Technical Data Sheet

EPOXY PRIMER 4:1 ANTICORROSION

PRODUCT DESRIPTION

Two pack epoxy primer anticorrosion, with very good adhesion to steel and aluminum surfaces.

Basic functions of this primer is anticorrosion protection, increase adhesion and interlayer. Primer can be used as a grounding, filling or finishing primer. It can be used below and above waterline.

PRODUCT INFORMATION

SURFACE TYPE	steel, aluminum
COLOR	red
GLOSS	mat
VOLUME SOLIDS	70%
DENSITY	1,4kg/l
VOC	374,8g/l (+5%), 513,8g/l (+40%)
MIXING RATIO	4:1 by volume (ml), 100:15 by weight (g)
THEORETICAL COVERAGE	11÷12m²/l for thickness 90µm (WFT) / 60µm (DFT)
METHODE OF APPLICATION	Brush, roll, airless spray gun, pneumatic spray gun

INSTRUCTION FOR USE

SURFACE PREPARATION

Steel – salt and other contaminations wash with water under pressure. Wait till dry. Clean the surface with abrasive steam to the degree of Sa 2,5. On small surface use angle grinder. Remove dust and degrease surface using Sea-Line Cleaner.
Aluminum- sand surface with P120. Remove any corrosion. Rinse surface thoroughly with 10% ammonia solution. Start painting no later than 6 hours after finishing grinding and cleaning.

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. For diluting product, add thinner recommended by producer in proper mixing ratio. Thinning level depends on method of application, tools, air temperature, paint viscosity. Percentage dilution ratio see in chapter thinning. Mix all components thoroughly and wait for air bubbles to disappear.

MIXING RATIO

4:1 by volume (ml), 100:15 by weight (g)

THINNING

For thinning it is recommended to use Sea-Line Thinner for epoxy primers in proportion:

brush/roll	Thin layer of pneumatic spray application (up to 90-100µm WFT)	Thick layer of pneumatic spray application (up to 300µm WFT)
5-25%	40-50%	5-10%

APPLICATION

Number of coats 2-4 layers (total film thickness 225 µm)

Pot life

2h (20°C) application airless spray gun

5h (20°C) application by brush/roll

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Spray parameters	Thin layer of pneumatic spray application (up to 90-100µm WFT)	Thick layer of pneumatic spray application (up to 300µm WFT)
gravity fed	1,4 - 1,6 mm	1,6 - 2,2 mm
pressure	2,0 bar	2,0 - 2,5 bar

CURING INFORMATION

Temperature	Overcoating interval	Dust dry	Fully hardened
20°C	minimum 5 h	5 h	2 days
10°C	minimum 6 h	6 h	3 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 primer Anticorrosion 4:1 on one pack products. Avoid painting in direct sunlight. For degreasing use Sea-Line Cleaner.

Maximum primer recoating without standing primer is applied only when the surface is free from chalking and other contamination. If the primer coating was exposed to direct sunlight, it must be cleaned 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 it is recommended to sand surface using abrasive paper P240-P400

Sea-Line Epoxy Primer Anticorrosion 4:1 can be finished with:
any epoxy system
polyurethane 2K paint and varnish
any polyester system

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 and follow workplace safety laws. The general rule is to avoid contact of 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.