

# Epifanes Epoxy Primer

## Versatile two-component epoxy primer

<b>Type</b>	Chemical drying
<b>Base</b>	Epoxy resin with zinc phosphate
<b>Properties</b>	Anti-corrosive two-component primer with excellent adhesion on various surfaces. High filling, quick building and easy to sand.
<b>Field of application</b>	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.
<b>Colour</b>	White
<b>Gloss</b>	semigloss
<b>Density</b>	1.62 /dm <sup>3</sup> (mixed product)
<b>Viscosity</b>	100 seconds DIN-cup 4 mm.
<b>Solids contents</b>	50± 2 vol.% (mixed product)
<b>VOC-level mixed product</b>	417 gram / liter (mixed product)
<b>Packing</b>	750ml. - 2000ml. - 4000ml.

<b>Mixing ratio</b>		<b>By volume</b>	<b>By weight</b>
	Base component A	100	100
	Curing component B	25	14

<b>Induction time at 20°C. / 65% RLV</b> <b>Potlife after mixing</b>	10-20 minutes		
	<b>at 12°C</b>	<b>at 20°C</b>	<b>at 28°C</b>
	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 m<sup>2</sup> 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
<b>15°C. / 65% RAH</b>	3 hours	16 hours	7 days
<b>20°C. / 65% RAH</b>	2 hours	12 hours	5 days
<b>28°C. / 65% RAH</b>	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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