TEKNOS

EPINOX 98

Epoxy primer

Epoxy primer, MIO pigmented, thixotropic, two component paint.

For priming of steel or cast iron constructions operating in sea, coastal and aggressive environment. For self-protection of steel constructions or elements, in building industry, when high decorative value of coating is not required, water, sewage and petroleum products tanks, external surfaces of tanks and systems used in temperatures up to 160°C.

Semi-gloss, hard and resistant to mechanical factors coating. The coating is resistant to long term exposition to 160°C temperature. Coating resistant to water, salt and alkali solutions, oil, fuel oil, diesel, motor gasoline and some organic solvents. When exposed to sun radiation, the tint of the coating may change.

Machinery, Steel constructions, Storage tank







TECHNICAL DATA

Fields of application

Recommended substrate	Cast iron, Steel	Cast iron, Steel				
Binder	Ероху	Ероху				
Solids	62±2% by volume (ISO 323)	62±2% by volume (ISO 3233)				
Total mass of solids	Approx. 1350 g/l	Approx. 1350 g/l				
Volatile organic compound (VOC)	Approx. 375 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	Day (Hay (sup)	Wet film (μm)	Theoretical spreading rate			
	Dry film (μm)		(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-290 brown, TO-880 da	TO-290 brown, TO-880 dark grey				
Gloss (60°)	Semi-gloss .					
Hardener	Comp. B: UTWARDZACZ 897					
Mixing ratio (A:B)	100:46 parts by volume					
Pot life, +23°C	8 h					



Thinner	TEKNOSOLV 9506
Storage	The storage stability is shown on the label. Store in a cool place and in tightly
	closed containers.

DIRECTION FOR USE

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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-, grease- and
	dust-free, cleaned to the degree of cleanliness according to ISO 8501-1 at least
	Sa 2½ for constructions used in immersion and in the aggressive environment;
	at least St 3 for constructions used in the internal environment.
	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. Wait 15 min (at 23°C) before use. 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.
	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: 0.017 - 0.027"
	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 70
	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.
	The compartment must be closed during painting, afterwards must be
	ventilated as long as the odour is sensible.
Application conditions	During the application and drying period the minimum temperature of the
	ambient air, the surface and the product shall be above +5°C and the relative air
	humidity holow REV. Additionally, the temperature of the surface to be treated

During the application and drying period the minimum temperature of the ambient air, the surface and the product shall be above +5°C and the relative air humidity below 85%. Additionally, the temperature of the surface to be treated and the product must be at least +3°C above the dew point of the ambient air. Adequate ventilation during application and drying period is recommended.



Drying time +23°C / 50% RH (dry film 100 μ m)

- dust free after 3,5 h- touch dry after 8,5 h

- fully cured after 7 days

Surface	By itself		By topcoats	
temperature	Min.	Max.	Min.	Max.
+10°C	24 h	unlimited*	24 h	unlimited*
+23°C	12 h	unlimited*	12 h	unlimited*

*unlimited in internal conditions. It is a rule, that unlimited overcoating interval is for EPINOX 98. Due to higher sensitivity of topcoats to surface cleanness, overcoating time should be short. It is very important especially when applying non-epoxy systems or operating in aggressive environment. 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.

Cleaning TEKNOSOLV 9506

HEALTH AND SAFETY

Safety and precaution measures See safety data sheet.

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