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Material Safety Data
Sheets



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MADE IN ITALY

TECHNICAL DATASHEET

FONDO K391 - ITALYMARINE TM

Universal anti-corrosion primer

DESCRIPTION

Product Name (A)	FONDO K 391
Product Code	NF.PRI.K391
Product line	ITALYMARINE Anticorrosive Base Coat
Areas of use	Universal anti-corrosion primer Can be applied directly on: Iron, Aluminium, Copper, Galvanised iron, light alloys, fibreglass plastics and all pourous materials .

PRODUCT SPECIFICATIONS

Binder type	Two-component epoxy resins and zinc phosphates
Appearance	Opaque
Colours ^[1]	Transparent - Black - Blue
Supply Vx	23 ± 3" CF/4 at 20°C
Specific Density (A)	1,55 Kg/l (± 0,05)
Supply Viscosity	Thixotropic product
Dry residue (A+B)	64% (± 2%)

MEDIA PREPARATION

Porous materials	Air blow dust free fiberglass , wood , ceramic, concrete, gypsum, terracotta etc
Ferrous surfaces:	Sandblasting, or thorough mechanical cleaning followed by solvent degreasing
Galvanized steel:	Scouring or sanding followed by solvent degreasing.
Copper	Degreasing with solvents
Aluminium:	Mechanical cleaning by sanding, followed by solvent degreasing
Thermosetting resins	Degreasing with solvents
ABS:	Degreasing with solvents

APPLICATION FEATURES

Hardener (B)	CATALIZZATORE K501
Product Code	NF.CAT.K501
Mix ratio	20% in weight
Coloring	Coloring pastes can be added on request
Thinner	if needed dilute with epoxy thinner to achieve uniform consistancy and color
Application tools	Brush; Roller HVLP Airless spray - only PROFESSIONAL USE
Spay gun parameters	Nozzle tip 1,4 -1,8 mm Pressure at nozzle 300 bar /4351 psi
Reccomended Thickness	40-80 µm
Pot- Life at 20° C	8 hours. At higher temperature, pot-life decreases Dust free 30' -40'
Drying	Deep drying 24 -36 hours at 20 °C Drying Forced 30' -40' at 60°C- 80°C
Coating layers	One crossed hand coating
Theoretical yeild	11,5 m2/Lt or 7,9 m2/Kg to 50 µm dry
Repaintability ^[2]	minimum 8 hours - maximum 48 hours

STORAGE INSTRUCTIONS

Packaging	Tin cans 5kg ; 10kg ; 20 kg
Shelf life	Storage temperature min 10°C max 35°C
Product Stability	FONDO K 391 5 years in original package-unopened CATALIZZATORE K 501 3 years in original package-unopened
Safety Instructions	Read MSDS Material safety data sheet carefully before using products

[1] Upon request custom colors are available

[2] After 48 hours, a light sanding of the film is recommended to ensure good adhesion of the finishing coat.

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The Technical Data Sheet (TDS) is recommended to be read in conjunction with the Material Safety Data Sheet (MSDS)

