



EPODUX ST 71

Modified epoxy with zinc phosphate

DEFINITION

Primer or intermediate epoxy coat, 2 components, high solids, fast drying. Contains zinc phosphate.

INTENDED USES

Coating for the repair or newbuilding of existing systems for:

- bridges,
- silos,
- storage tanks,
- machine tools,
- etc.

PRINCIPAL CHARACTERISTICS

Good adhesion on :

- Sa 2 1/2 blasted steel.
- steel already coated, treated by Ultra High Pressure waterjetting
- old glyceros and epoxies in good condition
- galvanized steel, stainless steel
- aluminium.

Good filling, for applying layers up to 400 µm without sagging.

Note: the properties of the coating, apart from its appearance, are not affected by exposure to actinic radiation.

CERTIFICATIONS / APPROVALS

ACQPA : Brand ACQPA 27612

Is used in the following certified systems: C4ANV1518, C4ANV1520, C3ANV1519, C3ANV1521, C4AMV1518, C4AMV1520, C3AMV1519 and C3AMV1521.

TECHNICAL DATA

Gloss level	: Mat
Colours	: White, Gris, beige, brown red others please consult us.
Number of components	: 2
Mix ratio, by weight	: 91,7/8,3
Mix ratio, by volume	: 90/10
Specific gravity	: 1,47 +/- 0,05 g/cm ³
Solids volume	: 71 +/- 3%
Solids weight	: 73,5 +/- 2%
Typical thickness (dry)	: 80 µm - 280 µm
Typical thickness (wet)	: 110 µm - 400µm
Theoretical spreading rate	: 9,1 m ² /L for 80µm DFT



EPODUX ST 71

Modified epoxy with zinc phosphate

INSTRUCTIONS

SURFACE PREPARATION

New steel « heavy duty use »

Scraping / brushing mini St2, the performances of the coating will be improved by abrasive blasting to Sa 2 ½ according to ISO 8501-1 : 2007

Roughness profile

Medium Grit (ISO 8503-1) (Ra 10-12,5 µm)

Old coat

EPODUX ST 71 is adapted to recoat some old and undamaged paints. In all cases, it is necessary to perform a test of convenience (application followed by an adhesion test after complete drying) to validate the compatibility of products and surface preparation chosen.

Refer to COMPATIBILITY.

Galvanized steel / Aluminium

Sweep blasting or etching with METONET followed by rinsing with clean water

Stainless Steel

Sweep blasting.

Fine Grit (ISO 8503-1)

APPLICATION

Mixing : The product is delivered in pre-dosed kits. Pour the hardener part into the base can and mix, taking care not to add air. The recommended temperature of the mixture should be at least 15 ° C, otherwise it may be necessary to add thinner to obtain the application viscosity. Attention, an excess of thinner can cause a phenomenon of sagging.

Induction time : no

Working pot life :

Temperature	Time
10°C	4 hours
20°C	2 hours 30
30°C	1 hours 30

Substrate temperature : Between maxi 40°C and at least 3 °C above the dew point to avoid any risk of condensation.

Weather conditions : The temperature should be between 5°C and 40°C
The relative humidity should be between 0% and 85%

Technical note : Do not leave the spraying equipment in charge longer than the pot life. Rinse the material with 67-232 v02 Thinner and clean thoroughly with cleaning solvent. The can containing the prepared and unused mixture must not be hermetically sealed. In case of extended stop, it is better to prepare a new kit.

AIRLESS SPRAY

Thinner : 67-232 v02

Dilution : 0 à 10 %

Nozzle : 0.013 -0.017

Pressure at nozzle : 250-300 bars

Mini pump ratio : 60/1

AIR SPRAY

Thinner : 67-232 v02

Dilution : 10 à 20 %

Nozzle : depending on equipment used

Pressure at nozzle : 4-5 bars

BRUSH

Thinner : 67-232 v02

Dilution : 0 à 5 %

ROLLER

Thinner : 67-232 v02



EPODUX ST 71

Modified epoxy with zinc phosphate

Dilution : 0 à 5 %

CLEANING SOLVENT : 67-232 v02



EPODUX ST 71

Modified epoxy with zinc phosphate

CURING TIME

Temperature	Drying time		Overcoating interval	
	Touch dry	Hard dry	Minimum	Maximum
10°C	8 hours	10 hours	8 hours	Not critical.
20°C	4 hours	5 hours	4 hours	Not critical.
30°C	2 hours	2 hours 30	2 hours	Not critical.

COMPATIBILITY

Previous coat(s) Itself, CHIMICOTE, EPODUX PRIMER 61-134 v01, PRIMODUX H, EPODUX BR 100,...

Subsequent coat(s) Itself, POLYSTRIA HES, POLYSTRIA v01, FERROTHANE, PRESTOTRUCK...

REGULATORY SPECIFICATIONS

AFNOR RATING

VOC (Directive 2004/42/EC) EU limit value for this product (cat. A/j) : 500 g/l (2010)
This product contains max 350 g/l VOC

HEALTH AND SAFETY

Flash point BASE : between 23°C and 55°C
HARDENER : superior to 61°C

Transport and labelling Consult to the safety data sheet established according to the European Directives.

Shelf life 3 years in original full, sealed packaging. Store in a cool, ventilated place.

Precautions Refer to the current material safety data sheet

PACKAGING

KIT	BASE	HARDENER
15 l	13,5 l	1,5 l