

**DESCRIPTION**

- a two pack high build polyamide-cured recoatable, zinc phosphate pigmented epoxy primer
- approved to APAS-2971
- conforms to AS/NZS 3750.13

PRINCIPAL CHARACTERISTICS

- unlimited recoatability
- general purpose epoxy primer in protective coating systems for steel structures exposed to atmospheric conditions
- can be used as a one coat primer/finish
- can be recoated with two component and conventional coatings even after long weathering periods if free from chalking and contamination
- excellent rust preventing properties in polluted or coastal atmospheres
- tough, with long term flexibility
- will cure at temperatures down to -5°C although curing rate is reduced
- can be applied under high relative humidity conditions up to maximum of 95%
- excellent adhesion on steel and aged epoxy coatings
- easy application, both by airless spray and brush
- resistant to water and splash of mild chemicals
- may be applied over a damp substrate

COLOURS AND GLOSS

- Sand - semi gloss

BASIC DATA AT 25°C

- solids content approx. 63% by volume
- mix ratio 4A:1B by volume
- typical film thickness (per coat) 75-150 microns(dry) 120-240 microns(wet)
depending on system
- theoretical spreading rate 8.4 m²/l for 75 microns(dry) 4.2 m²/l for 150 microns(dry)
- touch dry after 2 hours
- overcoating interval refer overcoating table for details
- full cure after 4 days
- shelf life (cool and dry place) at least 12 months

RECOMMENDED CONDITIONS AND SUBSTRATE TEMPERATURE

- all surfaces to be coated must be clean and free from chalking and contamination
- oil and grease should be removed from all surfaces in accordance with AS 1627.1 solvent cleaning
- mild steel; blast clean in accordance with AS 1627.4 to Sa 2½ minimum (AS 1627.9), surface profile 40-70 microns
- if oxidation occurs between blasting and application, the surface should be reblasted to the specified visual standard
- surface defects revealed by the blast cleaning process should be ground, filled or treated in the appropriate manner
- previous suitable coat; dry and free from any contamination and sufficiently roughened if necessary
- at temperatures less than 0°C, ensure the substrate is free from ice
- substrate temperature must be at least 3°C above dew point

**INSTRUCTIONS FOR USE**

- mixing ratio by volume 4A:1B
- mix with EpinameL EH100 standard hardener only
- induction time - none if applied above 10° C
- induction time - 20 minutes if applied at temperatures below 10° C
- stir thoroughly after the induction time before using
- pot life at 25° C 6 hours. Do not use after this time even if the mix is still liquid
- stir the components and mixed product well using a mechanical mixer
- the temperature of the mixed product must be above 15° C, otherwise extra thinner may be required to obtain application viscosity
- too much thinner will result in lower sag resistance and slower cure
- thinner should only be added after mixing the components
- freshly catalysed material should not be added to product that has been mixed for some time
- for recommendations outside those contained in this data sheet, refer to WattyL

APPLICATION

- **AIRLESS SPRAY**
 - recommended thinnerL760
 - volume of thinnerup to 10%, depending on required dft
 - nozzle orifice.....approx. 0.48 mm (0.019 inch)
 - nozzle pressure 15 MPa (2100 psi)
- **AIR SPRAY**
 - recommended thinnerL760
 - volume of thinnerup to 15%
 - nozzle orifice.....1.5 - 2 mm
 - nozzle pressure0.3 - 0.4 MPa (50 - 60 psi)
- **BRUSH/ROLLER**
 - recommended thinnerL760
 - volume of thinnerup to 5%

The maximum dry film thickness that can be achieved when brushing/rolling is 75 microns
Multiple coats may be required to achieve the recommended dry film thickness
- **CLEANING SOLVENT**L760

SAFETY PRECAUTIONS

- flammable. Avoid contact with heat and naked flame
- avoid contact with skin and eyes
- use gloves, mask and goggles during application
- provide adequate ventilation when using in confined spaces
- this product is intended for use in industrial situations by professional applicators in accordance with the advice given on this sheet. All work involving the use and application of this product should be carried out in compliance with all relevant Health, Safety & Environmental standards and regulations and must not be used without reference to the Material Safety Data Sheet (MSDS)

**ADDITIONAL DATA****Overcoating table - with Epiname1 EB600**

Substrate temperature	5°C	15°C	25°C	35°C
Minimum interval	10 hrs	4 hrs	3 hrs	2 hrs
Maximum interval	unlimited when dry and free from chalking and contamination			

Overcoating table- with chlorinated rubber, polyurethane, catalysed acrylic, alkyd, and epoxy coatings

Substrate temperature	5°C	15°C	25°C	35°C
Minimum interval	5 days	2 days	16 hrs	8 hrs
Maximum interval	unlimited when dry and free from chalking and contamination			

Curing table

Substrate temperature	Dry to handle	Full cure
5°C	18 hrs	8 days
15°C	8 hrs	5 days
25°C	6 hrs	4 days
35°C	4 hrs	3 days

- Adequate ventilation must be continuously maintained during application and curing

Pot life (at application viscosity)

Paint temperature	Pot life
15°C	10 hrs
25°C	6 hrs
35°C	4 hrs

CUSTOMER SERVICE HOTLINE 132101 (Aust)

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