TECHNICAL DATA SHEET
EP-ZNF PRIMER

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2 Components high build epoxyprimer with zincphosphate..
High-grade anticorrosive, free from lead and chrome.
Excellent adherence on blasted or chemical pre-treated hot-dip galvanised steel.
Easy to apply in thick layers.
Curing at low temperatures up to 5°C.
Application en hardening is possible at high relative humidity up to 90%.
After hardening excellent mechanical resistance and elasticity.

Application as anti-rust primer for coating systems on steel constructions in aggressive industrial environment and as primer on hot-dip galvanised steel.

PRODUCT INFORMATION

Type of paint	Two components epoxyprimer with polyamide adduct hardener
Finish	Mat
Colour	Grey, white, redbrown, black, beige, …
Density (Mixed product)	Approx. 1.4 kg/L
Solids content (mixed product)	Approx. 60 vol%
VOC (volatile organic compounds)	280 g/L
Recommended dry film thickness (dft)	70-120 µm
Recommended wet film thickness (wft)	120-210 µm
Theoretical spreading rate	
70 µm d.f.t.	8.6 m²/L
120 µm d.f.t.	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

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DRYING TIMES

For d.f.t. up to 60µm

	20°C	10°C	5°C
Dust dry	1 ½ hours	2 hours	3 hours
Transportable	16 hours	24 hours	36 hours
Complete hardening	4 days	6 days	10 days

Recoatable with vinylcoatings, epoxy coatings and polyurethane coatings

Surface temperature	**20°C**	**10°C**	**5°C**
Minimum interval	6 hours	18 days	30 days
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

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.

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

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SURFACE CONDITIONS

Steel:	New steel: Blasting according to Sa2½ Roughness profile Ra 10-12 m Rz 50-60m 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 water-soluble impurity by spraying with clean tap-water under high pressure. Remove rust a.o. by blasing 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 blasing and will result in less protection of the applied paint system.
Hot-dip galvanised steel:	Blast with a fine, non-metallic blasting prepartation until a level roughened surface is obtained, or chemical age of the surface(according to het 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

1 L + 0,25 L - 4 L + 1 L - 16 L + 4 L

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