









S24080 SOTTOFONDO 912

							
1000 ml 400 ml 100-250 ml (5+2+1)	Ford 4 22-25"	Ø 1,5-1,9 mm 3,5-4 Atm HVLP: 2-2,5 Atm N° coats: 2-3	20-30' at 20°C	80-100µ	12h at 20°C	p 280 p 360	6.3m ² /L at 90 µ dry film thickness

Description

Undercoat

2K sealing undercoat for dry-on-dry paint processes formulated with polyester resin. Suitable as an undercoat for finishing enamels in the yachting field, to seal and fill surfaces with different degrees of absorption. It can also be used as sealer on epoxy primers, before the topcoat, above the waterline (upper works).

Colour

White

Characteristics

- Very good adhesion.
- High hiding power.
- Good filling power.

Specific weight (part A): 1,65 ± 0,05 g/ml

Specific weight (part B): 1,05 ± 0,05 g/ml

Substrate preparation

Old thermosetting coatings (Verify resistance by PU solvent test)

Dry sanding with P240-280 paper

Epoxy primers

Dry sanding with P240-280 paper

Epoxy fillers

Dry sanding with P180-220 paper

Application

By brush, roller, airless and spray with traditional spray gun or HVLP.

Relative humidity < 80%

Spray temperature >10 °C <35°C

Substrate temperature 5 °C >dew point

Mixing ratio

Brush or roller

		volume	weight
S24080	SOTTOFONDO 912.....A	1000 ml	1000 g
S24081	SOTTOFONDO 912 HARDENER.....B	400 ml	250 g
S70030	DILATANTE 371.....C	100-200 ml	50-100 g

Spray or airless

		volume	weight
S24080	SOTTOFONDO 912.....A	1000 ml	1000 g
S24081	SOTTOFONDO 912 HARDENER.....B	400 ml	250 g
S70060	DILUENTE 911.....C	150-250 ml	100-150 g

Spray viscosity FC 4: 22-25"

Pot life at 20°C: 6h

Ø conventional spray gun and HVLP 1.5-1.9 mm

Pressure: 3,5 – 4 Atm HVLP: 2 – 2,5 Atm

N° of coats: 2/3

Recommended film thickness: 80-100µ dry (n° 3 coats by spray of 60µ wet each)

Minimum interval between coats: 8h by roller/ brush, 20-30' by spray at 20°C

Theoretical coverage mix A+B : 6.3 m² for 1lt mixture at 90µ dry film thickness

Theoretical coverage mix A+B+C: 5.4 m² for 1lt mixture at 90µ dry film thickness

Solids content by volume mix A+B 56.4%

Solids content by volume mix A+B+C 49,0%

Drying

	10°C	20°C	35°C
Sanding after	24 h	12 h	6 h
Overcoat after	min. 1 h max. 16 h	min. 30' max. 8 h	min. 15' max. 4 h

Overcoating

After drying and sanding the undercoat can be overcoated with topcoats from the **ISOFAN MARINE-GLASSTOP** series. In order to achieve the correct adhesion and gloss degree prepare the undercoat as follows:

One-coat solid finishes	Sanding with P280-320 paper
Two-coat effect finishes	Sanding with P320-360 paper

For sanding we recommend to use roto-orbital machines equipped with suitable suction system. In case of additional manual sanding we recommend to use sandpaper blocks with finer papers.

After sanding remove dust with compressed air and degrease with SM00800 ISOFAN MARINE DEGREASER with suitable clean cloths.

In order to assure the best paint process adhesion it is recommended to overcoat by 7 days after sanding.

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