable to contact the technical assistance service in order to carry out the inspection and the necessary surveys for a consultancy activity relating to the application methods and the definition of ad hoc technical details on the plant in question.

EQUIPMENT	VISCOSITY	NOOZLE	PRESSURE	NOTES
AIRBRUSH - CUP GUN	25" - 45" Ford Cup 4	1,6 - 1,9 mm	3,5 - 4 bar	-
AIRLESS	F&K technical assistance	F&K technical assistance	F&K technical assistance	F&K technical assistance
AIRMIX	Depending on application parameters	13 - 15	60 - 100 bar	-
ROLLER AND BRUSH	-	-	-	Dilution at 10-15% with Epoxy Thinner Series 0981

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CATALYSIS

SERIES	HARDENER	CATALYSIS	USE	POT LIFE AT 20°C	PACKAGE
0949	EPOX ELECTROSTATIC HARDENER	25% by weight (100 + 25)	Slow	6 hours	5 kg
0918	EPOX SLOW HARDENER	20% by weight (100 + 20) or 3:1 by volume	Slow for primers	6 hours	4 kg

ENVIRONMENTAL CONDITIONS



ENVIRONMENT
TEMPERATURE

12°C - 30°C



SUBSTRATE
TEMPERATURE

12°C - 30°C



RELATIVE
HUMIDITY

60 %



SHELF LIFE

Store 2 years in original sealed packaging
at +5/+35°C.

TECHNICAL DATA



THEORETICAL
AVERAGE
SPREADING RATE

7,2 m²/kg
each coat at the
dry film thickness
of 50 µ



APPLICATION

Spray, Brush



DILUTION

10-15% with
Epoxy Thinner
Series 0981



GLOSS

-



WET FILM
THICKNESS
EACH COAT

98 µ



DRY FILM
THICKNESS
EACH COAT

50 µ



N° OF COATS

1 or 2 coats to
achieve the total
desired thickness



TOTAL DRY FILM
THICKNESS

90 µ



THEORETICAL
AVERAGE
CONSUMPTION

138 g/m²

DRYING



OVERCOATING
INTERVAL

6 - 96 hours
(after it is
necessary to
sand)



AIR DRYING

20°C



DUST-FREE
DRYING

30 minutes



DRY TO TOUCH

1 - 2 hours



DRY THROUGH

24 - 36 hours



FULL CURE

28 days



FLASH OFF

-



STOVING DRYING

-



RESISTANCE TO
TEMPERATURE

80°C short
temperature leap
at 100°C

WARNINGS AND RECOMMENDATIONS

- Do not apply the product at ambient temperatures below 12°C-15°C and maintain this limit, with reference to both the product and the surface to be treated, at least for 8-12 hours after application.
- Given the duration of the hardened mixture which is not visible, it is recommended not to partially top up with the fresh product.
- Shelf Life Component B: the shelf life of the hardener used with Component A is 24 months.
- The product can be applied by roller and brush only on small areas and parts of the product to be coated, for maintenance purposes and in case of moderate needs and expectations in relation to the final aesthetic finish.

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SUPPLY TECHNICAL DATA

Composition: Epoxy polyamide
Reference color: Grey Ral 7035
% solid content by weight: $77 \pm 2\%$
% solid content by volume: $57 \pm 2\%$
VOC: 379 ± 2 g/l
VOS: $23 \pm 2\%$

PARAMETER	DATA	TEST METHOD
VISCOSITY	10000 - 12000 mPa.s (20°C) Rod 5 Speed 20	ISCOL 1
SPECIFIC WEIGHT	1.51 - 1.65 g/ml	ISCOL 2

MIXING RATIO A+B

Specific weight after catalysis (A+B): $1.41 \pm 0,05$ g/ml
% solid content by weight (A+B): $67 \pm 2\%$
% solid content by volume (A+B): $51 \pm 2\%$
VOC (A+B): 457 ± 2 g/l
VOS (A+B): $32 \pm 2\%$

METHOD	0949	0918
A+B BY WEIGHT	100 + 25	100 + 20
A+B BY VOLUME	100 + 45	3:1

NOTES

Cleaning tools: At the end of the application, carefully wash the spray guns, the painting systems and the containers with a suitable thinner and store the tools dry to avoid encrustations.

Sanitary labelling: Handle the product with care. Make reference to the MSDS and respect the national and local regulations in force concerning personal and environmental safety.

Additional notes:

- The data reported in this data sheet have been obtained using only Franchi&Kim production materials (coatings, hardeners, thinners) applied in accordance with the specifications described. The improper use of thinners and/or hardeners, other than those mentioned or not manufactured by Franchi&Kim, can compromise application features, performances and final curing of the product. Therefore, in case of mixed coating systems with Franchi&Kim and other brand products, the conformity of the results with the parameters indicated in the technical data sheet cannot be granted.
- All times indicated in the drying section are to be intended at the temperature of 20°C, unless otherwise specified.
- The data relating to section mixing ratio A+B are to be considered referring only to the first recommended catalyst.
- The spreading rates are theoretical, indicative and intended per coat as they can be influenced by the color and the application system. Practical application test is suggested.
- Pot Life times have been defined at the temperature of 20°C, therefore higher or lower temperatures, hardeners, environmental conditions and humidity different from the standard can influence in defect or in excess the duration of the Pot Life.

The information contained in this technical document is correct and accurate to the best of our knowledge, and should therefore be considered reliable. In any case, they cannot imply a guarantee on our part, as certain factors such as the preparation of the product and the substrate, the conditions of use, application, drying and overcoating, as well as the state of conservation of the products, are outside our strict control. It is responsibility of the user to verify the suitability of the products for the specific use, as well as the correct and precise execution of the work in accordance with the content of the technical data sheet, the recommended coating system and preparation of the support. For further information regarding the method of application and conditions of use, it is recommended to contact our technical support service. It should be noted that the packaging image could have a placeholder purpose and could therefore be an indicative reference. The packages indicated may vary according to the additions or changes of the annual price lists. This document replaces all previous versions. In any case, it is advisable to refer to the annexes with the explanatory notes to better understand and deepen the parameters of the technical data sheet. The updated edition, available on the website www.franchi-kim.com in the section technical data sheets of the download area is to be considered the only ones to consult as reference.

ESTALIA Performance Coatings Spa

Via Giacomo Matteotti, 160 - 25014 Castenedolo - Brescia - Italia - Tel. +39 030 21 35 55 - Fax +39 030 27 31 664 - www.franchi-kim.com - www.estaliacoatings.com