



PRODUCT SPECIFICATION SHEET TWO PACK EPOXY PRIMER

High performance coating based on epoxy resin used for metals in chemical and non-chemical environments as well as on many other substrates including marine plywood.

- Contains zinc phosphate anti corrosion pigment
- Suitable for galvanised steel and aluminium after appropriate cleaning.
- The product can be force dried and possesses moderate heat resistance.
- Can be over coated with most types of paint finishes

Supply Viscosity	Approximately 135 seconds Ford 4 Cup@20°C
Thinner	T7003 (T/3)
Spraying viscosity	Dependent on equipment, typically 90 sec
Spraying equipment	Conventional : 1.4 - 1.8mm tip @ 3.5 – 4.2 bar Suction feed HVLP : 1.8mm tip @ 0.7 bar (max) Pressure pot HVLP : 1.0 - 1.4 mm tip @ 0.7 bar Airless : 11 - 21 thou Air assisted airless : 11 - 15 thou Electrostatic : On request to equipment manufacturers recommendations
Surface preparation	Mild steel : Surfaces must be clean, dry and free from dust, grease, oil, millscale, etc. For best results blast clean to SA2 and coat with a suitable blast primer within 4 hours Aluminium & Galvanised steel : for best result apply a suitable etch primer
Film Thickness	Dry 40µ -50µ Wet 75µ -100µ
Volume solids	Typically 50%
Volatile Organic Content	Typically 440 grams/litre
Covering capacity	Approximately 8-10 sq metres per litre @ 50µ DFT
Mixing ratio	4 : 1 base : curing agent
Flash point	Approx 26°C
Pot life	6 hours when mixed * material stays liquid beyond this point but will not perform satisfactory
Drying times Substrate temp 20°C	Touch dry : 10-15 minutes Hard dry : up to 6 hours (dependent on conditions) Full cure : 2 days Force dry : Flash off for 30 minutes then stove between 60-80 °C for 30 mins
Overcoating	Over coat after 6 hrs, preferably overnight (times dependent on conditions, can be force dried to reduce over coating times. When several coats are to be applied do so between 6 and 24 hours to reduce the chance of poor intercoat adhesion and possible delamination
Specific gravity	Typically 1.4 kg/litre
Shelf life	2 years, in an unopened, original container from date of manufacture. Storage should be in accordance with the instructions in section 7 of the relevant MSDS
Finish	matt - eggshell
Colours	As specified
Health & Safety	Before using this product refer to Jawel Paints Ltd MSDS HS15