

PRIMODUX EV

Polyvalent fast drying epoxy with zinc phosphate

DEFINITION

- Fast-drying, two-component epoxy primer and intermediate, with high reactivity even at low temperature (-10 °C).
- Particularly suitable for new construction where the short times for handling parts and recovering are required.
- Used in maintenance for short recoating times on site.

TECHNICAL DATA

NUMBER OF COMPONENTS	2
GLOSS LEVEL	Mat
COLOURS	Beige, Red-bronw, Grey, others : contact us
MIXING RATIO	weight : 70 / 30 volume : 70 / 30
SPECIFIC GRAVITY	1,45 +/- 0,05 g/cm ³
SOLIDS CONTENT	weight : 75,0 +/- 2% volume : 64,0 +/- 3%
TYPICAL THICKNESS (DRY)	80 - 220 µm
RECOMMENDED WET FILM THICKNESS	125 - 345 µm
THEORETICAL SPREADING RATE	8 m ² /l for 80 µm dry (maxi 50µm on galvanized steel)
AFNOR RATING NFT 36 005	Classement AFNOR NFT 36005 Famille I Classe 6b/7a1
VOC (Directive 2004/42/EC)	Cat. A/j : 500 g/L (2010) 400 g/L VOC
PACKAGING	15L - 4L

COMPATIBILITY

PREVIOUS COAT(S)*	SUBSEQUENT(S) COAT(S)*
Itself	Itself
EPODUX ZINC 62-208	POLYSTRIA v01
EPODUX ZINC 57-35	FERROTHANE
EPODUX ZINC 52-80	EPODUX IM 209
EPODUX IM 208 ...	EPODUX ST 86-31
	POLYSTRIA HES.

*For any product not mentioned in compatibility lists, contact our technical support.

DRYING TIME - OVERCOATING INTERVAL

FILM THICKNESS 0 µm dry	POT LIFE	DRYING TIME		OVERCOATING INTERVAL	
		Touch dry	Hard dry	Minimum	Maximum
10°C	6 hours	40 minutes	2 hours 30 minutes	1 hour 45 minutes	Not critical.
20°C	3 hours	20 minutes	1 hour 15 minutes	30 minutes	Not critical.

FILM THICKNESS 0 µm dry	POT LIFE	DRYING TIME		OVERCOATING INTERVAL	
		Touch dry	Hard dry	Minimum	Maximum
30°C	1 hour 30 minutes	10 minutes	30 minutes	20 minutes	Not critical.

Introduce thinner may affect pot life. Dilution, relative humidity and aeration could affect drying time.

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INSTRUCTIONS

All surfaces must be clean, dry and contamination-free before painting.

SURFACE PREPARATION

SUBSTRATE(S) :	RECOMMENDED
Crude steel	Abrasive blast clean to Sa 2½ according to ISO 8501-1 : 2007.
Roughness profile	Mid G according to ISO 8503-2 (Ra 10-12,5 µm).
Waterjetting	Waterjetting (UHP) up to Wa 2 ½ -L degree according to ISO 8501-4
Previous coat	PRIMODUX EV is suitable for the recovery of certain old previous coating in good condition. In all cases, it is necessary to perform a suitability test (application followed by an adhesion test after complete drying) in order to validate the compatibility of the products as well as the chosen surface preparation. See previous compatible layers.
Galvanized steel	Sweep blasting with fine abrasive or pickling with METONET followed by rinsing with clean water
Stainless steel	Sweep blasting. Roughness profile: Fine G according to ISO 8503-2

APPLICATION CONDITIONS

MIXING	The product is sold as pre-prepared kits. For the hardener portion in the base coat container and mix without creating air bubbles. The minimal recommended temperature of the mixture must be at least 10°C, or a thinner may be required in order to achieve adequate viscosity. Please note that an excessive amount of thinner may induce a dripping phenomenon.	
INDUCTION TIME	Néant	
WEATHER CONDITIONS	Room temperature : Relative humidity :	The temperature should be between -10°C and 40°C 85% maximum
TEMPERATURE	Of substrate : Of product :	Between and 0°C et +40°C and at least 3°C higher than the dew point in order to eliminate any risk of condensation.
TECHNICAL NOTE	Do not keep the spraying equipment loaded for longer than the pot-life of the product. Rinse the equipment with the 67-232 v02 thinner and clean thoroughly with a cleaning solvent. The container containing the prepared and unused mixture must not be hermetically sealed. In case of prolonged interrupted use, it may be preferable to prepare a new kit.	

Early exposure to condensation or rain could provide a change of gloss and/or shade.

APPLICATION

APPLICATION EQUIPMENT	DILUTION*	NOZZLE	PRESSURE AT NOZZLE	MINIMUM PUMP RATIO	REMARKS
AIRLESS SPRAY	0 à 10 % - ready to use depending on application conditions and material used	0.015-0.017 (inches)	150-200 bars	-	-
AIR SPRAY CONVENTIONAL	10 à 20 %	depending on the equipement	3-5 bars	-	-
BRUSH	0 à 5 %	-	-	-	Thicknesses achievable in 2 passes
ROLLER	0 à 5 %	-	-	-	Thicknesses achievable in 2 passes
THINNER	-		CLEANING SOLVENT	-	-

* Dilution rate % are indicative and should be adapted to atmospheric conditions and site specific conditions. Excess of thinner could involve sagging effect and lost of opacity.

HEALTH AND SAFETY

Flash point	: BASE Between 23°C and 55°C HARDENER Between 23°C and 55°C
Shelf life	: DLUO : 3 years minimum in original full, sealed packaging . Store in a cool, ventilated place.
Precautions	: Refer to the current material safety data sheet(SDS).
Transport and labelling	: Refer to SDS according to European directives.
Waste Management	: Soiled Industrial wastes. For more information, please refer to SDS.