

1. DESCRIPTION

Impa Poly Epoxy Undercoat is a unique high performance two component urethane undercoat for use as an undercoat /build coat on a wide variety of suitably prepared and prime substrates to be finished with pigmented Impa Poly Epoxy Undercoats

2. PRODUCT FEATURES

- Excellent adhesion to variety of substrates
- Contains corrosion inhibitive pigments.
- Easily over coated with decorative epoxy or polyurethane twin-packs.
- Good pot life allows for flexibility during application.
- A high solid's coating

3. LIMITATIONS

- Not recommended for contact with strong acids and alkalis
- The product will discolour after long exposure to sunlight
- In early stages of curing, film may be susceptible to mechanical damage.

4. SURFACE PREPARATION

MILD STEEL

- All surfaces to be painted should be thoroughly degreased using **RESTORE HEAVY DUTY DEGREASER** followed by fresh water rinses.
- Abrasive blast cleans to Grade Sa 2½ of the ISO 8501-1:1988 with a blast profile not exceeding 50 µm or prepare steel mechanically so that the surface has a pronounced metallic sheen (Grade St3).
- Mechanical cleaning is not as effective as abrasive blasting and results in a shorter maintenance-free life.
- Apply 1 coat of **IMPA TUFFCOTE ZINC PHOSPHITE PRIMER** followed by 1 coat of **IMPA POLY EPOXY UNDERCOAT GALVANISED STEEL**
- Clean with **IMPA GALVANISED IRON CLEANER** to achieve water break-free surface and rinse thoroughly with water.
- Abrade lightly with fine grit paper and dust off.
- Then apply **IMPA ETCHING PRIMER** followed by **IMPA POLY EPOXY UNDERCOAT**

HIGH PERFORMANCE FINISHES

IMPA POLY EPOXY UNDERCOAT

ISSUED DATE: JUNE 2014, REV 1

TECHNICAL DATA

<i>Product Code</i> <i>Colour</i>	EP904 Base: White Activator: Pale Translucent
<i>Pot Life</i> <i>Appearance</i> <i>Shelf life</i> <i>Packaging</i> <i>Flashpoint</i>	45 min @23°C Sheen 24 Months 1L&5L 25 °C
<i>Viscosity</i> <i>S.G (weight)</i> <i>Solids per volume</i> <i>Solids per mass</i>	63– 65KU/23°C 1.21 – 1.23kg/l 58– 60% 47 – 49%
<i>Practical Spreading rate (depending on porosity)</i> <i>Recommended finishing coats.</i>	8-10 m ² /L per coat @ 55µm DFT 1 Minimum
<p>DRYING TIME</p> <i>Touch dry time</i> <i>Recoating Time</i> <i>Full Cure</i>	2 – 3 Hours at 23°C 6 – 8 Hours at 23°C 4 – 7 Days
<p>APPLICATION</p> <i>Roller & Brush</i> <i>Mixing Ratio</i>	Ready for use 4 Base: 1 Activator by Volume
<i>Cleaning</i> <i>Mixing</i>	IMPA PU Thinners IMPA PU Thinners if needed

ALUMINIUM

- Degrease with **RESTORE HEAVY DUTY DEGREASER** and rinse thoroughly with water.
- Abrade with 220 grit sandpaper to provide a key and dust off.
- Then apply **IMPA ETCHING PRIMER** followed by **IMPA POLY EPOXY UNDERCOAT**

FIBRE-GLASS

- Remove oil/wax with **RESTORE CLEANING THINNERS**
- Then sandpaper to an overall matt finish with 220 grit paper and wipe down again with **RESTORE CLEANING THINNERS**
- Apply **IMPA POLY EPOXY UNDERCOAT**

WOOD

- Surface must be clean and well sanded.
- Apply 1 coat of **IMPA POLY EPOXY UNDERCOAT** if finishing off with a pigmented enamel finish
- For a clean finish no undercoat is required

CEMENT OR CONCRETE

- Ensure that the surface is completely dry, firm, and free from dirt and grease.
- Then apply 1 coat of **IMPA POLY EPOXY UNDERCOAT**

5. MIXING

- Stir the base component well with a flat-bottomed paddle or mechanical mixer until product is uniform. Continue stirring and add the entire contents of the activator container. Continue stirring until the mixture is homogeneous.

6. APPLICATION

- **Brush:** Apply uniform, even coating with high quality brushes.
- **Rollers:** Apply uniform, even coating with a short pile roller.
- **Airless Spray:** Pump ratio – 30 to 1 min
Nozzle Orifice – 13 to 15 Thou
Tip Pressure -145 Bar Min
- **Conventional Spray:** Air Assisted Airless
Pressure Pot – Pressure Feed Gun
Gravity Feed Gun
Various Nozzle sets are available to suit guns

7. PRECAUTIONS

In order to limit minor colour variations from batch to batch, it is advisable to use product from the same batch on large open areas batch on large open areas. Batches may be factory blended on request.

- Application should be avoided in cold and moist weather conditions.
- **Do Not** apply the product at surface temperatures below 6°C (minimum of 2°C above dew point) and temperatures above 40°C
- **Do Not** apply if ambient temperature is less than 10°C or more than 40°C.
- **Do Not** apply if relative humidity temperature is less than 10°C or more than 85. °C
- Extremely cold conditions will make drying time longer
- Paint in area where there is good ventilations
- Do not smoke while painting
- Use only recommended thinner
- Discard any mixed material left over from the previous day

Environmental Health & Safety Information

DANGER! CONTAINS SULFAMIC ACID. CAN BURN EYES AND SKIN. SEVERELY HARMFUL IF SWALLOWED. HARMFUL IF INHALED. AVOID BREATHING IN DUST, MIST OR VAPORS. USE ONLY IN A WELL VENTILATED AREA. MAY CAUSE COUGHING, WHEEZING, THROAT IRRITATION, SHORTNESS OF BREATH, HEADACHE, NAUSEA OR VOMITING. DO NOT MIX CONTENTS WITH CHLORINE BLEACH OR ANY OTHER CLEANING PRODUCT OR DETERGENT. TO DO SO MAY EXPOSE YOU TO DANGEROUS GASES. MIX ONLY IN PLASTIC CONTAINERS.

Wear protective clothing, eyegoggles and acid resistant rubber gloves and footwear. Avoid contact with eyes and skin. **FIRST AID: If Swallowed:** Do not induce vomiting. Have victim drink lots of milk or water if conscious. Get medical attention immediately! **Eye and Skin Contact:** Flush immediately with plenty of water for at least 15 minutes; spread eyelids and occasionally flush underneath them. **Get medical attention immediately!** Remove contaminated clothing and shoes immediately. Wash contaminated clothing before reuse. If experiencing Respiratory Discomfort (e.g., throat irritation, coughing, wheezing); Remove victim to fresh air. Get medical attention immediately!

CAUTION: KEEP OUT OF REACH OF CHILDREN AND ANIMALS - DO NOT TAKE INTERNALLY.

Refer to Material Safety Data Sheet for additional health and safety information.

IN CASE OF FIRE: Use foam, CO2, dry chemical, or water fog.

SPILL – Absorb with inert material and dispose of as specified under **Thinning/Clean-up**.

DISCLAIMER

The technical information contained in this document are given in good faith and are meant to be used as a guideline by the specifier or user. Whilst we are confident about the quality of our products, we cannot accept any liability for the incorrect use or application of our products. Surface preparation forms an integral part of the scope of works and it is expected that the highest standards are maintained during surface preparation and application, to ensure that our products perform as intended. Always ensure to use the same product batch numbers, refrain from doing spot touch-ups and paint surfaces from corner to corner to prevent colour and sheen variance. As technology may change over time we reserve the right to change products to keep up with changes in raw materials or product trends without pre notice. Although we will always prevail to keep clients informed about changes to be made, but cannot bind ourself to such notes Please ensure the use of the latest Technical Data Sheet.

Please note: that all our latest Product Data Sheets and Material Safety Data Sheets are available for viewing on our website at www.impa.co.za. All information listed is owned or used under licence of Impa Paints and its related companies. © 2010 Lurama 149 (Pty) Ltd. All rights is reserved.