

# PRIMODUX H

Fast drying epoxy

## DEFINITION

Primer and intermediary epoxy paint, two components, with high reactivity even at low temperatures (-5°C).

## INTENDED USES

Particularly well suited to :  
- Workshop paint jobs.  
- As a long-lasting protection coat on blast-cleaned steel.

## PRINCIPAL CHARACTERISTICS

- Can rapidly be over-coated by itself or by an epoxy or polyurethane topcoat.
- Enables to quickly turn the parts over.
- Applicable from 60 to 190 µm dry.
- Part of "two component epoxy primer" for intumescent systems according to ETAG 018 (1).

Note : the coating properties, excluding the aspect, are not affected by exposure to actinic radiation.

(1) Compatible with intumescent coating and flocking according to supplier's recommendations and restriction of the associated ETA.

## CERTIFICATIONS / APPROVALS

ACQPA : Brand ACQPA 24312  
Is used in the following certified systems :  
C3ANV 1420, C3ANV 1490, C4ANV691, C3ZNV1134, C4ZNV1135 and Im2ANI950.

EDF : Is used in the following systems registered in the FNP under numbers 1054, 1064 and 1068

## TECHNICAL DATA

Gloss level	: Satin
Colours	: Beige, red-brown, grey, others : contact us
Number of components	: 2
Mix ratio, by weight	: 76/24
Mix ratio, by volume	: 76/24
Specific gravity	: 1,40 +/- 0,05 g/cm³
Solids volume	: 57,0 +/- 3%
Solids weight	: 73,0 +/- 2%
Typical thickness (dry)	: 90 µm
Typical thickness (wet)	: 160 µm
Theoretical spreading rate	: 6,3 m²/l for 90 µm dry



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### INSTRUCTIONS

#### SURFACE PREPARATION

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).

Metallization

This will be in compliance with standard NF EN 2063 : brushing, grease removal, dust removal, as necessary.

#### APPLICATION

**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 :** None

**Working pot life :**

Temperature	Time
10°C	8 hours
20°C	6 hours
30°C	4 hours

**Substrate temperature :** Between 0°C and +40°C and at least 3°C higher than the dew point in order to eliminate 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 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.

#### AIRLESS SPRAY

Thinner : 67-232 v02

Dilution : 0 to 10 %

Nozzle : 0.015-0.017

Pressure at nozzle : 150-200 bars

#### AIR SPRAY

Not advised.

#### BRUSH

Thinner : 67-232 v02

Dilution : 5 to 10 %

Thickness achievable after 2 passes

#### ROLLER

Thinner : 67-232 v02

Dilution : 5 to 10 %

Thickness achievable after 2 passes

**CLEANING SOLVENT :** 67-232 v02

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### CURING TIME

Temperature	Drying time		Overcoating interval	
	Touch dry	Hard dry	Minimum	Maximum
10°C	1 hour 15	3 hours	1 hour 15	Not critical
20°C	40 minutes	2 hours	40 minutes	Not critical
30°C	20 minutes	1 hour 30	20 minutes	Not critical

### COMPATIBILITY

Previous coat(s) EPODUX ZINC 62-208  
Subsequent coat(s) Itself, EPODUX HV PC, POLYSTRIA v01, FERROTHANE, EPODUX IM 209, EPODUX ARF

### REGULATORY SPECIFICATIONS

AFNOR RATING AFNOR NFT 36005 rating Family I Class 6b/7a1  
VOC (Directive EU limit value for this product (cat. A/j) : 500 g/l (2010)  
2004/42/EC) This product contains max 445 g/l VOC

### HEALTH AND SAFETY

Flash point BASE : Inferior or equal to 21°C  
HARDENER : Inferior or equal to 21°C  
Transport and labelling Refer to the safety data sheet established as per applicable 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	11.40 l	3.60 l
4 l	3.04 l	0.96 l