

EPIRUST ALU-STEEL PRIMER 2002

Issue: 18.10.2021

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CHARACTERISTICS Modified epoxy primer, fast curing with amine adduct, two component. Can be applied on wet and not well cleaned surfaces, humidity insensitive. The coating cures very fast even in low temperatures and is not sensitive to water (rain) when cured to touch dry degree.. High reactive coating with long pot life. 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 and some organic solvents. Coating resistant to the elements occurring in the cathodic protection.

PRODUCT USE Priming the hulls and equipment parts from steel, aluminum and cast iron.

PROPERTIES	Density (approx.), g/cm ³	1,3
	Flash point, °C	21
	Typical dry film thickness, µm	40
	Typical wet film thickness, µm	80
	Theoretical coverage at 100µm, dm ³ /m ²	0,08
	Volume solids (about), % vol.	51
	Recommended number of coats	1 - 3
	Volatile Organic Compounds, g/dm ³	380

Given data may vary slightly for different colours as well as due to normal manufacturing tolerances.

COLOUR 250 red oxide 840 metallic grey

SURFACE PREPARATION It is recommended to wash surface with water with addition of OLIVA CLEANER and then rinse with fresh water.

PAINT PREPARATION Stir thoroughly component I, mix with component II according to the following mixing proportions:

	by weight	by volume
component I	100	100
component II	15	22

Mix thoroughly components before use.

Pot life in 23°C: 6h

APPLICATION METHODS 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 - 0,48 mm
Nozzle pressure	15 - 20 MPa

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THINNING

Not recommended.

When necessary (for example – thickening product) use TEKNOSOLV 9506, TEKNOSOLV 564. (see Technical Information).

For cleaning tools: TEKNOSOLV 9506, TEKNOSOLV 564.

APPLICATION CONDITIONS

Application and curing conditions:

- minimum surface temperature: -5°C (surface frost- and ice-free),
- minimum temperature of paint itself +15°C,
- ambient temperature not lower than -10°C,
- relative air humidity below 95%,
- good ventilation.

The coating can be applied on wet and cold surfaces (temperature below dew point). The wet surfaces means:

- surfaces after hydroblasting;
- cold surfaces with temperature below dew point, without water observed.

Drying time (in 23°C):

- dust dry - 15 min,
- touch dry - 50 min,

Overcoating intervals (depending on coatings and exposure conditions):

epoxy coatings							
temperature	30°C	20°C	10°C	5°C	0°C	-5°C	-10°C
minimum	35 min	40 min	1h	3 h	5h	9 h	15 h
maximum	unlimited						

vinyl, acrylic, polyurethane coatings							
temperature	30°C	20°C	10°C	5°C	0°C	-5°C	-10°C
minimum	50 min	60 min	2 h	4 h	6 h	10 h	20 h
Maximum for C1 to C4 corrosive environment	unlimited						
Maximum for C5 corrosive environment	6 h	24 h	2 days	3 days	7 days	12 days	26 days

Due to higher sensitivity of topcoats to surface cleanness, overcoating time should be short, preferably as short as full cure coating time in related temperature.

To obtain good intercoat adhesion surface cleanest is needed. It is important in case of long overcoating intervals. When the coating was applied in unfavourable conditions (high humidity, insufficient ventilation) it is recommended to wash primer surface down with water and dry.

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.

Full cure:

temperature	40°C	30°C	20°C	10°C	5°C	0°C	-5°C	-10°C
time	3,5 h	14 h	38 h	60 h	4 days	8 days	14 days	28 days

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SUBSEQUENT COAT

Paint line BOSMAN

ADDITIONAL INFORMATION

- Depending on destination and type of construction, other thickness of a single layer can be assumed than recommended in information. Typical dry film thickness range using airless spray is from 35 to 90 microns. Changing the thickness of the coating changes the theoretical consumption, thickness, weight of dry coating, drying time, time of recoating and finishing work.
 - 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 is not recommended to apply EPIRUST ALU_STEEL PRIMER 2002 on wet or covered with drops surfaces.
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SHELF LIFE

The storage stability is shown on the label. Store in cool place and in tightly closed can.

CAUTION!

During application and drying of the coating flammable and health threatening substances are emitted. It is important to avoid inhaling the fumes of the product and contact with the eyes and skin. Use only in well ventilated rooms. Detailed information on dangerous substances contained in the products and threats connected with them are included in the specification cards of the dangerous substances, which we make available at the Customers' request.

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 versions of Teknos data sheets, material safety data sheets and system sheets are on our home pages www.teknos.com.