TEKNOPOX 98 (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.



TECHNICAL DATA

Fields of application	Machinery, Steel constructions, Storage tank
Recommended substrate	Cast iron, Steel
Binder	Epoxy
Solids	62±2% by volume (ISO 3233)
Total mass of solids	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	<table><tr><th>Dry film (µm)</th><th>Wet film (µm)</th><th>Theoretical spreading rate (m^2/l)</th></tr><tr><td>100</td><td>161</td><td>6.2</td></tr><tr><td>150</td><td>242</td><td>4.1</td></tr></table> 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 dark grey
Gloss (60°)	Semi-gloss
Hardener	Comp. B: TEKNOPOX HARDENER 7497 (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

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 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. Enclosed spaces where TEKNOPOX 98 (EPINOX 98) has been used must be thoroughly ventilated both during and after painting; once the characteristic odour has dissipated, the spaces may be put back into use.
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 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 µm)
- dust free	3.5 h
- touch dry	8.5 h
- fully cured	7 days

Overcoatable

Surface temperature	By itself		By topcoats	
	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 TEKNOPOX 98 (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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