

EPINOX 22

Epoxy primer

Two component epoxy primer, containing active anticorrosion pigment - zinc phosphate.

For priming of steel, thermally sprayed steel, aluminum or galvanized constructions operating in sea, coastal and industrial environment.

The coating can be applied on not well cleaned surfaces. The coating is not sensitive to water (rain) when cured to touch dry degree. Cures at temperatures down to 0°C. Semi-gloss, flexible coating, tough and resistant to urban, marine and industrial environment. When exposed to sun radiation, the tint of the coating may change.



TECHNICAL DATA

Fields of application	Steel constructions		
Recommended substrate	Steel, Aluminium, Zinc		
Binder	Epoxy		
Solids	62±2% by volume		
Total mass of solids	Approx. 1150 g/l		
Volatile organic compound (VOC)	Approx. 350 g/l (DIRECTIVE 2010/75/EU) The VOC value provided is the average value for factory produced products, and consequently it will be subject to variations between individual products covered by this Technical Data Sheet.		
Theoretical spreading rate	Dry film (µm)	Wet film (µm)	Theoretical spreading rate (m²/l)
	100	161	6.2
	150	242	4.1
	As many of the paint's properties will change if too thick coats are applied, it is not recommended that the product is applied to a film thickness that is more than double of the thickest recommended film.		
Practical spreading rate	The values depend on the application technique, surface conditions, overspray, etc.		
Colours	TO-810 light grey		
Gloss (60°)	Semi-gloss		
Hardener	Comp. B: EPINOX 22 UTWARDZACZ		
Mixing ratio (A:B)	100:20 parts by volume		
Pot life, +23 °C	3 h		

Thinner

Not required. If necessary (eg. thickening of product) use TEKNOSOLV 9506.

Storage

The storage stability is shown on the label. Store in a cool place and in tightly closed containers.

DIRECTION FOR USE**Surface preparation**

Before cleaning of surface, it is recommended to wash it with water with addition of OLICLEAN 123 and then rinse with fresh water. The surfaces are prepared according to the different materials as follows:

STEEL SURFACES: The surface to be treated must be dry, salt- and grease-free, cleaned to the degree of cleanliness according to ISO8501-1, at least St 3 for external surfaces. For internal surfaces at least St 2 according to ISO 8501-1. Porous surfaces should be primed with thinned EPINOX 22 paint. Coating gets highest mechanical and chemical resistance when applied directly to sandblasted steel surfaces (cleanliness at least Sa 2½ according to ISO 8501-1).

STEEL SURFACES PRIMED WITH SHOPPRIMER: The surface to be treated must be dry, salt-, dust- and grease-free and free of contamination. Rust, mechanical, thermal damage or any defects of surface should be cleaned to the degree of cleanliness at least St 3 according to ISO 8501-1 for external surfaces. For internal surfaces cleanliness at least St 2. Shopprimed coating without visible defects, roughened mechanically.

NOT STABILIZED HOT DIP GALVANIZED STEEL SURFACES AND DRY ALUMINIUM SURFACES: The surface to be treated must be free of tarnish with non-metallic abrasive. All contamination eg. oil, grease, fluxing agent, etc. should be removed. Galvanized surface should be contaminant-free.

STABILIZED HOT DIP GALVANIZED STEEL SURFACES: The surface to be treated must be dry, dust-, grease- and salt-free, without any products of zinc corrosion (white rust free) and without any contaminants. For cleaning hot water, water under pressure, steam, abrasives or manual mechanic tool cleaning can be used.

THERMALLY SPRAYED GALVANIZED AND ALUMINIUM SURFACES: The surface to be treated must be dry, dust-, grease- and salt-free and primed immediately with thin layer of diluted EPINOX 22 or shopprimer, before any condensation occurs.

Additional instructive information for surface preparation can be found in standards EN ISO 12944-4 and ISO 8501-2.

Application method

Airless spraying, Brush

Application

Take into consideration the pot life of the mixture when estimating the amount to be mixed at a time. Before application the base and hardener are mixed in right proportion. Stir thoroughly down to the bottom of the vessel. Mixing by machine is recommended, for example a slow-rotating hand-drill equipped with a mixer. Inadequate stirring or incorrect mixing ratio results in imperfect curing and impaired film properties. Mix thoroughly components and wait 15 minutes (at 23 °C) before use.

Apply by airless spray or brush. When using a brush it may be necessary to apply several layers to achieve recommended coating thickness.

Airless spray parameter:

Nozzle size 0.017 - 0.023".

Nozzle pressure 20 - 25 MPa

When preparing painting specification, depending on subject and type of construction, different dry film thickness than recommended can be assumed. During airless spray application typical dry film thickness range is between 80 and 150 µm. Different dry film thickness than recommended causes change in theoretical spreading rate, wet film thickness, weight of dry film thickness, drying time, overcoating time and ready for handling time. In high corrosive environment it is recommended to prepare surface as best as possible and to apply successive layers of paint before full curing of previous layers to achieve best protection.

Application conditions

During the application and drying period the temperature of the surface shall be above 0 °C (frost- and ice-free surface) and at least 3 °C higher than dew point of the ambient air. The minimum temperature of the paint should be +15 °C and the relative air humidity below 95%. Adequate ventilation during application and drying period is recommended.

Drying time	+23 °C / 50% RH (dry film 100 µm)			
- dust free	after 1,5 h			
- touch dry	after 4 h			
- fully cured	after 7 days			
Overcoatable	Surface temperature	By itself		By topcoats
		Min.	Max.	Min. Max.
	0 °C	-	unlimited*	- unlimited*
	+5 °C	12 h	unlimited*	12 h unlimited*
	+10 °C	8 h	unlimited*	8 h unlimited*
	+20 °C	4 h	unlimited*	4 h unlimited*
<p>*if the coating is not chalked and is free of any contamination, there is no limit for overcoating. The best intercoat adhesion is when following coat is applied before the first one is totally cured. If the coating was exposed to atmospheric conditions or long-term solar radiation, the surface preparation should be focused on. Given indications relates to the recommended coating thickness, drying in good ventilation conditions. Overcoating times may be different with a change of temperature, ventilation, number of layers and the thickness of the coating.</p>				

Cleaning TEKNOSOLV 9506

HEALTH AND SAFETY

Safety and precaution measures See safety data sheet.

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