

TECHNICAL DATA SHEET

EP-INTERMIOX

Revision date: 26/08/2025

Publication date: 14/04/16

Epoxy primer pigmented with iron oxide and inert fillers.
Excellent adhesion to irradiated or chemically pre-treated hot-dip galvanized steel.
Easy to apply in large layers
Application and hardening is possible at high relative humidity (up to 80%)?
Excellent chemical and mechanical resistance after hardening.

Application as an adhesion primer/sealer on zinc rich primer such as VIBOL ZINC 2, ZINC 3 and ZINKSILICAAT, further as a primer on hot-dip galvanized steel and coated steel. Can be painted over with almost any paint system, even after prolonged outdoor exposure

PRODUCT INFORMATION

Type of paint	Two components epoxyprimer/coating with polyamide adduct hardener
Finish	Satin
Colour	Grey
Density (Mixed product)	1.5 kg/L
Solids content (mixed product)	65 vol%
VOC (volatile organic compounds)	240 g/L
Recommended dry film thickness (dft)	50-100 µm
Recommended wet film thickness (wft)	85-165 µm
Theoretical spreading rate	
50 µm d.f.t.	12.0 m²/L
80 µm d.f.t.	7.5 m²/L
Practical spreading rate (Depending on several factors like shape of object, profile of surface, method of application, application circumstances and experience.)	Brush/roller : 85-90 % of the theoretical spreading rate Spraying : 50-70 % of the theoretical spreading rate
Flashpoint	>21°C
Dry temperature resistance	120°C

DRYING TIMES

For d.f.t. up to 100 µm at 20°C

	20°C
Dust dry	30 min
Transportable	16 hours
Complete hardening	4 days
Overpainted	
Minimum interval	10 hours
Maximum interval	Unlimited*

*provided that the surface is dry and clean

Film thickness, ventilation, temperature and relative humidity are of great influence on the drying times

APPLICATIONS-INSTRUCTIONS

Mixing ratio:	volume: base - hardener 4A - 1B weight: base - hardener 85 - 15
Mixing instructions:	Base and hardener should be mixed and applied at temperatures above 10°C At lower temperatures extra thinner is needed which gives a slighter resistance against sagging and which will delay hardening.
Induction time:	At 20°C not necessary At 10°C at least 10 minutes.
Pot life after mixing:	20 litre packing: 8 hours at 20°C
Application conditions	During application and hardening the temperature should be above 5°C to attain maximum resistance against chemical and mechanical influences.

Application at lower temperatures (down to -5°C) is possible, however hardening will take considerable more time and complete resistance will be achieved much later.

The surface should remain free from water and ice and the temperature of the surface should at least be 3°C above dew point.

During application and hardening in closed or small spaces, it is necessary to refresh the air continually to remove the solvent vapours, this because of drying, health and safety.

Usage information	Airless-spray	Airspray	Brush/roller
Type of thinner	Thinner EP	Thinner EP	Thinner EP
Recommended thinner	5-10 vol%	10-15 vol%	0-5 vol%
Nozzle orifice	0.41-0.46 mm 0.016-0.018 inch	2.0 – 2.5 mm	/
Nozzle pressure	150-180 bar	3-5 bar	/
Cleaning of tools	cellulose thinner	cellulose thinner	cellulose thinner

SURFACE CONDITIONS

Steel:	New steel: Blasting according to Sa2½ Roughness profile Ra 10-12 µm Rz 50-60µm Surface must be clean and dry. Repair and maintenance: Clean the surface thoroughly with suitable cleaning preparation or by steam cleaning. Remove salts and other watersoluble impurity by spraying with clean tap-water under high pressure. Remove rust a.o. by blasting Sa2½ or derust mechanical until St.2-3 Apply the advised paint system on a clean surface. - Mechanical or hand derusting gives less quality than blasting and will result in less protection of the applied paint system.
Hot-dip galvanised steel:	Blast with a fine, non-metallic blasting preparation until a level roughened surface is obtained, or chemical age of the surface(according to the directions of the manufacturer)

DURABILITY

At least 12 months, provided that it has been stored in closed original packing at a dry and cool spot.

PACKAGING

4 L + 1 L - 16 L + 4 L

These data have been drawn up to the best of our knowledge and were correct at the date of issue. However we cannot accept full responsibility, because the choice of products and circumstances during elaboration of the systems fall outside our judgement. This documentation sheet will not automatically be replaced in case of modification.