TEKNOPOX 82 (EPINOX 82)



Epoxy primer

Epoxy thixotropic primer, pigmented with zinc phosphate which improves adhesion to surfaces and anticorrosion properties, two component, cures at low temperatures (from -5°C).

For priming of steel constructions operating in coastal, urban and industrial environment.

Coating resistant to mechanical factors. When exposed to sun radiation, the tint of the coating may change.

TECHNICAL DATA

Fields of application	Steel constructions
Recommended substrate	Steel
Binder	Epoxy
Solids	81±2% by volume
Total mass of solids	Approx. 1460 g/l
Volatile organic compound (VOC)	Approx. 240 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)** 100 / 125 / 8.0 120 / 150 / 6.7 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-030 cream, TO-250 red oxide
Gloss (60°)	Semi-matt
Hardener	Comp. B: TEKNOPOX HARDENER 7466 (UTWARDZACZ 080/082)
Mixing ratio (A:B)	100:32 parts by volume
Pot life, +23°C	1,5 h
Thinner	TEKNOSOLV 1639

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 TEKNOCLEAN 123 (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: Sa 2½ for constructions operating in aggressive environment. In low aggressive environment in case of partial fitting damages, it is possible to prepare surface manually to at least St 3 according to ISO 8501-1. 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. 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 0.015 - 0.021". Nozzle pressure 15 - 20 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 180 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. It should be remembered that increasing the degree of cleanliness of the substrate extends the durability of the paint coating.

Application conditions	During the application and drying period the temperature of the ambient air shall be above -5°C, of the paint should be over +15°C and the relative air humidity below 95%. The minimum temperature of the surface shall be above -5°C (frost- and ice-free surface) and at least 3°C higher than dew point of the ambient air. Adequate ventilation during application and drying period is recommended.
Drying time	+23°C / 50% RH (dry film 100 µm)
- dust free	4 h
- touch dry	8 h
- fully cured	3 days

Overcoatable

Surface temperature	By itself		By topcoats	
	Min.	Max.	Min.	Max.
-5°C	40 h	1 month*	40 h	1 month*
0°C	36 h	1 month*	36 h	1 month*
+5°C	22 h	1 month*	22 h	1 month*
+10°C	16 h	1 month*	16 h	1 month*
+20°C	8 h	1 month*	8 h	1 month*

*in case of high temperature and sun radiation, the overcoating interval should be shortened to 1 week. When exceeded, the surface should be washed down, abrasive prepared by delicate sweeping with sand. 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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