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Technical Data Sheet

Product	E0-158-7101-010 #EPOSSIDICO LISCIO OPACO GRIGIO FONDO - EPOXY SERIES EQ PART OF QSC SYSTEM PE 0040, PE 0073, PE 0098, PE 0146
Series: EQ Group: EQ000000	**EPOXY THERMOSETTING PRIMER FOR INDOOR USE**

SPECIFIC PRODUCT PROPERTIES

CURE TEMPERATURE :	180	°C	Object temperature
CURE TIME :	20	Min	-
GLOSS AT 60 °:	10 - 25	% Units %	ISO 2813
THEORIC OUTPUT :	9.73	m²/kg	Thickness 60 µm
APPLICATION :	Tribo/Corona	-	-

Polimerization area (Object temperature)	Temperature (°C)	Min time (min)	Max time (min)
	170	20	35
	180	15	27
	200	8	15

GENERAL PROPERTIES OF THE SERIES

Fundamental product characteristics

The Epoxy Primer of this **Series** is based on high quality raw materials conveniently chosen to give the finishing good anticorrosion properties. The Primer is suitable for the protection of ferrous items and fulfils his maximum efficacy if accompanied by an adequate pre-treatment (zinc phosphating process or sand-blasting) of the painted article. For an excellent aesthetic quality of the painted product and/or to give the surface resistance against atmospheric agents and UV radiations, the Anticorrosive Primer can be overcoated with a suitable powder coating.
IMPORTANT: For a perfect inter-adhesion between Primer and finishing coat, the primer should not completely reticulate: we recommend only film fusion or, to the utmost, partial reticulation (for ex. 180°C x 5 min). The complete primer reticulation (180°C x 20 min) will be reached with the following reticulation of the paint final coat. If the topcoat is a river textured finish, it is advisable to adopt a different curing cycle for the primer in order to prevent its outcrop in the valleys of the river textured finish. The optimum curing cycle must be determined experimentally as influenced by the heating ramp of the oven.

Substrate preparation

Before the painting, the item should be adequately pre-treated in accordance with surface type, final use and required performances. The following table can be used as starting point for the pre-treatment choice.

Substrate	Indoor Use	Otdoor Use	Architecture
Aluminium	Soil removal, Chromate, Chrome-Free	-	-
Steel	Soil removal, Iron Phosphate, Zinc Phosphate, Sand-blasting	-	-
Zinc coated steel*	Acid attack, Iron Phosphate, Zinc Phosphate, Chromate	-	-

*If the powder has to be applied on galvanized steel, please contact the representative.

Particle size distribution

Powder coatings of this **Series** are characterized by an average particle size included between 30 and 40 microns. According to the customer's specific needs, specific particle size distributions can be supplied.

Typical applications

Powder coatings of this **Series** can be used for painting several products for indoor use.

Storage stability	The self-life of this Powder coatings Series, if stored in a dry place and at temperatures below 30°C, will be at least 36 months from production date. For product older than 36 months, it is recommended to check the characteristics before use.

General properties of the series (1)	**Regulation**	**Test result**
Impact Test (2)	ASTM D2794	2,5 Nm
Adhesion (2)	ISO 2409	GT0
Deep-drawing	ISO 1520	5 mm
Bending test (2)	ISO 1519	5 mm
Salt spray (3)	ISO 9227	1000 hours without film separation
Humidity test (3)	ISO 6270	1000 hours without film separation or blistering
Acetone	100 double passages with cotton wad	Limited resistance
Ethyl alcohol	100 double passages with cotton wad	Excellent resistance
Methylethylketone	100 double passages with cotton wad	Limited resistance
Perchloroethane	100 double passages with cotton wad	Limited resistance
Toluene	100 double passages with cotton wad	Excellent resistance
Trichloroethane	100 double passages with cotton wad	Limited resistance
Xylene	100 double passages with cotton wad	Excellent resistance
Acetic acid (10%)	Film immersion for 30 days	Excellent resistance
Citric acid (10%)	Film immersion for 30 days	Limited resistance
Hydrochloric acid (10%)	Film immersion for 30 days	Excellent resistance
Phosphoric acid (10%)	Film immersion for 30 days	Excellent resistance
Lactic acid (10%)	Film immersion for 30 days	Excellent resistance
Sulphuric acid (10%)	Film immersion for 15 days	Excellent resistance
Ammonium hydroxide (10%)	Film immersion for 30 days	Excellent resistance
Sodium hydroxide (10%)	Film immersion for 30 days	Excellent resistance

(1) All tests were performed on smooth glossy white powder without fillers sensitive to acids. For physical-chemical tests on specific codes please contact the Technical Direction of ST Powder Coatings.

(2) Tests carried out on Unichim steel panels with coating thickness of about 60 microns.

(3) Tests carried out on Bonder 26S/60/0C panels with coating thickness of about 60 microns.

Note 1

The information given in this Technical Data Sheet, based upon laboratory tests, is currently correct to the best of our knowledge. Since product application and conditions vary and are often beyond our control, we can guarantee only the product quality itself. In the light of continuous product improvement, ST Powder Coatings reserves the right to modify without notice the content of this technical sheet.

Note 2

The acronym RFG, if present in the description, indicates a product formulated with special additives that minimize the problems related to direct polymerization in gas ovens.

Note 2

The use in direct gas ovens can significantly reduce the interfacial adhesion with the topcoat.

Print date: 28/10/2026 Edition: EQ000000 - Valid at: 28/10/2026