

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

Substrate(s) : Carbon steel
Old paint
Galvanized steel
Aluminium
Stainless steel

Exposure(s) : Indoor
Outdoor (if covered)

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.

(1)

CERTIFICATIONS / APPROVALS

ACQPA



27612

COMPATIBILITY

PREVIOUS COAT(S)*	SUBSEQUENT(S) COAT(S)*
Itself EPODUX PRIMER 61-134 v01 PRIMODUX H v01 PRIMODUX EV EPODUX BR 100 EPODUX IM 208...	Itself EPODUX IM 209 POLYSTRIA HES POLYSTRIA v01 FERROTHANE PRESTOTRUCK...

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

TECHNICAL DATA

NUMBER OF COMPONENTS	2
GLOSS LEVEL	Mat
COLOURS	White, Gris, beige, brown red others please consult us.
MIXING RATIO	weight : 91,7/8,3 volume : 90/10
SPECIFIC GRAVITY	1,47 +/- 0,05 g/cm ³
SOLIDS CONTENT	weight : 73,5 +/- 2% volume : 71 +/- 3%
TYPICAL THICKNESS (DRY)	80 µm - 280 µm
RECOMMENDED WET FILM THICKNESS	110 µm - 400µm
THEORETICAL SPREADING RATE	9,1 m ² /L for 80µm DFT
VOC (Directive 2004/42/EC)	Cat. A/j : 500 g/L (2010) 350 g/L VOC
PACKAGING	15 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 150 µm dry	POT LIFE	DRYING TIME		OVERCOATING INTERVAL	
		Touch dry	Hard dry	Minimum	Maximum
10°C	4 hours	8 hours	10 hours	8 hours	Not critical.
20°C	2 hours 30	4 hours	5 hours	4 hours	Not critical.
30°C	1 hours 30	2 hours	2 hours 30	2 hours	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
Carbon steel	Sa 2½ (ISO 8501-1); Medium Grit (ISO 8503-2; Ra 10-12,5µm)
Old paint	Compatible coating intact and adherent. Washing High Pressure + Pst 2 (ISO 8501-1)
Galvanized steel	Blasting with non metallic abrasive. The surface should be clean, uniform and have rough profile.
Aluminium *	Sweep Blasting with non metallic abrasive. The surface should be clean, uniform and have rough profile.
Stainless steel	Seep Blasting with non metallic abrasive. The surface should be clean, uniform and have rough profile.

*An appropriate test (application and adhesion test after drying) is recommended to ensure product compatibility.

APPLICATION CONDITIONS

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	none	
WEATHER CONDITIONS	Room temperature : Relative humidity :	The temperature should be between 5°C and 40°C 85% maximum
TEMPERATURE	Of substrate : Of product :	Between and +5°C et +40°C and at least 3 °C above the dew point to avoid any risk of condensation. Between and 10°C and 35°C
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.	

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 %	0.013 -0.017 (inches)	250-300 bars	60 : 1	Mini pump ratio : 60/1
AIR SPRAY CONVENTIONAL	10 à 20 %	depending on equipment used	4-5 bars	-	-
BRUSH	0 à 5 %	-	-	-	(2)
ROLLER	0 à 5 %	-	-	-	(2)
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 lost of opacity.

Remark(s)

- (1) The coating's properties, other than its appearance, are not affected by exposure to actinic radiation.
(2) For pre-touching and small surfaces only.

HEALTH AND SAFETY

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