

PRIMODUX SR 74-31

Fast drying epoxy



DEFINITION

Epoxy coating, two components, with high reactivity even at low temperatures (-5°C).
Can be used as a primer or intermediate.

INTENDED USES

Particularly suitable for :
- Workshop paint jobs.
- Long term 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 250 µm dry.
- Good adhesion on old and undamaged paints.

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

CERTIFICATIONS / APPROVALS

ACQPA : Brand ACQPA 26532.
Is used in the following certified systems : C3ANV 1283, C3ANV 1330,
C4ANV 1282 and C4ANV 1329.

TECHNICAL DATA

Gloss level	: Satin
Colours	: light grey.
Number of components	: 2
Mix ratio, by weight	: 83,5/16,5
Mix ratio, by volume	: 3/1
Specific gravity	: 1,45 +/- 0,05 g/cm³
Solids volume	: 74,0 +/- 3%
Solids weight	: 84,0 +/- 2%
Typical thickness (dry)	: 100 µm
Typical thickness (wet)	: 135 µm
Theoretical spreading rate	: 7,4 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).

Galvanized steel

Normally, degreasing is sufficient, however, in case of an ancient galvanized steel, zinc salts will be removed by any suitable mechanical or chemical means.

Stainless steel

Degreasing, followed by a light blast-cleaning.

APPLICATION

Mixing : The product is supplied in pre-measured kit form. For the hardener part into the base tub and mix, taking care not to incorporate air. The mixing temperature should be at least 10°C. If not, it is necessary to add thinner to get the application viscosity. N.B. : excess thinner increases the risk of sagging.

Induction time :

None

Working pot life :

Temperature	Time
10°C	3 hours
20°C	2 hours
30°C	1 hour

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 leave paint in spray equipment for longer than the pot life. Rinse equipment with 67-232 v01 thinner then clean it carefully with cleaning solvent. Prepared mix that is not used should not be sealed hermetically. For an extended stop, it is better to prepare a new kit.

AIRLESS SPRAY

Thinner : 67-232 v02

Dilution : 0 to 10 %

Nozzle : 0.017-0.019

Pressure at nozzle : 200-250 bars

AIR SPRAY

Thinner : 67-232 v02

Dilution : 10 to 20 %

Nozzle : depends on equipment used

Pressure at nozzle : 3-5 bars

BRUSH

Thinner : 67-232 v02

Dilution : 5 to 10 %

ROLLER

Thinner : 67-232 v02

Dilution : 5 to 10 %

CLEANING SOLVENT : 67-232 v02

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CURING TIME

Temperature	Drying time		Overcoating interval	
	Touch dry	Hard dry	Minimum	Maximum
10°C	2 hours	6 hours	4 hours	12 months
20°C	1 hour 30	3 hours	2 hours	12 months
30°C	45 minutes	2 hours 30	1 hour 30	12 months

COMPATIBILITY

Previous coat(s) Itself, EPODUX ZINC 62-208, EPODUX ZINC 52-80.
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
VOC (Directive EU limit value for this product (cat. A/j) : 500 g/l (2010)
2004/42/EC) This product contains max 320 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
4 l	3,00 l	1,00 l
15 l	11,25 l	3,75 l