

EPOCOAT 21 PRIMER

Epoxy Primer

DATA SHEET 12/09

PROPERTIES AND RECOMMENDED USAGE

Paint type:

EPOCOAT 21 PRIMER is a two-component fast drying epoxy primer. It meets with the swedish standard SS 1852 01 for two-component paints.

Typical uses:

As a primer on blast cleaned steel surfaces in epoxy paint systems in corrosivity classes C2-C4 and C5-I and C5-M. Suitable also for zinc-, aluminium and stone based substrates. Can also be overcoated with polyurethane paints.

Most common SFS-EN ISO 12944-5 systems:

- A2.06 EPPUR120/2-FeSa2½
- A4.13 EPZn(R)EP160/3-FeSa2½
- A4.08 EPPUR240/3-FeSa2½
- A5I.02 EPPUR320/4-FeSa2½

Chemical resistance:

Used in recommended paint systems and correctly applied EPOCOAT 21 PRIMER withstands continuous immersion to water, mineral- and fuel oil, kerosene and non-alcoholic petrol as well as occasional splashes and spillage of weak process chemicals.

TECHNICAL DATA

Volume solids:	approx. 53 vol.%
Total mass of solids*:	approx. 980 g/l
VOC value*: (Volatile organic compound)	approx. 420 g/l

(*Values are calculated.)

Mixing ratio:

Resin 4 parts by volume
Cure 1 part by volume

Pot life: at +23°C

with Standard Comp.B: approx. 7 h after mixing
with S-Comp.B: approx. 3 h after mixing

Drying times: 70 µm	Standard Comp.B		S-Comp.B	
	+10°C	+23°C	+10°C	+23°C
Surface dry	2 h	½ h	½ h	15 min
To touch	10 h	4 h	4 h	1 h
To recoat				
- same type of paint	10 h	3 h	6 h	2 h
- Normadur HB / 65 HS / 90 HS / 80 Aluminium	12 h	4 h	8 h	3 h
- immersion service	24 h	16 h	24 h	16 h
Fully cured	12 d	7 d	12 d	7 d

Calculated theoretical coverage and recommended film thickness:

Dry	Wet	Coverage
50 µm	95 µm	10,5 m ² /l
70 µm	135 µm	7,4 m ² /l
100 µm	190 µm	5,3 m ² /l

Practical coverage:

Depends on wind conditions, structure to be painted, roughness of the surface and application method.

Colour: AL red, grey and offwhite*

Thinner and cleaner: OH 17

Finish: Matt

* Offwhite contains zincphosphate.

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APPLICATION INSTRUCTIONS

Surface preparations:

Ice, concrete, plaster and other solids should be removed by scraping or brushing. Remove salt and other water soluble contaminants by water cleaning with brush, high pressure, steam or alkali cleaning. Grease and oil should be removed by alkaline-, emulsion- or solvent cleaning (SFS-EN ISO 8504-3, SFS-EN ISO 12944-4).

Steel surfaces:

Blast cleaning to minimum of Sa2½ (SFS ISO 8501-1, SFS-EN ISO 8504-2).

Shopprimed surfaces:

Damaged or corroded surfaces should be blast cleaned to a minimum of Sa2½. (SFS-ISO 8501-2, SFS-EN ISO 12944-4).

Aluminium surfaces:

Remove grease, anodising residues and other contaminants. Sand-sweeping before painting improves adhesion.

Galvanized surfaces:

Remove grease, zinc salts and other impurities. Sand-sweeping before painting improves adhesion.

Primer:

EPOCOAT 21 PRIMER,
NORMAZINC SE

Top coat:

EPOCOAT 210, EPOTEX HB,
NORMADUR HB, NORMADUR 65 HS,
NORMADUR 80 ALUMINIUM,
NORMADUR 90 HS

Environmental conditions during application:

The surface should be dry and clean. During application and drying time the temperature of the paint, air, and surface should be above +10°C and the relative humidity below 80 %. The surface temperature should be min 3°C above the dew point of the air.

Method of application:

Use airless spray or brush. Stir resin and cure separately and then mix both components thoroughly. The mixing ratio is 4:1 (resin:cure) by volume. If needed, 0-15 % thinner (OH 17) may be added. High pressure airless spray with a nozzle tip of 0,013" - 0,018" orifice. Spray angle depending on the object to be painted.

SAFETY

Please follow the environmental and safety instructions displayed on the container and Safety Data Sheet.

Use under well ventilated conditions. Do not breathe or inhale mist, use respirator mask. Avoid skin contact. Spillage on the skin should immediately removed with suitable cleanser, soap and water. In case of contact with eyes, rinse immediately with plenty of clean water and if necessary seek medical advice.

For specific information on hazardous constituents and more detailed safety measures see Safety Data Sheet.

DISCLAIMER

The above information is given to the best of our knowledge based on laboratory tests and practical experience. However, as the paint is often used under conditions beyond our control, we cannot guarantee anything but the quality of the paint itself. We reserve the right to change the given data without notice.