

Epifanes Epoxy Primer

Two component primer for below and above the waterline



PRODUCT DESCRIPTION

A very tough modern two component zinc phosphate epoxy primer for above and below the waterline. This primer has excellent filling properties and still has a good flow. It has a great rust protection for steel, impregnates in to wood very well with a high protection. It also creates a tough and strong protection for GRP with a good osmose protection. It has a perfect adhesion to GRP. In addition, this is a fast drying primer and easy sandable.

Field of use: This primer can be used on all surfaces. With enough film building, this primer can completely seal the boat from water entering the surface of the boat. Above the waterline this primer gives a strong scratch resistance. This primer is unique in the way that it is recoatable with two pack and single pack.

PRODUCT INFORMATION

Type	Chemical drying						
Base	Epoxy resin with di-calcium phosphate						
Gloss	Semi gloss						
Colour	White						
Density at 20°C.	1.74gr. / dm³ (mixed product)						
Viscosity	100 seconds DIN-cup 4 mm						
Solids Contents	75 ± 2 vol. %						
VOC-level	439 grams/liter (mixed product)						
Packing	600ml. Component A + 150ml. Component B = 750ml. 1600ml. Component A + 400ml. Component B. = 2000ml. 3200ml. Component A + 400ml. Component B. = 4000ml.						
Mixing ratio	By weight : 100 parts Base component A + 14 parts curing component B By Volume: 100 parts Base component A + 25 parts Curing component B (4 : 1)						
Shelf life	In closed unopened container stored between 5 - 25°C Base component A 2 years after production date Curing component B 1 year after production date						
Rec. filmthickness	100 µm wet = 75 µm dry						
Potlife after mixing	<table><tr><th>15°C.</th><th>20°C.</th><th>25°C.</th></tr><tr><td>3 - 4 hours</td><td>2 - 3 hours</td><td>1 - 2 hours</td></tr></table>	15°C.	20°C.	25°C.	3 - 4 hours	2 - 3 hours	1 - 2 hours
15°C.	20°C.	25°C.					
3 - 4 hours	2 - 3 hours	1 - 2 hours					
Thinner brush	Epifanes D-601 Epoxy Thinner						
Thinner spray	Epifanes D-601 Epoxy Thinner						
Thinning in general	Thinning ratio depends on product temperature and working area. Avoid overthinning ratios, refer to the Epifanes paint systems.						

Drying times at 65% RLV	12°C.	15°C.	20°C.	25°C.
Dust Dry	4 hours	2 hours	1 hour	30 min.
Recoatable	18 hours 10 days	12 hours 7 days	6 hours 5 days	4 hours 4 days

If subsequent coat is applied within 548 hours, sanding is not required. After 48 hours always sand with P120 before applying a fresh coat Epoxy Primer. Do not use below 12°C. The above mentioned drying times are indicative at 65% RAH and 60 µm dry film thickness. Drying also depends on the amount of ventilation and applied wet film thickness. Higher wet film thickness and/or limited ventilation results in longer drying times. Especially flat surfaces may take longer to dry due to high wet film thickness. Allow each paint coat sufficient time to dry. Do not apply wet-on-wet!



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APPLICATION

Conditions during application Temperature minimal 12°C. - maximal 28°C.
Relative air humidity minimal 50% - maximal 75%

Best results are achieved by roller, longhaired soft brush or by spray. Evenly distribute the paint over the surface and do not retip. Do not apply wet-on-wet. Do not apply excessive wet film thickness to avoid the formation of curtains and drying problems. Avoid painting in direct sunlight or too much wind. A rapid loss of solvents will occur under these conditions and decrease the flowing ability. The maximum difference in temperature between the surface and the paint is 3°C. In case the product "pulls" and is difficult to apply, 10% Thinner D-601 may be added. After drying, firmly sand the surface with P180 before applying the next coat. Always sand by hand.

Guidelines for spray application	Nozzle	Pressure	Thinning ratio
Air spray	1.4mm	3 - 4 Bar	10-15%.
Airless Spray	0,419 - 0,525"	170-250 bar	0-2%

Surface conditions	steel	Completely remove rust, grease, dirt and other contaminants. Remove salt and other water-soluble dirt by thoroughly rinsing with clean water and high-pressure cleaner or an emulsifier. Remove grease and oil by cleaning with water and ammonia or another suitable cleaning agent. Coarse sanding P 60-80
	GRP	Degreased with Epifanes Polyester Degreaser and sanded P240
Additional remark		Sand every coat with dry sandpaper P180-220. On new aluminium it is recommended to apply 1 coat of Epifanes Wasprimer AQ.
Existing painted surface		Clean the surface well and degrease with Epifanes Spray Thinner. Follow by sanding the surface with P180-220. Always clean and degrease again with Epifanes Spray Thinner for Paint & Varnish.
Theoretical coverage		10m ² per liter @ 60 µm dry filmthickness
Practicle coverage		The total coverage is dependent on the wet film thickness, surface, application technique and use of any thinners.
Recoatable above the waterline		Epifanes Poly-urethane Primer - Epifanes Poly-urethane Yacht Coating Epifanes Epoxy HB Coat
Recoatable below the waterline		Epifanes Epoxy HB Coat - Epifanes Interimcoat
Fillers		Epifanes Epoxy Filler 1500 - Epifanes Epoxy Finishing Filler
Safety		The user of this product should obey all national laws and legislation concerning health, safety and environmental hazard. For more information on health and safety, refer to the Material Safety Data Sheet of this product.

Although the facts and suggestions in this product information sheet are based on our own research and field experiences and are believed reliable, we cannot simply be held responsible for performance or results obtained through the use of this product. Ineffectiveness or other unintended consequences may result, because of such factors as weather, conditions, presence or other materials or the manner of preparation, use or application all of which are beyond W. Heeren & Zoon's control. All such risks are assumed by user.

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