

PAINT TYPE

Epoxy primer, MIO pigmented, thixotropic, high solid, two component, cured in low temperatures (from -10°C). The coating can be applied on wet and poorly prepared surfaces, is not sensitive to water (rain) when cured to touch dry degree.

USAGE

For priming or self-protection of (when high decorative value of coating is not required): steel, aluminium operating in sea and industrial environment.
For renovation of old alkyd-, acrylic-, polyvinyl-, chlorinated rubber, epoxy- and polyurethane coatings.

SPECIAL PROPERTIES

The coating is flexible and mechanically resistant. The coating resistant to water, salt 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.

TECHNICAL DATA

Mixing ratio

Base (Comp. A): 100 parts by volume
Hardener (Comp. B): UTWARDZACZ 080 30 parts by volume

Pot life; +20°C

2,5 h

Solids

80±2% by volume

Total mass of solids

abt. 1340 g/l

Volatile organic compounds (VOC)

abt. 280 g/l

Recommended film thickness and theoretical spreading rate

Dry film (µm)	Wet film (µm)	Theoretical spreading rate (m ² /l)
100	125	8,0
150	187	5,3

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 +20°C / 50% RH (for 100 µm dry film thickness)

- dust free
- touch dry
- fully cured

after 3 h
after 6 h
after 3 days

Overcoatable (50% RH ;100 µm dry film thickness)

surface temperature	by itself		by topcoats	
	Min.	Max.	Min.	Max.
-5°C	34 h	unlimited*	34 h	unlimited*
0°C	24 h	unlimited*	24 h	unlimited*
+5°C	16 h	unlimited*	16 h	unlimited*
+10°C	12 h	unlimited*	12 h	unlimited*
+20°C	8 h	unlimited*	8 h	unlimited*

*It is a rule, that unlimited overcoating interval is for EPIRUSTIK 2000. 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. In case of chalking, it is recommended to remove degradation products.

Thinner

TEKNOSOLV 779

TEKNOS Sp. z o.o.

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Clean up	TEKNOSOLV 564.
Finish	Semi-matt
Colours	TO-250 red oxide, TO-820 ash grey, TO- 860 light grey , TO-330 mustard

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 PN-ISO 8501-1: Sa 2½ for constructions used in the aggressive environment, where long term protection is needed; St 3 for constructions used in the industrial environment; St 2 for constructions used in coastal and urban environment and for internal exposure. Surface dry and without any contamination (grease-, salt-, dust-free). It is possible to use it on wet surfaces. Porous surfaces primed with tinted EPIRUSTIK 2000.

Steel surface previously primed using shopprimer should be dry and free of contamination. Rust, mechanical, thermal damage or any defects of surface should be cleaned to Sa 2 according to PN-ISO 8501-1 for immersion, St 3 for external exposure. For internal surfaces cleanliness at least St 2. Surfaces covered with epoxy shopprimer without visible defects, abrasive blasted (submerged surfaces) or roughened mechanically (external surfaces). Surface dry, salt-, grease- and dust-free.

Dry aluminium surface, tarnished, grease-, salt- and dust-free.

Old coating grease-, salt- and dust-free. It is recommended to remove all loose parts and rust, wash it down with water under pressure. It is recommended to make small scale trials before application on wet surfaces or old coatings.

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. Wait 10 minutes (in 20°C) before use.

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 -10°C. Maximum humidity 95%. Minimum paint temperature +15°C. Adequate ventilation during application and drying. The coating can be applied on wet surfaces and surfaces with temperature below dew point. The wet surfaces means: surfaces after hydroblasting; cold surfaces with temperature below dew point, without water observed.

Application

Airless spray, brush. When using a brush it is recommended to dilute paint (3% of TEKNOSOLV 779) and it may be necessary to apply several layers to achieve recommended coating thickness. For wet and rusted surfaces it is recommended to apply first layer by brush.

Airless spray parameter:	Nozzle size	0,48 - 0,63 mm
	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 70 and 170 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.

EPIRUSTIK 2000 can be used as a stand-alone protection for internal surfaces of tanks if applied for minimum coating thickness of 300µm.

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 EPIRUSTIK 2000 on wet or covered with water drops surfaces.

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continuation is on the next page

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

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, safety data sheets and system sheets are on our home pages www.teknos.com.
