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## PRODUCT DATA SHEET

**PRODUCT:** **EPORUST BC**  
**Two-component zinc phosphate epoxy-polyamide primer**

**CODE:** **COMP. A 145 EPORUST BC**  
**COMP. B 900012 - CAT EPOX PR 12**

**PRODUCT DESCRIPTION:** Two-component epoxy-polyamide anticorrosive primer for general use on steel protection. It has excellent chemical resistance (oils, fuels, detergents, fertilizers) as well as an excellent impact resistance, scratch and abrasion. It is used in all cases in which the request is an effective anti-corrosion action, even in severe conditions. It is also used as an intermediate or tie coat on inorganic zinc in three- or more layer cycles and is also overcoatable after long period of time. Not recommended for continuous immersion service.

**SURFACE PREPARATION:** For particularly harsh operating conditions we recommend a white metal blasting (grade Sa3). For less severe conditions an almost white metal (grade Sa 2½) is enough. A commercial blasting or alternatively a good quality mechanical cleaning are often acceptable. The product must be applied strictly on dry surfaces, clean, perfectly free of oil, grease, dust, moisture or other contaminants.

**APPLICATION METHODS:** Spray, brush or roll. Preferred application is airless spray. Brush or roller don't grant an uniform coverage, use these techniques only on retouch or small surfaces.

<b>APPLICATION INSTRUCTIONS:</b>	<b>CONVENTIONAL SPRAY LOW PRESSURE PUMP</b>		<b>AIRLESS AIRMIX</b>	
	Nozzle diameter (mm)	<b>1,8÷2,2</b>	Pressure ratio	<b>28:1</b>
Product pressure (Atm)	<b>1,0÷1,7</b>	Nozzle diameter (inch)	<b>0,013÷0,017</b>	
Air pressure	<b>3,5÷5,0</b>	Product pressure (Atm)	<b>160,0÷190,0</b>	



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## TECHNICAL DATA:

	<b>Evaporation of the solvent and chemical reaction</b>
Mechanism of hardening	
Specific weight (kg / l) *	<b>1,45 (±8%)</b>
Volume solids (%) *	<b>54 (±1%)</b>
Medium dry film thickness (microns)	<b>80 ±20</b>
Correspondence wet film thickness (microns)	<b>148</b>
Yield to the average or recommended thickness (m <sup>2</sup> / kg) *	<b>4,66</b>
Yield to the average or recommended thickness (m <sup>2</sup> / lt) *	<b>6,75</b>
Consumption at the average or recommended thickness (Kg / m <sup>2</sup> ) *	<b>0,21</b>
Consumption at the average or recommended thickness (lt / m <sup>2</sup> ) *	<b>0,15</b>
Touch dry at 25 ° C (min)	<b>60</b>
Recoat time min. recommended 25 ° C (hours)	<b>5</b>
Recoat time max. recommended 25 ° C (days)	<b>5</b>
Hard dry at 25 ° C (days)	<b>24</b>
Recommended application temperature (° C)	<b>+10 ~ +40</b>
Maximum operating temperature (° C)	<b>105</b>
Pot life at 25 ° (hours)	<b>6</b>
Mixing ratio by weight	<b>20%</b>
Mixing ratio by volume	<b>35%</b>
Thinner	<b>603.0000</b>
Aspect of the film	<b> matt</b>
Color	<b> On request</b>
Storage in suitable conditions (months)	<b>12</b>

N.B.

\* Data referred to colour white. The solid content values, specific weight and yield were calculated with theoretical method. Thickness and performance are only indicative, in fact vary greatly depending condition of substrate, dilution, absorption, porosity, surface irregularities and application method. Data referred to the mixture of component A + 20% by weight of Comp.B



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#### ADDITIONAL INFORMATION:

This is a two-component product. Before mixing the two components it is recommended to homogenize the component possibly with agitator and shake vigorously, possibly without opening, the packaging of component b. After mixing and addition of appropriate thinner, agitation should be continued until it became homogeneous. In order to use the correct mix ratio, necessary to obtain the best results, we recommend to catalyse only entire packs. In case you want to use only a portion of the pack, you should equip with adequate precision scale for catalysis by weight and appropriate sized containers for catalysis by volume. The pot life (time of use after catalysis) is significantly reduced by increase of temperature. Ambient temperature has influence on curing time which, under 10° C is extended considerably. Epoxy products are not suitable to use at low temperatures (typically under 5-8° C), except through the use of a specific catalyst (winter grade). The temperature of the surface to be treated must be at least 3° C higher than dew point. If this condition is not met the resulting condensation, not always visible, may easily lead to phenomena of non-adherence. The coating requires a period of 7-15 days at 25° C for complete curing. Carefully remove any accumulated roughness prior to the application of subsequent coats. It is recommended to implement all necessary measures (development of equipment for painting, using any thinner retardant-wetting thinner, position yourself upwind, proper progression of the surfaces to be painted) to prevent the accumulation of dust coating, which if not removed causes inhomogeneity of the film.

#### IMPORTANT NOTE

All information contained in this form are the result of laboratory tests carried out under controlled conditions and well-defined and / or correspond to our most advanced and current technical and practical knowledge. this does not exempt the customer, given the variability of environmental conditions and personal systems of application, from carrying out their own investigations and to make their own eligibility checks. Mondial Color assumes no responsibility for any damage caused by improper use of the product. This sheet supersedes the previous editions.