



AQUA 2C BIPOX PRIMER RAL1013



PRODUCT CODE: 5045

Description

Aqua 2C Bipox Primer is a waterborne 2 component corrosion-inhibiting adhesive primer based on epoxy resin and polyamide hardener.

Aqua 2C Bipox Primer is both lead and chromate-free.

Features

Aqua 2C Bipox Primer features excellent adhesion on a wide range of substrates, high mechanical and chemical resistance, and corrosion-inhibiting properties.

Uses

Extremely versatile adhesive primer for steel and non-ferrous substrates in, for example:

Mechanical engineering, illuminated advertising, trailer and chassis fabrication, agricultural machinery, and other industrial metal assemblies with demanding requirements on the protection and finish.

Specifications

(tinted product at 20°C)

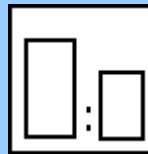
Colour	: cream (RAL1013)
Viscosity	: Viscous
Specific gravity	: approx. 1.45 kg/l
Solids content	: 62% wt./45% vol.
Flash point	: > 65° C
VOC content	: 51 gram/litre
Application conditions	
Minimum temp	: + 10°C
Max rel. humidity	: 70 %
(application & drying)	
Theoretical coverage	
(DFT= 40µm)	: 14.5 m ² / l
Shelf life in	
sealed packaging	: 12 months

APPLICATION INSTRUCTIONS



Surface preparation

The surface must be completely clean, dry, and free of grease and rust. First de-grease and sand old and intact paint layers. Grit-blast steel to surface quality SA 2.5 or mechanically brush to surface quality ST3.



Hardener:

Aqua 2C Bipox Primer Hardener

Hardener mixing ratio (base : hardener)

1.2 : 1 by volume
5 : 3 by weight

Mixing:

Intensively mix the base and hardener, without beating too much air into the mixture. Then allow the product to stand for 10 minutes (induction time).

Pot life:

Approx. 5 hours

Thinning: tapwater

Application methods and viscosity:

	Airless	Air spray	Brush / Roller
Water	0 - 5%	0 - 10%	0 - 5%
Viscosity DIN 6mm	60-100 sec	30-50 sec	-
Pressure	150-200 bar	3-4.5 bar	-
Nozzle	0.011"-0.013"	1.5-2.0 mm	-



Spraying instructions

If necessary, multiple cross-coats.

Recommended film thickness

Min. 70-180 µm wet
Min. 40-100 µm dry

Tool cleaning

Rinse immediately after application using water, followed by a rinse with Biqua cleaner. Then rinse thoroughly once more with clean tapwater.



Drying times (20°, DFT0µm)

Touch-dry	45 min
Handleable	3 hours
For overcoating	12 hours
Cured	7 days

Data at 20°C and 65% RH



Mixing instructions

<I> Intensively mix the base and hardener, avoiding beating air into the mixture.

Then allow the product to stand for 10 minutes (induction time). If a month or more passes before adding colour paste to the base, then the clear base product should first be gently stirred so that a good fluid mixture is created.

Top coats

A suitable enamel top coat must be selected that fulfils the requirements for the intended purpose of the object to be primed. Various 1 and 2 component BICCS Aqua products are available for this purpose

For a specific recommendation, please contact BICCS Almere.

If there is any doubt as to the suitability of an enamel top coat on Aqua 2C Bipox Primer RAL1013, and/or the adhesion of Aqua 2C Bipox Primer RAL1013 on a certain substrate, you should always paint a test area in order to verify the result.

Drying times

The drying time always depends on the temperature, humidity, ventilation and applied film thickness. Excessive humidity and temperature that is too low can lead to extended drying times. Adequate air ventilation over the substrate can have a very positive effect on the touch- and hard-drying of the product. The ideal conditions are a relative humidity of 65% and a drying temperature of 20°C.

Storage

This product must be stored frost-free. Freezing can cause irreparable harm to the quality of the product. To avoid deterioration, the product must be stored at a temperature no lower than 5°C and no higher than 40°C.

Special considerations

The hardener should be stored in the original, sealed packaging immediately after use.

Warning/restricted applicability

Considering the great diversity of purpose-specific aluminium alloys available in the market, it is impossible for us to recommend a single coating system that will apply to all kinds of aluminium. Our product data is generally based on pure, unalloyed aluminium, also known as the 1000 series.

Safety

See the appropriate safety sheet

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The information provided in this product data sheet is based on precision testing carried out in our laboratory, and is intended solely as a guideline. All recommendations and suggestions related to the use of products produced by BICCS, including but not limited to that provided in technical documentation or in response to a specific question, is based on data that we have compiled to the best of our knowledge.

The products and information are intended for users in possession of the required specific knowledge and industrial skills, and the suitability of any product for any purpose whatsoever remains at all times the responsibility of the end user. BICCS bv has no knowledge of the quality or condition of the substrate, nor of the many factors that can influence the use and application of the product. BICCS therefore accepts no liability of any kind pertaining to loss or damage as a consequence of using or referring to this data sheet, except where otherwise agreed in writing.

The data in this information sheet is subject to amendment, and is the result of practical experience and continuous product development. This data sheet replaces all earlier publications, and it is therefore the responsibility of the user to make certain that this sheet is the correct version for the product, before starting to use the product.



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INDUSTRIAL COATING & COLOURANT SYSTEMS

N.B. De technische gegevens in deze publicatie steunen op onze huidige kennis. Zij gelden als aanduiding en leveren u vrijblijvend een beeld van de toepassingsmogelijkheden van onze producten. De gegevens kunnen door een recentere uitgave gewijzigd worden.

Please note: The technical data in this publication are based on our current knowledge. These should be regarded as indicative, providing an impression of possible applications of our products without obligations. The data may be updated or changed in future editions.