

EPODUX 292 CM

Epoxy phenolic coating

DEFINITION

Epoxy phenolic coating that can be used as a primer or intermediate coat.

INTENDED USES

Substrate(s) : New steel « heavy duty use » (1)
Galvanized steel

Exposure(s) : Indoor
Immersed
(2)

PRINCIPAL CHARACTERISTICS

Quick drying.
Chemical resistance (3) up to 80°C.
Temperature Resistance (150°C continuous and up to 200°C as peak temperature).

CERTIFICATIONS / APPROVALS

EDF



COMPATIBILITY

PREVIOUS COAT(S)*	SUBSEQUENT(S) COAT(S)*
Itself EPODUX 291 EPODUX 292 or EPODUX 294 and EPODUX 294 CM	Itself EPODUX 291 EPODUX 292 or EPODUX 294 and EPODUX 294 CM EPODUR NV 75-25

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

TECHNICAL DATA

NUMBER OF COMPONENTS	2
GLOSS LEVEL	Mat
COLOURS	White or beige
MIXING RATIO	weight : 94.4/5.6 volume : 92/8
SPECIFIC GRAVITY	1,44 +/- 0,05 g/cm ³
SOLIDS CONTENT	weight : 70,4 +/- 2% volume : 52,0 +/- 3%
TYPICAL THICKNESS (DRY)	70 µm
RECOMMENDED WET FILM THICKNESS	140 µm
THEORETICAL SPREADING RATE	7.4 m ² /l for 70 µm dry
AFNOR RATING NFT 36 005	Famille I Classe 6b
VOC (Directive 2004/42/EC)	Cat. A/i : 500 g/L (2010) 405 g/L VOC
PACKAGING	15 L - 5 L

Specific gravity, solid content by volume and by weight are given for mix A+B, without thinner and on the white base for all topcoat. Liquid characteristics of products are given at 20°C.

DRYING TIME - OVERCOATING INTERVAL

FILM THICKNESS 70 µm dry	POT LIFE	DRYING TIME		OVERCOATING INTERVAL	
		Touch dry	Hard dry	Minimum	Maximum
10°C	6 hours	15 hours	20 hours	12 hours	18 months
20°C	3 hours	6 hours	10 hours	6 hours	12 months
30°C	2 hours 30	2 hours 30	4 hours	3 hours	6 months

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) :	MINIMUM	RECOMMENDED
New steel « heavy duty use » (1)	/	Abrasive blast cleaning at Sa 2 1/2 according to ISO 8501-1 : 2007 Roughness profile : Mid G according to ISO 8503-2 (Ra 10-12,5 µm)
Galvanized steel	Etching with METONET followed by rinsing with clean water. The surface should have a rough profile	SWEET Blasting with non metallic abrasive. The surface should be clean, uniform and have rough profile.

APPLICATION CONDITIONS

MIXING	The product is sold as pre-prepared kits. For the hardener portion in the base coat container and mix. Take care not to create 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	
WEATHER CONDITIONS	Room temperature : The temperature should be between 5°C and 35°C Relative humidity : 85% maximum	
TEMPERATURE	Of substrate : Between and +5°C and +40°C and at least 3°C higher than the dew point in order to eliminate any risk of condensation. Of product : Between and 7°C and 35°C	
TECHNICAL NOTE	Do not keep the spraying equipment loaded for longer than the lifespan of the product in a container. Rinse the equipment with the 67-232 v02 thinner and rinse 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	5 to 15 %	0.013-0.017 (inches)	150-200 bars	45 : 1	-
AIR SPRAY CONVENTIONAL	10 to 25%	According to the material	Between 3 and 4 bars	-	-
BRUSH	0 to 5%	-	-	-	(4)
ROLLER	0 to 5%	-	-	-	(4)
THINNER	67-232 v02	CLEANING SOLVENT	67-232 v02	-	-

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

Remark(s)

- (1) Considering the surfaces generally treated and depending on the application conditions (temperature, humidity), use EPODUX 291 as a primer.
- (2) The coating's properties, except for its appearance, are not affected by actinic radiation.
- (3) Consult our technical department for each solution used (type and concentration).
- (4) For pre-touching and small surfaces only.

HEALTH AND SAFETY

Flash point	: BASE Between 23°C et 55°C HARDENER between 23°C et 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.