

# 1803 EPOX LUCIDO

GLOSS EPOXY ENAMEL



Two-component



Spray



See warnings



Airless

## Description and Use

Two-pack epoxy-polyamide coating featuring good elasticity and abrasion resistance.

If outside exposed it will chalk like all epoxy products; this phenomena doesn't affect the resistance features.

Recommended for painting machine-tools, metal furnishings, etc.; suitable to protect surfaces placed in industrial premises (like chemical plants) and in contact with chemical weapons such as solvents, mineral oils, gasoline, diluted acids, sodium hydroxide, ammonia, etc.

It can be coloured using the ADVANCE HT tinting system.

## Substrate preparation

### IRON SURFACES:

- Sand-blasting SA2.5 grade or careful mechanical cleaning followed by solvent degreasing, then apply a first coat of primer FONDO EPOX code 1806.

### GALVANIZED STEEL AND STAINLESS STEEL:

- Remove iron scale and foreign matters. Degrease carefully with organic solvents and apply FONDO EPOX code 1806 before the enamel EPOX LUCIDO.

### ALUMINIUM AND LIGHT ALLOYS:

- Chromate or phospho-chromate conversion coating; otherwise, mechanical cleaning by sanding followed by degreasing with a solvent. Then apply the primer as above described.

In case of applications over existing paints make an adhesion test.

## Application

### Application method:

- air mix spray gun with nozzle Ø 1.5-1.7 mm and pressure of 1.5-2.5 bar.
- airless

### Product preparation:

Stir thoroughly the Part "A" to achieve even colour and consistency.

Then mix with the Part "B" INDURITORE PER EPOX code 1871 in the ratio of 100:25 by weight.

Dilute with 1612 DILUENTE PER EPOX:

- 15-20% for air mix spray gun
- 0-5% for airless spraying

## Storage life

If stored in a cool, dry place, away from sources of heat and sheltered from sunlight, in its sealed original packaging, the product has a shelf life of 24 months. Check the product's shelf life by referring to the production batch number shown on the packaging. The batch number is made of eight numeric characters in which the first four digits identify the year and month of production. Once the product has expired, it must be disposed of in accordance with the current legislation.

## Technical features

|                                                                                                      |                                       |
|------------------------------------------------------------------------------------------------------|---------------------------------------|
| Colour                                                                                               | see price list                        |
| Appearance of the dry film                                                                           | glossy                                |
| Gloss                                                                                                | > 90 gloss (Gardner 60°)              |
| Type of product                                                                                      | two component                         |
| Pot-life                                                                                             | 4 hours                               |
| Viscosity **                                                                                         | 2000-3000 mPa.s Brookfield rpm 20 s 4 |
| Recommended thicknesses                                                                              | 60 µm dry film                        |
| Practical cover rate *                                                                               | 5-6 m²/kg per two coats               |
| Air drying (20°C and 65% R.H.)                                                                       | 30-40 minuti, dust free               |
|                                                                                                      | 5-6 hours, touch dry                  |
|                                                                                                      | 24-36 hours, through drying           |
| Oven drying (80-100°C)                                                                               | 30 minutes, through drying            |
| Maximum chemical resistance                                                                          | after 7 days                          |
| AFNOR NF T 36-005 classification                                                                     | Family I - Category 6b1               |
| * The cover rate is calculated on the suggested thickness and applied on plane and regular surfaces. |                                       |
| ** May change according to the colour.                                                               |                                       |
| The data are measured at a temperature of 20°C.                                                      |                                       |

## Warnings

- **The product contains synthetic polymer microparticles (SPM).**
- **INSTRUCTIONS TO PREVENT THE RELEASE OF SYNTHETIC POLYMER MICROPARTICLES INTO THE ENVIRONMENT**
- **In accordance with Regulation (EU) 2023/2055, please follow the procedures below to prevent environmental release.**
- During use and application, avoid accidental release of the product onto soil, into drains, or household wastewater. Apply the product only to the surfaces to be treated.
- Any remaining product should be stored by tightly sealing the original container. Dispose of the product/container in accordance with national regulations.
- If you wish to reuse the tools used for application, follow these steps to clean them in an environmentally responsible manner.
- The water, solvents or thinners used for cleaning tools, as well as any product residues, **MUST NOT** be released into the environment or poured down domestic drains.
- Remove as much product as possible from the tools used.
- Soak the tools in hot water or in solvent for at least a couple of hours, then remove them from the container.
- Allow the water in the bucket to evaporate and let the tools dry. For solvent-based products, close the container. Do not release the product into the environment and do not pour it into drains.
- Deliver the container with any remaining product / wash water / solvent / cleaning thinner to an authorised waste collection centre, in accordance with national regulations.

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## Warnings

- Do not apply when the temperature is below + 8°C (47°F) and the relative humidity exceeds 80%.
- Like all this kind of products, high humidity and low temperatures during application can damage the features and drying of the film.
- Do not use this product with tinting pastes 1895 4402 GIALLO S GL and 1895 7258 ROSSO S RL.
- For industrial use only.
- Exclusively for use not restricted from Directive 2004/42/EC.
- Always read the safety datasheet before use.
- For use with aluminium pastes, contact the paint mixing service.
- It is recommended to acquire all the material required to finish the work of the same batch.
- The information provided on this technical datasheet is based on our technical and practical knowledge and experience. The technical data refer to the average characteristics of the basic product and are determined under controlled laboratory conditions. The variability of the raw materials available on the market and the tinting of the product can lead to slight deviations in the declared values, in the colour and in the aesthetic effects obtained. It is therefore necessary for the purchaser/user to personally verify, before application, the suitability of the product for the intended use, in particular when different batch numbers of the same material are used in the same work/site.

The above mentioned data are meant to facilitate our customers in the use of our products. IMPA is not responsible for applications of products carried out beyond its direct control. For further technical information about specific systems and/or special applications, please contact our TECHNICAL SERVICE at [assistenza.technica@impa.it](mailto:assistenza.technica@impa.it).