







S741. EPOXY PLUS

					
900 ml 100 ml 100-250 ml	Ø 1,5-1,9 mm 3,5-4 Atm HVLP: 2-2,5 Atm N° coats:1-5	1 h at 20°C	50-70µ	16 h at 20°C	7,5 m ² /l at 60 µ dry film thickness

Description

Primer

2K epoxy primer. Used for hull protection in the paint processes on steel, wood, zinc-coated steel, aluminium, light alloys and gelcoat boats. It can be used on the ship's bottom (under the waterline) as well as on topside (above the waterline). On fibreglass boats it avoids osmosis formation and helps antifouling adhesion.

Colour

Available in the following colours: S74155 white; S74157 red and S74158 grey.

Characteristics

- Very fast drying
- Multipurpose application
- Very good adhesion
- Good sanding

Specific weight (part A): 1,35 ± 0,05 g/ml

Specific weight (part B): 0,97 ± 0,03 g/ml

Substrate preparation

Steel

Sanding disc Sa 2,5

Gelcoat

Dry sanding with P120-180 paper

Wood

Sanding with P120 paper

Zinc-coated steel

Rub down with red scotchbrite

Aluminium, light alloys

Sand blasting, disc sanding P-36

Application

By brush, roller, airless and spray with traditional spray gun or HVLP.

Relative humidity < 80%

Spray temperature >10 °C <35°C

Substrate temperature 5 °C >dew point

Mixing ratio

Brush or roller

		volume	weight
S741..	EPOXY PLUS	900 ml	925 g
S74156	EPOXY PLUS HARDENER.....	100 ml	75 g
S70171-00535	EPOXY THINNER.....	100-150 ml	50-100 g

Spray or airless

		volume	weight
S741..	EPOXY PLUS	900 ml	925 g
S74156	EPOXY PLUS HARDENER.....	100 ml	75 g
S70171-00535	EPOXY THINNER.....	150-250 ml	100-150 g

Pot life at 20°C: 7h

Ø conventional spray gun and HVLP 1,5-1,9 mm

Pressure: 3,5 – 4 Atm HVLP: 2 – 2,5 Atm

N° of coats: 1-5

Recommended film thickness as anticorrosive paint :50 - 70µ dry (n°2 coats by spray of 80 µ wet each)

Recommended film thickness as antiosmosis paint: 200-250 µ (n°5 coats by roller of 110 µ wet each)

Interval between coats: 16 h by roller/brush, 60' by spray

Theoretical coverage A+B : 7,5 m² for 1l at 60 µ film thickness

Theoretical coverage A+B+C : 6,4 m² for 1l at 60 µ film thickness

Solids content by volume A+B: 45,2 %

Solids content by volume A + B + C by spray: 38,1%

Drying

	10°C	20°C	35°C
Sanding after	32 h	16 h	8 h
Overcoat with Epoxy Plus	min. 2 h max. 96 h	min. 1 h max. 48 h	min. 30' max. 24 h
Overcoat with epoxy Filler	min. 16 h max. 96 h	min. 8 h max. 48 h	min. 4 h max. 24 h
Overcoat with Undercoat PU	min. 16 h max. 96 h	min. 8 h max. 48 h	min. 4 h max. 24 h
Overcoat with Antifouling	min. 16 h max. 96 h	min. 8 h max. 48 h	min. 4 h max. 24 h

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