

DATA SHEET

UNIEPOX PRIMER

COD. 35000342 White - COD. 35000344 Ivory

o Universal epoxy primer

Description	General purpose two component polyamide cured epoxy primer
Use and principal characteristic	<ul style="list-style-type: none"> • Good adhesion to steel, galvanized steel and non ferrous metals • Good flow and wetting properties, water and corrosion resistance • Cures at temperature down to 5°C • Suitable for touching up of weld seams and damages of epoxy coatings during construction, and for application to wet or dry abrasive cleaned substrates • Long recoating intervals are possible when overcoating with epoxy and polyurethane coatings • Tolerant for a damp steel surface, and compatible with cathodic protection systems • Uniepox can be obtained in a zinc phosphate type

Resistance to

Corrosion	Excellent
Dry Heat	Up to 100°C
Flexibility	Good
Abrasion resistance	Excellent
Weathering	Excellent
Top coat required	May be topcoated with epoxies, phenolics, vinyls, acrylics, silicones, chlorinated rubbers, alkyd or others as recommended

Basic data at 20°

Colour and gloss	White, greenish yellow - eggshell
Mass density	approx. 1,43 g/cm ³
Solids content by volume	approx. 57% by volume
Recommended dry film thickness	50- 125 µm depending on system
Coverage theoretical	9 m ² /l for 60 µm. The practical coverage will be less, depending on application technique, job conditions and type of surface to be coated

Set - to - touch	30 min. at 20° C						
Full cured	One week at 20° C- see additional data						
Overcoating interval	minimum :30 minutes maximum : 3 months						
Shelf life	24 months in cool and dry place						
Shipping weight	Base	35000344	25 - 5 kgs				
	Hardener	35120105	3,750 - 0,750 kgs				
	Thinner	25100200	25 - 5 lt				
Flash point (DIN 53213)	Base	26° C					
	Hardener	26° C					
	Thinner	28° C					
Surface preparation and application condition	All surfaces to be coated must be clean dry and free of rust, oils,dust, dirt, old paint, and other contaminants. <u>For immersion exposure :</u> steel: Dry or wet abrasive blast cleaning to near-white in accordance with SSPC-SP 10 to a degree of cleanliness in accordance with NACE 2 or ISO Sa 2 1 /2 to obtain blasting profile (Rz) 40 - 70 µm. steel with approved zinc silicate shop primer; pretreated according to PSS- <u>For atmospheric exposure:</u> steel: pretreated according to SIS - St3 shop primed steel: pretreated according to SPSS - Pt3 galvanized stee: cleaned from grease, salts contamination substrate temperature should be at least 3°C above dew point to avoid condensation.						
Material preparation	Product is supplied in pre measured standard pails so that the right ratio is reached by mixing one pail of base product with one pail of binder . If smaller quantities are required, the ratio by weight is: <table><tr><td>Base product</td><td>100 p.</td></tr><tr><td>Hardener</td><td>15 p.</td></tr></table> Thinner should be added after mixing the components. The temperature of the mixed base and hardener should be above 15°C, otherwise extra solvent may be required to obtain application viscosity.			Base product	100 p.	Hardener	15 p.
Base product	100 p.						
Hardener	15 p.						
Induction time	None						
Pot life at 20°	10 hours; see additional data						
Airless spray	Recommended thinner	cod. 25100200; <i>0 -5 % for a dft of 80-150 µm 10-25% for a dft of 35-80 µm</i>					
	Nozzle orifice	approx. 0,46 (=0,018 inch)					
	Nozzle pressure	15 MPa (= approx. 150 at. - 2100 p.s.i.)					
Air spray	Recommended thinner	cod. 25100200 <i>0 - 5%, depending on dft to be applied</i>					
	Nozzle orifice	1.5 - 2 mm					
	Nozzle pressure	0,3 - 0,4 MPa (= approx. 3 - 4 at. - 43 - 57 p.s.i.)					
Brush/Roller	No extra thinner is necessary, but up to 5% thinner cod.25100200 can be added if desired						
Cleaning Solvent	cod. 99100151						

Cleaning Solvent

Additional Data

Spreading rate

Theoretical spreading rate

grams per square metres	120	185	243
square metres per kg.	8,2	5,4	4,1
dry film thickness in µm	50	75	100
max. dft without sagging with airless spray	250 µm		
min. dft for closed film with airless spray	25 µm		
max. dft when brushing	50 µm		

Pot life (application viscosity)

15° C	16 hour	the figures are valid for quantities of approx. 6 kgs
20° C	14 hour	
25° C	11 hour	
30° C	8 hour	
35° C	5 hour	

Overcoating table for two pack epoxy - or polyurethane paint

Substrate temperature	5° C	10° C	20° C	30° C	40° C
Minimum interval	48h	24h	8h	6h	4h
Maximum interval when not exposed to daylight	6 month	6 month	6 month	6 month	6 month
Maximum interval when exposed to daylight	3 month	3 month	3 month	3 month	3 month
<i>figures are valid for a dft of 50 mm Uniepoxy primer</i>					
<i>surface should be cleaned from chalking and contamination</i>					

Overcoating table for other type of paints like: chlorinated rubber, vinyl, alkyd paint

Substrate temperature	5° C	10° C	20° C	30° C	40° C
Minimum interval	48h	24h	8h	6h	4h
Maximum	21 day	21 day	10 day	7 day	7 day
<i>figures are valid for a dft of 50 mm Uniepoxy primer</i>					
<i>surface should be cleaned from chalking and contamination</i>					

Curing table

Substrate temperature	Touch dry	Dry to handle	Full cure
5° C	120 min.	6 hour	20 days
10° C	60 min.	4 hour	20 days
15° C	50 min.	3 hour	10 days
20° C	30 min.	2 hour	7 days
30° C	20 min.	1 hour	5 days
<i>* adequate ventilation is required during application and curing</i>			
Use only where application and curing can be proceed at temperatures above 5°C/41°F. The temperature of the surface and that of the paint itself must also be above this limit. For lower temperatures the curing rate will be very low.			

SAFETY PRECAUTIONS

WARNING

VAPOUR HARMFUL, MAY CAUSE IRRITATION.
COMBUSTIBLE. CONTAINS ORGANIC SOLVENTS.
Avoid contact with eyes, skin and clothing. Avoid breathing vapour. Wash thoroughly after handling. Use with adequate ventilation. Wear an air supplied mask to avoid breathing concentrated vapours in enclosed areas. Close container after use.
Keep away from heat, sparks, and open flame.
In case of eye contact, immediately flush with plenty of water for at least 15 minutes.