

Epifanes Epoxy Primer

Versatile two-component epoxy primer

Type	Chemical drying
Base	Epoxy resin with zinc phosphate
Properties	Anti-corrosive two-component primer with excellent adhesion on various surfaces. High filling, quick building and easy to sand.
Field of application	GPR - Steel - Plywood - Aluminium: Bonding and filling primer for interior and exterior use above and below the waterline. Also for maintenance of existing epoxy systems.
Colour	White
Gloss	semigloss
Density	1.62 /dm ³ (mixed product)
Viscosity	100 seconds DIN-cup 4 mm.
Solids contents	50± 2 vol.% (mixed product)
VOC-level mixed product	417 gram / liter (mixed product)
Packing	750ml. - 2000ml. - 4000ml.

Mixing ratio		By volume	By weight
	Base component A	100	100
	Curing component B	25	14

Induction time at 20°C. / 65% RLV Potlife after mixing	10-20 minutes		
	at 12°C	at 20°C	at 28°C
	12 hours	8 hours	4 hours

Shelf life unmixed In closed container stored in a dark location between 5 - 25°C. approx. 2 years

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

Temperature of substrate must be 3°C. above dew point.

Thinner brush / roller / spray Epifanes Thinner D-601

Thinner guideline Add thinner after mixing both components. Thinning ratio depends on temperature of mixed product and work area. For surface penetration on bare wood and steel, thin first coat approx. 25%

Application tools Nylon roller - Soft, longhaired brush - conventional and airless air spray.

Recommended filmthickness / coat 80 - 200 µm wetfilmthickness = 40 - 100 µm dryfilmthickness.

Application recommendations Do not apply wet-in-wet. Do not apply excessive wet films to avoid the formation of curtains and drying problems. Avoid applying in direct sunlight or too much wind. A rapid loss of solvents will occur under these conditions and decrease the flowing ability.

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Theoretical coverage 12 m² per liter. @ 50 µm dry filmthickness

Practicle coverage Dependent on condition of substrate, loss of material due to factors such as application technique, shape of object, circumstances during application.

Application details

	Air spray	Airless Spray	Brush / Roller
Thinning volume	10-20%	0-5%	0-5%
Nozzle	1.5 - 1.8 mm	0.015 - 0.020"	
Pressure	3 - 4	150-180 bar	
Viscosity DIN-cup 4 mm	20 - 25 sec.	30 - 35 sec.	

Drying times @ 50 µm dry filmthickness

	Dustdry	Recoatible	Through hardened
15°C. / 65% RAH	3 hours	16 hours	7 days
20°C. / 65% RAH	2 hours	12 hours	5 days
28°C. / 65% RAH	1 hour	10 hours	4 days

Intercoat sanding If subsequent coat is applied within 5 days (18°C.), intercoat sanding is not necessary. If recoated after 5 days, sand with P120 dry abrasive paper.

One-component recoatability After 24 hours and sanding with P220-240 dry abrasive paper.

Above the waterline Epifanes Poly-urethane Yacht Coating - Epifanes Poly-urethane Primer

Below the waterline Epifanes Epoxy HB Coat - Epifanes Interimcoat

Filler After 24 hours and sanding with P150-180 dry abrasive paper.

Epifanes Epoxy Filler 1300 - Epifanes Epoxy Filler 1500
 Epifanes Epoxy Filler LG 800 - Epifanes Epoxy Finishing Filler

Substrate conditions Clean, dry degreased and sanded .
 For optimum adhesion always thin first coat on bare plywood and metal by 20-25% and apply by stiff brush.

Safety The user of this product should obey all 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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