

A two sheet issue

DESCRIPTION	two component polyamide cured epoxy primer for use over a wide range of substrate types
PRINCIPAL CHARACTERISTICS	<ul style="list-style-type: none"> - good adhesion to steel and galvanized steel - good adhesion to non ferrous metals - good adhesion to various plastics and wood - good adhesion to cement based building materials - good wetting properties - excellent water resistance - good chemical resistance - can be overcoated with alkyd, epoxy and polyurethane - good abrasion and impact resistance
COLOUR AND GLOSS	white, red-brown – eggshell
BASIC DATA AT 20 °C	(for mixed product)
Mass density	approx. 1.4g/cm ³
Solids content	approx. 53% by volume
Recommended dry film thickness	35 µm
Theoretical spreading rate	15.1 m ² /ltr for 35 µm* depending on the nature and condition of the substrate and the application method employed
Touch dry after	approx. 30 minutes
Overcoating interval	min. 16 hours* max. 10 days*
Full cure after	7 days*
Shelf life (cool,dry place)	12 months
Flashpoint	base 17 °C - hardener 26 °C
Available pack size	5 ltr, 20 ltr
*see additional data	

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**RECOMMENDED
SUBSTRATE CONDITIONS**

- substrate must be dry and free from any contamination
- steel: blast cleaned (dry or wet), to ISO-Sa2½
- shop primed steel: pretreated according to SPSS Pt3
- concrete: remove all laitance and loose material
- must not be applied at temperatures below 5 °C
- substrate temperature should be at least 3 °C above the dew point

INSTRUCTIONS FOR USE

- mixing ratio: by volume; base to hardener 75 : 25
- the temperature of the mixed base and hardener should be above 15 °C, otherwise extra solvent may be required to obtain the correct application viscosity
- too much solvent will result in lower sag resistance and slower cure
- thinner should only be added after proper mixing of the base and hardener

Induction time at 20 °C

none

Potlife at 20 °C

10 hours*

**METHOD OF
APPLICATION****AIRLESS SPRAY**

Recommended thinner

91-92 (flashpoint 20 °C)

Volume of thinner

10 - 20%

Nozzle orifice

approx. 0.33 mm (0.013 inch)

Nozzle pressure

150 bar (approx. 2100 p.s.i.)

AIR SPRAY

Recommended thinner

91-92 (flashpoint 20 °C)

Volume of thinner

10 - 20%

Nozzle orifice

1.5 - 2.0 mm

Nozzle pressure

3 - 4 bar (approx. 43 - 57 p.s.i.)

BRUSH AND ROLLER

Recommended thinner

91-92 (flashpoint 20 °C)

Volume of thinner

5 - 10%

CLEANING SOLVENT

90-53 (flashpoint 30 °C)

**SAFETY
PRECAUTIONS**

see safety sheet 1570 for information on
LEL and TLV values

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ADDITIONAL DATA**Film thickness and spreading rate**

Dry film thickness in microns (μm)	20	35
Theoretical spreading rate (m^2/l)	26.5	15.1

Maximum dft without sagging with airless spray: 50 μm Minimum dft for closed film with airless spray: 20 μm Maximum dft for brush application: 35 μm **Note: maximum dft is for overlap areas only****Overcoating table with epoxy paints**

substrate temperature	10 °C	15 °C	20 °C	30 °C
minimum interval	48 hours	24 hours	16 hours	8 hours
maximum interval	21 days	14 days	10 days	7 days

Substrate should be free from chalking and contamination

Curing table

Substrate temperature	Touch dry	Full cure
5 °C	120 minutes	21 days
10 °C	60 minutes	14 days
15 °C	45 minutes	10 days
20 °C	30 minutes	7 days
30 °C	20 minutes	5 days

Ensure adequate ventilation during application and curing

Potlife at application viscosity; these figures are valid for approx. 5 ltr

Paint temperature	Pot life
15 °C	12 hours
20 °C	9 hours
25 °C	7 hours
30 °C	5 hours
35 °C	3 hours

REFERENCES

explanation to product data sheets on information sheet 1551