







S2402. EPOXY HIGH PROTECTION

					
1000 ml 250 ml 100-250 ml	Ø 1,5-1,9 mm 3,5-4 Atm HVLP: 2-2,5 Atm N° coats:2	1h at 20°C	180-220µ	24h at 20°C	2.3 m ² /l at 200 µ dry film thickness

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 ± 0,05 g/ml
Specific weight (part B): 0,91 ± 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	EPOXY HIGH PROTECTION.....A	1000 ml	1000 g
S24022	EPOXY HIGH PROTECTION HARDENER B	250 ml	140 g
S70171-00535	EPOXY THINNER..... C	100-250 ml	50-125 g

Airless/Roller

		volume	weight
S24020-21	EPOXY HIGH PROTECTION.....A	1000 ml	1000 g
S24022	EPOXY HIGH PROTECTION HARDENER..... B	250 ml	140 g
S70171-00535	EPOXY THINNER..... C	0-100 ml	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 m² 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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