

# EPOLEX<sup>®</sup> PRIMER PROFI S 2300

Two-component anticorrosive epoxy primer

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**Composition** Dispersion of inorganic pigments and fillers in a solution of epoxy resin of medium molecular weight in organic solvents with addition of additives and zinc phosphate.

**Characteristics and use** The product is intended for use as anticorrosive primer for metal surfaces providing the coating system with excellent adhesion and corrosion protection. Before use the paint is mixed properly with the hardener in specified ratio.

The product is not intended for coatings that come into direct contact with food, feed and drinking water and for coatings of children's furniture and toys. The product can be used on surfaces that come into indirect food contact.

- ◆ excellent anticorrosive properties
- ◆ excellent adhesion to a variety of substrates
- ◆ stays on vertical surfaces

**Application area** Substrate: steel, aluminium, brass, zinc  
 Environment: for interior and exterior, according to type of final topcoat  
 Examples: metal tanks, piping, machines, industrial structures, bridge structures.

**Shades** 0110 grey

<b>Physical properties</b>	Flow time	medium, short (thixotropic character)
	Weight solids	> 70 % (not hardened mixture)
	Volume solids	51 % (hardened mixture)
	Flash point	> 25 °C
	Density of hardened mixture	1380 kg/m <sup>3</sup>

<b>Emission limits</b>	VOC: 0.25 kg/kg of hardened mixture	TOC: 0.21 kg/kg of hardened mixture
	Product subcategory: A/j	Threshold value (2010): 500 g/l
	Max. VOC content in ready to use state: 463 g/l	

<b>Properties of hardened coat</b>	Gloss	degree 4 - 5
	Pendulum hardness / Persoz	up 30 % in 5 days
	Adhesion with crosshatch test	degree 0
	Cupping test	5 mm
	Bend test	perfect (cylindrical mandrel ø 2 mm)

<b>Drying time</b>	Surface temperature	23 °C
	Dust free	up to 1 hour
	Dry through	up to 24 hours
	Dry film thickness DFT	25 - 30 µm

<b>Spreading capacity</b>	Wet film thickness WFT	50 - 57 µm
	Dry film thickness DFT	25 - 30 µm
	Theoretical spreading capacity	9 - 12 m <sup>2</sup> /kg of hardened mixture

**Thinning** S 6300

**Hardening** Hardener: EPOLEX S 7300  
**Mixing ratio: 100** weight parts S 2300 : **17** weight parts S 7300  
 The pot life of the hardened mixture is 8 hours (20 °C).

**Surface preparation** The surface must be clean, dry, degreased, free of rust and dust, mechanically cleaned. First of all the surface must be degreased by means of suitable agent (e.g. technical benzine P 6402, acetone P 6401 or, if it is possible, warm pressurized water with detergent). For removing of residues of various salts it

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is necessary then to rinse the surface with clear water. Rough and sticky impurities must be removed manually or mechanically (grinding, scraping). Possible rust may be removed also manually or mechanically (metal brushes, grinding discs).

Absorbent surfaces must be treated (penetrated) with suitable agent, providing even absorbency.

Formerly coated surfaces must be cleaned, degreased and without old non-adhesive paints. It is recommended for providing compatibility of a new paint with the old one to perform a reference coating (painting) of surface - ca 1 m<sup>2</sup>. It is recommended to follow the procedure system according to the technical data sheet.

## Application conditions

Minimal air temperature for application is 10 °C, temperature of painted surface must be 3 °C above dew point. Temperature and relative humidity must be measured in proximity of painted surface. The surface temperature must not be higher than 35 °C. Relative humidity must not be higher than 75 %. The optimal application temperature is 18 to 23 °C and relative humidity 40 to 70 %. Lower temperature and higher humidity during an application and a drying and high thickness of applied coats markedly slow down drying and hardening of the coat.

During rain, fog, creation of condensation water, effect of aggressive gases and during wind with strong content of dust the coating work must be suspended and can be restart after absolute drying of surface-treated material.

## Workflow

Properly mix before use. Mix with hardener EPOLEX S 7300 in prescribed weight ratio and properly mix together. Apply on the prepared surface.

### **The coating of a metal:**

1. 1x EPOLEX PRIMER PROFI S 2300. The second coat should be applied not sooner than after 24 hours (20 °C). Drying and maturing of coat can be accelerated by drying at the temperature 60 – 100 °C during 60 – 30 minutes.
2. 1 - 2x EPOLEX ENAMEL PROFI S 2321 (for interior) or TELPUR T 300 (for exterior)

## Application

Brush, roller, spraying

**Data for airless spraying**, e.g. VYZA VARIO 56-45 (EST)

Nozzle 0.011 inch (0.28 mm) or 0.013 inch (0.33 mm); Pressure on nozzle 25 – 33 Mpa (250 – 330 atm.; 3600 – 4800 psi); Spraying angle 20 – 60°; Filter of spraying gun - yellow 100/149 (mesh/ μm).

## Handling

Read the instructions in the Safety Data Sheet before use and follow all safety instructions and regulations. The product contains organic solvents. Follow basic hygiene rules. Do not eat, drink or smoke while using this product. Avoid contact with eyes, skin or clothing. Wear protective gloves, eye protection, protective clothing. Ensure effective ventilation of the workplace. People and animals should not remain in the treated area until the paint dries.

If on skin: take off contaminated clothing and wash skin with plenty of soap and water. If inhaled: remove person to fresh air. If in eyes: rinse thoroughly for 10-15 minutes with clean water. Remove immediately contact lenses if present. If swallowed: rinse your mouth with water. If you feel unwell or in case of health problems or if in doubt, and accidental ingestion and contact with eyes, always consult a doctor immediately.

## Packing

1.18 kg (including hardener)

## Storability

The product keeps the product qualities 5 years from production date in original closed container. To store in dry storage at the temperature 5 to 25 °C. Flammable liquid II. hazard class.

## Disposal of packing and waste

Hand over the used, properly empty packing at the collection point of the packing waste. Dispose the packing with the product rest at the place determined by the town for disposal of hazardous waste or hand over to the person authorized for hazardous waste disposal. Further see MSDS.

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These data are only for information and their accuracy is influenced by the properties of individual materials and unpredictable factors during application. The user is responsible for correct use of the product according to the direction for use and for correct application of painting system, i.e. he must always evaluate all conditions of application, which could influence final quality of the top treatment. Therefore we always recommend to the user to carry out the test for actual working conditions and type of surface applied. Above mentioned data are data, which influence individual working conditions and therefore they do not establish a legal claim. It is necessary to consult information outside the terms of this catalogue sheet with the producer.

The producer stipulates the right for the change in the catalogue sheets without previous notification.