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TECHNICAL DATA SHEET

PRODUCT EP210 2- PACK EPOXY ANTI-CORROSIVE PRIMER

DESCRIPTION EP210 Two-pack epoxy primer is based on non-toxic anti-corrosive zinc phosphate pigments and is suited for use over suitably prepared steel surfaces where a combination of resistance to chemicals, solvents and aggressive environmental conditions is required.

<u>PROPERTIES</u> COLOUR	Grey			
GLOSS LEVEL	Semi-gloss.			
WEATHERING	Not Applicable (usually top-coated).			
CHEMICAL RESISTANCE	Excellent (weak organic acids and common alkalis)			
SOLVENT RESISTANCE	Excellent (unaffected by most common organic solvents)			
ABRASION RESISTANCE	Excellent.			
TEMPERATURE RANGE	Up to 120 °C (dry).			
TECHNICAL DATA RECOMMENDED	<u>A</u>			
FILM BUILD	150 microns (wet) 75 mi	crons (dry)		
VOLUME SOLIDS	50% per coat.			
THEORETICAL COVERAGE	Approximately 7 sq. metres per litre	e at 150 microns wet.		
COMPONENTS	Two.			
MIXING RATIO	4A : 1B			



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DRYING AT 25 °C CHEMICALLY ASSISTED DRYING	Touch dry: Recoat:	2hrs 10hrs	Handleable: Full cure:	16hrs 6 days
AT 25 °C	Touch dry: Recoat:	1hr 5hrs	Handleable: Full cure:	6hrs 3 Days
POT LIFE AT 25 °C	8hrs (will reduce as temp increases)			
APPLICATION METHODS	Brush, roller, air or airless spray. Chemically assisted drying requires air atomisation or shaping air.			
FLASHPOINT	8 °C			
SHELF LIFE	12 months (minimum) in original containers			
PACKAGING	Part A Part B	4 lt. 1 lt. 5 lt.		

SYSTEM RECOMMENDATIONS

SUBSTRATE	PREPARATION	COATING SEQUENCE	FILM BUILD WET (DRY)
STEEL	Abrasive blast	SYSTEM 1	
~	Clean AS1627.4	1st coat :	
	class 2.5 (min)	BC300 2- pack Metal Etch Primer	40 - 50 (10 - 15) microns
		2nd coat :	
		EP210 2-pack Anti-corrosive Primer	150 (75) microns
		Finish coat:	
		UT100 Series Acrylic Topcoats	100 - 120 (40 - 50) microns
		SYSTEM 2	
		1st coat :	
		EP210 2-pack Anti-corrosive Primer	150 (75) microns
		2nd coat :	
		UT150 Series Acrylic Topcoat	100 (50)microns
		Finish coat :	
		UT150 Series Acrylic Topcoat	100 (50)microns



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SURFACE PREPARATION

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STEEL	Remove any grease or oil using suitable solvent or water based degreaser. Acid or alkali presence should be neutralised with appropriate products followed by thorough rising with clean water. Any other foreign matter e.g. rust, mill-scale etc., should be abrasively blast cleaned to Australian standard AS1627.4 Class 2.5 for ambient conditions or class 3 for immersion conditions.
<u>APPLICATION</u> MIXING	Stir each of the components till homogenous. Mix all base and hardener components until fully blended. Allow induction time of 15-20 mins prior to commencing application.
THINNING	Use recommended thinner only, up to a maximum of 15 % by volume depending on method of application employed.
BRUSH OR ROLLER	Use brush for small or difficult areas. Short nap roller is recommended with two coats for best result and even finish.
SPRAYING	Conventional pressure pot: 1.5 mm Fluid orifice using 450 kPa (70 psi).Pressure at pot: 130 kPa (20 psi)
AIRLESS	Standard airless equipment such as Graco, Binks etc. is suitable. Refer manufacturers recommended specifications for set-up.
EQUIPMENT CLEANUP	All equipment should be thoroughly cleaned with EP100 Epoxy Thinner.



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PRECAUTIONS

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SAFETY	Provide adequate ventilation during use.		
	Airflow should be adequate to ensure a comfortable working atmosphere.		
	When spray painting, users should comply with the provisions of the State		
	Spray Painting Regulations.		
	Where this is not possible, operators must use an air supplied respirator complying		
	with Australian Standards AS1715 and AS1716.		
	with Australian Standards AS1/15 and AS1/16.		
	This product is flammable and all sources of ignition (flame, pilot lights, furnaces,		
	spark producing switch etc.) must be eliminated in, or near, the application area. DO NOT SMOKE.		
	This product is polyamide catalysed and the necessary precautions must be observed		
	when handling this material.		
	Avoid contact with skin and eyes.		
	Wear protective goggles and gloves when handling the material.		
	In the case of skin contact, remove contaminated clothing and wash skin thoroughly		
	with clean water.		
	Seek medical attention if eyes are affected by splashes or fumes.		
GENERAL	Freshly mixed material must not be added to material which has been in use		
	for some time.		
	Rate of cure is dependent upon temperature.		
	Do not apply this product at temperatures below 10 $^{\circ}$ C or relative humidities > 85 %.		
	Ensure maximum recoat interval is not exceeded otherwise surface must be lightly		
	abraded and then dusted to ensure maximum intercoat adhesion.		
	Shelf life is normally 12 months (in original containers)		
	but depends on storage conditions.		
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DANGEROUS GOODS

Part A	Class 3.1	UN	1263	PAINT	HFP
Part B	Class 3.2	UN	1866	PAINT	HFP

This data sheet is based on information in BC Coatings possession at date of issue. BC Coatings supplies its products only on condition that the consumer is satisfied as to the performance of the product in meeting his particular requirements.