Technical Data Sheet
EPOXY PRIMER HS 3:2

PRODUCT DESRIPTION

A HIGH SOLID type two pack epoxy primer which does not include solvents.

Primer designed for fixing laminate damages that occurred due to osmosis, it can be used as a protection against osmosis and destructive effect of water on laminate. HS primer creates hard and resistance coat. Can be also used as a anticorrosion protection on steel and aluminum surface below and above waterline.

PRODUCT INFORMATION

SURFACE TYPE	Laminate, optionally steel and aluminum
COLOR	grey
GLOSS	gloss
VOLUME SOLIDS	100%
DENSITY	1,3kg/l
VOC	Not applicable
MIXING RATIO	3:2 by volume (ml), 100:48 by weight (g)
THEORETICAL COVERAGE	6÷7m²/l for thickness 150µm (WFT) / 150µm (DFT)
METHODE OF APPLICATION	Brush, roll, airless spray gun, pneumatic spray gun

INSTRUCTION FOR USE

SURFACE PREPARATION

Laminate (prevention) - salt and other contaminations remove with pressurized fresh water after that wait until surface is dry. Next step is to sand surface by abrasive paper P100-P240. If on the surface exists coats made of paints or primers 1K, before application HS remove it. After grinding remove dust and degrease surface using Sea-Line Cleaner.

Laminate (osmosis treatment)- clean surface from contaminations and remove all coats. Using abrasive paper P40-P120 sand laminate in the same time removing all bubbles and damages . Left hull for 6-9 weeks for drying. Only well dried hull allow to go further with work and avoid recurrence of osmosis. After drying gently sand surface, clean and degrease using Sea-Line Cleaner.

PRODUCT PREPARATION

This product is two pack product. Always mix components in accordance to mixing ratio. Component A is the base, Component B is the hardener. Once mixed, set should be used before pot life expiration- see chapter pot life. Mix all components thoroughly and wait for air bubbles to disappear.

MIXING RATIO

3:2 by volume (ml), 100:48 by weight (g)

THINNING

NOT APPLICABLE

APPLICATION

Number of coats prevention 1-2 layers (total film thickness minimum 300µm)
osmosis treatment 2-4 layers (total film thickness minimum 600µm)

Pot life

45 minutes (20°C)
1h (15°C)

Spray parameters	Thick layer of pneumatic spray application (up to 300µm WFT)
gravity fed	2,1 – 3,0 mm
pressure	2,5 bar

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CURING INFORMATION

Temperature	Overcoating interval	Dust dry	Dry to sand	Fully hardened
20°C	minimum 8 h	10-12 h	24 h	7 days
10°C	minimum 16 h	20-24 h	48 h	14 days

The given times must be considered as a guideline only. The actual drying time may be longer or shorter depend on film thickness, ventilation, humidity etc.

IMPORTANT NOTES

Product temperature should be minimum 15°C. Air temperature should be at least 10°C.

Do not apply two pack epoxy HS primer on one pack products. Avoid painting in direct sunlight. For degreasing use Sea-Line Cleaner.

The maximum overcoating time, without sanding the primer, applies when the surface is free from chalking and other contamination. If the primer coating was exposed to direct sunlight, it must be clean and sanded, removal of the top layer will provide better adhesion.

Immersion should be done only after when the last layer of primer and antifouling paint have hardened.

FURTHER WORK

After hardening is recommend to sand surface using abrasive paper P240-P400

Sea-Line Epoxy Primer HS can be finished with:
any epoxy system
polyurethane 2K paint and varnish

STORAGE AND SAFETY INFORMATION

SHELF LIFE

Base (component A) 24 months from production date
Hardener (component B) 24 months from production date

STORAGE

Product components should be stored in tightly sealed containers, in a temperature of 10-25°C, away from sources of fire, heat and sunlight. Close container tightly immediately after each use. Store in a dry place and keep sealed cans until use.

HSE CONDITIONS

Please follow safety instructions from the Safety Data Sheet for hazardous chemical and follow workplace safety laws. The general rule is to avoid contact of the product with the skin and eyes. When using the product in a small, closed spaces you must provide forced ventilation. It is also recommended that you protect your respiratory system, eyes, and skin. Special care should be taken in the area of fire protection and explosion hazards. **Notice ! Always follow all precautionary, health and safety notice on the Safety Data Sheet and container labels.**

DISCLAIMER

All data in this document have been prepared for informational purpose only. We can not take responsibility for the results of user actions over which we have no control. The user is responsible for making the control sample and determining the suitability of the product for specific, individual applications. Company Troton Sp. z o.o. does not take responsibility for any damage, or loss of profits associated with the improper use of the products. All information is based on scrupulous laboratory research and many

	years of experience. Our position of market leadership does not free us from constant quality control of our products. However, we do not accept responsibility for the effects of improper use or storage of our products, or the effects of using our products in any way contrary to the standard of good workmanship.
QUALITY GUARANTEE	Production, quality control and the realization of deliveries fulfill the demands of ISO 9001 and 14001 standards.