EPIRUST

Epoxy Primer

Modified epoxy primer, cured with polyamide, two component.

For priming of steel, aluminium or galvanised constructions operating in sea, urban and industrial environment. For priming of steel, cast iron and aluminium constructions operating in immersion.

Flexible coating, with good adhesion to surfaces and resistant to mechanical factors. The coating resistant to weathering, water, salt and alkali solutions, oil, fuel oil, diesel, motor gasoline.

TECHNICAL DATA

Fields of application	Machinery, Steel constructions
Recommended substrate	Steel, Zinc, Aluminium
Binder	Epoxy
Solids	54±2% by volume (ISO 3233)
Total mass of solids	Approx. 1080 g/l
Volatile organic compound (VOC)	Approx. 450 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 (m^2/l)
40	74	13,5

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-250 red oxide, TO-930 dark grey
Gloss (60°)	Matt
Hardener	Comp. B: UTWARDZACZ 897
Mixing ratio (A:B)	100:40 parts by volume
Pot life, +23°C	6 h
Thinner	TEKNOSOLV 9506, TEKNOSOLV 564
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. STEEL SURFACE: cleaned to the degree of cleanliness according to ISO 8501-1: at least Sa 2½ for constructions operating in immersion and in aggressive environment, when long term protection is needed; at least Sa 2 for constructions used in atmospheric conditions; well attached tarnish rust is acceptable; St 3 for constructions used in atmospheric conditions. Dry, salt-, grease-, dust- and poor-attached-rust-free surface. NO STABILIZED HOT DIP GALVANIZED STEEL SURFACES AND DRY ALUMINUM SURFACES: should be tarnish with non-metallic abrasive. All contamination e.g. oil, grease, fluxing agent, etc. should be removed. Galvanized surface should be contaminant-free. STABILIZED HOT DIP GALVANIZED STEEL SURFACES: should be zinc corrosion products free (white rust free) and any contaminant-free. For cleaning hot water, water under pressure, steam, abrasives or manual mechanic tool cleaning can be used. The surface for painting should be dry, dust-, grease- and salt-free. THERMALLY SPRAYED GALVANIZED AND ALUMINUM SURFACES: should be dry and primed immediately with thin layer of diluted EPIRUST 2002, EPIRUST or shop primer, before any condensation occurs. The surface for painting should be dry, dust-, grease- and salt-free.
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 painting on wet or corroded surfaces it is recommended to apply first layer by brush.
Airless spray parameter:
Nozzle size 0.38 - 0.48 mm
Nozzle pressure 10-15 MPa.

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 35 and 60 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.

Application conditions

During the application and drying period the temperature of the ambient air, the surface and the product shall be above +5°C and the relative air humidity below 85%. Good ventilation should be provided. 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.

Drying time +23°C / 50% RH (dry film 40 µm)

- dust free after 1 h

- touch dry after 5 h

- fully cured after 7 days

Overcoatable

Surface temperature	By itself		By topcoats	
	Min.	Max.	Min.	Max.
+10°C	16 h	Unlimited	16 h	Unlimited
+23°C	8 h	Unlimited	8 h	Unlimited

It is a rule, that unlimited overcoating interval is for epoxy coatings. 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, TEKNOSOLV 564

HEALTH AND SAFETY

Safety and precaution measures See safety data sheet.

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The above information is normative and based on laboratory tests and practical experiences. The information is noncommittal, and we cannot accept liability for the results obtained under working conditions beyond our control, and consequently the buyer or the user is not released from the obligation to test the suitability of our products for specific means and application methods under the actual application conditions. Our liability covers only damage caused directly by defects in the products supplied by Teknos. This product is intended for professional use only. This implies that the user possesses sufficient knowledge for using the product correctly with regard to technical and working safety aspects. The latest versions of Teknos' Technical Data Sheets and Safety Data Sheets are available from our homepage www.teknos.com. All trademarks displayed on this document are the exclusive property of Teknos Group or its affiliated companies.