# ADHERPOX

TECHNICAL DATA SHEET

## Product description

Modified bi-component epoxy primer, ideal on both topside and bottom. Due to the presence of special raw materials, ADHERPOX is an excellent primer onto every type of support (including light alloys), and if applied in several coats it creates an excellent anti-corrosion barrier. An important characteristic of ADHERPOX is that it can be covered later in time: within 3 months with any type of antifouling and within 6 months with itself, without the need to be sanded.

## Product information

| | | |
|---|---|---|
| Finish | Matt | |
| Colour | White .153 | |
| Solids (by volume) | ASTM D2369 | 55 ± 2% |
| Specific gravity | UNI EN ISO 2811-1 | 1,30 ± 0,02 g/cm$^3$ |
| Flash Point | UNI EN ISO 13736 | 23 °C |
| VOC (calculated average contet) | ISO 11890-2/2006 | 411 g/l |
| Packaging | 0,75 – 2,5 Lt | |



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## Application and use

**SURFACE PREPARATION**

For surfaces in bad conditions already treated with paint products, it is important to completely remove the old cycle, up to the substrate

Steel: wash with fresh water by pressure (200-300 bar) and remove all traces of oil and grease. Preform a sandblasting treatment grade Sa 2½ (ISO 8501-1/3). For surfaces covered with shop-primer, perfectly intact and adherent, it is possible to perform a commercial sandblasting Sa 2 or a mechanical cleaning grade St 3 (ISO 8501-1/3). The recommended value of Rz roughness, obtained after blasting or mechanical cleaning, is 50 - 90 µm. Coat with ADHERPOX the metal treated with the above standard before it shows principles of oxidation or shade variation.

Aluminium, Lead and Alloys: Wash under pressure with fresh water (200-300 bar) and remove all traces of oil and grease. Sand with coarse-grained discs no. P 36 (mechanical cleaning) or, alternatively, carry out the sandblasting treatment, using suitable abrasives: the surface layer of the metal must be completely and uniformly renewed, removing any residual oxidation, and covered with ADHERPOX on the day of preparation. Be careful not to polish the surface without exceeding it with the engraving; the recommended roughness value of Rz is 50 - 90 µm (ISO 8503).

Wood: The support must be dry, the humidity of the wood must not exceed 18%. All surfaces to be painted must be clean, dry and free of contaminants. Sand with P80-P120 paper. Before applying ADHERPOX, blow with clean, dry air to remove any residual sanding and dirt.

Composite (fiberglass carbon fibre, etc.): Degrease the surface to be treated with a solvent or suitable detergent. Pressurize with fresh water and remove all traces of oil and grease. All surfaces to be painted must be clean, dry and free of contaminants. Sand with sandpaper no. P180 - P220 and primer the treated surface. Before applying ADHERPOX, blow with clean, dry air to remove any residue of sanding and dirt.



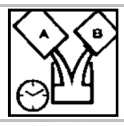
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## Application data

| | | | |
|---|---|---|---|
| Mixing ratio by volume |  | 3:1 | |
| Mixing ratio by weight<br>Base (comp. A) 6210.153<br>Hardener (comp. B) 6210.999 |  | 82 w/w<br>18 w/w | |
| Pot-life<br>NB: do not use this product when Pot-life time is exceeded |  | 5 h a 20 °C | |
| Thinner/Tool cleaning<br>NB: the indicated dilution % is considered on the catalyzed product |  | **6610** – Roller /Brush (5% max)<br>**6610** – Conventinal spray/Airless: (25% max) | |
| Application methods |  | Conventional<br>Pressure 3,5 bar<br>Nozzle 1,7 – 1,9 mm | |
| |  | Airless<br>Pressure 150 bar<br>Nozzle 0.3 – 0.6 mm<br>Angular range : 65° - 80° | |
| |   | | |
| Dry film thickness per coat<br>[on sanblasted as Bottom] | Dry | Standard application range | 100 – 200 µm |
| | | Recommended | 150 µm |
| | Wet | Standard application range | 180 – 360 µm |
| | | Recommended | 270 µm |
| Wet film thickness per coat<br>[on sanblasted as Primer] | Dry | Standard application range | 50 – 70 µm |
| | | Recommended | 60 µm |
| | Wet | Standard application range | 90 – 120 µm |
| | | Recommended | 110 µm |



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| | | |
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| Theoretical coverage | 150 µm | 3,6 $m^2/l$ |
| | 60 µm | 11 $m^2/l$ |
| Practical coverage [loss value 30%] | 150 µm | 2,5$m^2/l$ |
| | 60 µm | 7,7 $m^2/l$ |
| Notes | This product is provided in two tins to be mixed entirely and carefully before use. In case it is required, dilution has to be performed after the mixing of the two components. The physical data of two-component products refer to components that have been already mixed. | |

## Drying time

| Temperature°C | | | 10 | | 15 | | 20 | | 30 | |
|---|---|---|---|---|---|---|---|---|---|---|
| | | | Min | Max | Min | Max | Min | Max | Min | Max |
| Coverage | Adherpox |  | 8 h | 6 months | 6 h | 6 months | 4 h | 6 months | 3 h | 6 months |
| | AF | | 9 h | 3 months | 7 h | 3 months | 6 h | 3 months | 4 h | 3 months |
| Touch dry | | | 3,5 h | | 2 h | | 1,5 h | | 45 min. | |
| Depth dry | | | 30 h | | 18 h | | 12 h | | 8 h | |
| Full curing | |  | 10 days | | 7 days | | 7 days | | 7 days | |

**N.B.** *The drying times and the overcoating intervals increase with higher thickness of the applied film. Always check that the existing painting film is perfectly dry before applying a further product coat.*



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**CONDITIONS DURING APPLICATION**

In order to avoid the formation of condensation, the surface temperature should be at least 3 °C above dew point. During application and curing, the min. ambient temperature must not be lower than 10°C or higher than 30 °C; substrate temperature must not be lower than 5 °C, since curing is remarkably reduced at lower temperatures.
Application is not advisable when relative humidity exceeds 80%. The term-hygrometric survey should be carried out near the surface to be coated. Make sure there is enough ventilation when the application takes place in closed areas.

## Storage

It is recommended to avoid exposure to air and extreme temperatures. To maximize the shelf life in the can, it is worth checking that the container is well closed during the storage and the temperature is between 10 °C and 35 °C. Avoid exposure to direct sunlight.

## Safety rules

Observe the provisions of DPR 303 and 547. Avoid contact with the skin, for example. Operate in well ventilated places and, if in closed areas, use vacuum cleaners, fans and air conveyors. During the application use appropriate protections (masks, gloves, glasses, etc.). Before using, read sections 7-8 of the SDS.
INSTRUCTIONS FOR THE DISPOSAL OF PRODUCTS AND PACKAGING
Empty packaging that contained products: Dispose of empty packaging according to the requirements of the waste disposal law, for example by taking them to the recycling center.
Packages containing the unused products: Dispose of the unused product in accordance with the law of disposal of such waste, for example by taking it to a recycling center, recycling of packaging is prohibited in this case. Do not empty into drains or watercourses. Product packaging must be kept indoor, and the temperature in the storage place must be between 10 °C and 35 °C. Do not expose to sunlight.



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## Notes

The values indicated in the present technical sheet can have slight variations from one batch to another. All data refer to the mixed product. The applied product must not come in contact with water, chemicals or subjected to mechanical stress before the curing is complete. The above information is the result of accurate laboratory tests and practical experience; however, since the product is predominantly used outside the manufacturer's control, Boero Bartolomeo S.p.A. can only guarantee its quality. The information contained in this sheet may be subject to revision by the Company. For clarification, updates or further information, it is recommended to contact Boero Bartolomeo S.p.A. directly. The present datasheet annuls and replaces every other precedent to this one.



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