

DS 023

# EPINOX 82

## Epoxy Primer

3 01.01.2017

<b>PAINT TYPE</b>	Epoxy thixotropic primer, pigmented with zinc phosphate which improves adhesion to surfaces and anticorrosion properties, two component, cures at low temperatures (from -5°C).
<b>USAGE</b>	For priming of steel constructions operating in coastal, urban and industrial environment.
<b>SPECIAL PROPERTIES</b>	Coating resistant to mechanical factors. When exposed to sun radiation, the tint of the coating may change.

### TECHNICAL DATA

**Mixing ratio** Base (Comp. A): 100 parts by volume  
 Hardener (Comp. B): UTWARDZACZ 082 32 parts by volume

**Pot life; +20°C** 2 h

**Solids** 81±2% by volume

**Total mass of solids** abt. 1460 g/l

**Volatile organic compounds (VOC)** abt. 240 g/l

<b>Recommended film thickness and theoretical spreading rate</b>	Dry film (µm)	Wet film (µm)	Theoretical spreading rate (m <sup>2</sup> /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.

**Drying time at +23°C / 50% RH (for 100 µm dry film thickness)**

- dust free	after 4 h
- touch dry	after 8 h
- fully cured	after 3 days

**Overcoatable (50% RH , for 100 µm dry film thickness)**

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.

**Thinner** TEKNOSOLV 779

**Clean up** TEKNOSOLV 779.

**Finish** Semi-matt

**Colours** 030 cream 250 red oxide

**SAFETY MARKINGS** See Safety Data Sheet

**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: 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.

**Mixing of the components**

Take into consideration the pot life of the mixture when estimating the amount to be mixed at a time. Before painting the base and hardener are mixed in right proportions. Stir thoroughly down to the bottom of the vessel. Mixing by machine is recommended, for example a slow-rotating hand-drill equipment with a mixer. Inadequate stirring or incorrect mixing ratio results in imperfect curing and impaired film properties.

**Application conditions**

During the application and drying period the minimum temperature of the surface shall be above -5°C (frost- and ice-free surface), at least 3°C above the dew point of the ambient air. Minimum ambient air temperature -5°C. Maximum humidity 95%. Minimum paint temperature +15°C. Adequate ventilation during application and drying.

**Application**

Airless spray, brush. When using a brush it may be necessary to apply several layers to achieve recommended coating thickness.

Airless spray parameter:

Nozzle size	0,38 - 0,53 mm
Nozzle pressure	15 - 20 MPa

**ADDITIONAL INFORMATION**

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. Please note that increasing degree of cleanliness of surface results exceeding of coatings' durability.

The storage stability is shown on the label. Store in a cool place and in tightly closed containers. Additional instructive information for surface preparation can be found in standards EN ISO 12944-4 and ISO 8501-2.

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The information of this data sheet is normative and based on laboratory tests and practical experience. Teknos guarantees that the product quality conforms to our quality system. Teknos accepts, however, no liability for the actual application work, as this is to a great extent dependent on the conditions during handling and application. Teknos accepts no liability for any damage resulting from misapplication of the product. 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 version of Teknos data sheets, material safety data sheets and system sheets are on our home pages [www.teknos.com](http://www.teknos.com).

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