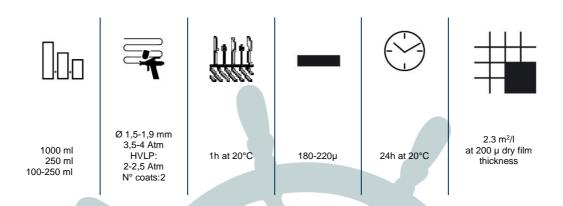


# S2402. EPOXY HIGH PROTECTION



# **Description**

#### **Primer**

2K high build epoxy primer. Used for hull protection in paint processes on steel, aluminium and gelcoat boats. It offers a very good barrier to water and it can be used on the ship's bottom (under the waterline) as well as on topside (above the waterline). Especially suitable to insulate the filler, it allows to obtain a high protection level with a limited number of coats. On fibreglass boats it avoids osmosis formation and it favours antifouling adhesion.

#### Colour

S24020 White S24021 Grey

## **Characteristics**

- Very good filling power
- Very good overcoating without sanding
- · High vertical stability
- · Very good impermeability

Specific weight (part A):  $1,65 \pm 0,05$  g/ml Specific weight (part B):  $0,91 \pm 0,05$  g/ml

#### **Substrate preparation**

#### Steel

Sanding disc Sa 2,5 **Aluminium, light alloys**Sand blasting, disc sanding P-36 **Gelcoat**Dry sanding with P120-180 abrasive paper



#### **2K** epoxy primers Stoppani Sand dry with P240-280 abrasive paper **2K** epoxy fillers Stoppani Sand dry with P180-220 abrasive paper

### **Application**

Airless or spray with traditional spray gun or HVLP, by brush or roller.

Application conditions: Relative humidity < 80% Spray temperature >10 °C <35°C Substrate temperature 5 °C >dew point

#### Mixing ratio

Conventional Spray					
	•	volume	weight		
S24020-21 S24022 S70171-00535	EPOXY HIGH PROTECTIONA EPOXY HIGH PROTECTION HARDENERB EPOXY THINNER	1000 ml 250 ml 100-250 ml	1000 g 140 g 50-125 g		
Airless/Roller		volume	weight		
S24020-21 S24022 S70171-00535	EPOXY HIGH PROTECTIONA EPOXY HIGH PROTECTION HARDENERB EPOXY THINNER	1000 ml 250 ml 0-100 ml	1000 g 140 g 0-50 g		

Pot life at 20°C: 3h N° of coats: 2

Recommended film thickness: 180-220µ dry (2 coats by spray of 200µ wet each) Minimum interval between coats: 24 h by roller or brush,1h by spray at 20°C

#### Airless/Roller

Air cap 0.3-0.38 mm, pressure 80-150 Bars

Solids content by volume mix A+B+C by spray Airless: 51.1 %

Theoretical coverage mix A+B+C by spray Airless: 2.6 m<sup>2</sup> for 1l mixture at 200µ film thickness

#### **Conventional Spray**

Ø conventional air cap and HVLP 1,7-1.9 mm Pressure: 3,5-4 Atm HVLP: 2-2,5 Atm

Solids content by volume mix A+B+C by conventional spray: 46.1 %

Theoretical coverage mix A+B+C by conventional spray: 2.3 m² for 1l mixture at 200µ film thickness

#### **Drying**

	10°C	20°C	35°C
Sanding after	48 h	24 h	12 h
Overcoat with itself by brush or roller	min. 48 h max 30 days	min. 24 h max 30 days	min. 12 h max 30 days
Overcoat with itself by spray	min. 2h max 30 days	min. 1h max 30 days	min. 30' max 30 days
Overcoat with Filler Epox Resolution Primer Undercoat PU ISM Top Coat Antifouling	min. 32h max 30 days	min. 16h max 30 days	min. 8h max 30 days

# TECHNICAL DATA SHEET N° S219-GB UPDATED 06/2022

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