

Epifanes Epoxy Primer

Two-component anti-corrosive primer, based on epoxy resin and zinc phosphate as the anti-rust agent. For use on steel, aluminium, fiberglass and (ply)wood. Primer coat for any high performance two-component paint system. For interior and exterior use, above and below the waterline. High chemical and mechanical resistance.

Type	Drying and curing by reaction of components
Base	Epoxy resin, polyamide adduct, zinc phosphate.
Colour	White
Gloss	Semi gloss
Package	750 ml. - 2000 ml. - 4000 ml.
Density	1.62 kg/dm ³ (mixed product)
Solids content	50 ± 2 vol.% (mixed product)

Drying times -100 µm wft = 50 dft
at 20°C / 68°F 65% RAH -

Dust dry	Tack free	Recoatible	Fully cured
45 minutes	1 uur	12 hours	7 days

If next coat is applied within 5 days, no sanding is needed.
If this overcoating period is missed , first degrease the coat and sand with 120 grit abrasive paper used dry.

Recoatible With all Epifanes two component products.

	By volume	By weight
Base (component A)	100	100
Cure (component B)	25	14

Thinner Epifanes Thinner D-601
Potlife mixed produkt 8 hours at 20°C / 68°F
Application temperature 10°C / 50°F minimum

	Airless spray	Air spray	Brush / roller
Thinner	D-601	D-601	D-601
Volume.%	0 - 5	5 - 10	0 - 5
Nozzle	0.016" - 0.018"	1.5 - 1.8 mm	
Pressure in Bar	120-150	3-4	

Coverage 10 m² per litre @ 50 µm dry film thickness
Practical coverage is dependent on many factors, such as application method, roughness and condition of substrate, loss of material due to shape of object, conditions and circumstances during application, etc.

Guide lines for
brush application 90% of TC
spray application 70% of TC (large areas) - 50% of TC (small areas)

Recommended film thickness 80 - 250 µm wft (= 40 - 125 µm dft)

Surface conditions Surface must be clean, degreased, dry, well sanded and free of dust.
Remove all salt and other water soluble dirt with fresh water. Remove grease and oil with water and ammonium solution or Epifanes Spraythinner for Paint and Varnish or other suitable detergent.

Application conditions Temperature of paint, object and working area during application and drying should not be lower than 10°C / 50°F. Relative air humidity should not exceed 85%. Temperature of object during application and drying should be at least 3°C / 38°F above dew point.