

Epifanes Epoxy Primer

Two component primer for below and above the waterline



PRODUCT DESCRIPTION

A very tough modern two component zinc phosphate epoxy primer for above and below the waterline. This primer has excellent filling properties and still has a good flow. It has a great rust protection for steel, impregnates in to wood very well with a high protection. It also creates a tough and strong protection for FRP with a good osmose protection. It has a perfect adhesion to FRP. In addition, this is a fast drying primer and easy sandable.

Field of use: This primer can be used on all surfaces. With enough film building, this primer can completely seal the boat from water entering the surface of the boat. Above the waterline this primer gives a strong scratch resistance. This primer is unique in the way that it is recoatable with two pack and single pack.

PRODUCT INFORMATION

| | |
|-------------------------|--|
| Type | Chemical drying |
| Base | Epoxy resin with di-calcium phosphate |
| Gloss | Semi gloss |
| Colour | White |
| Density at 68°F. | 1.74gr. / dm ³ (mixed product) |
| Viscosity | 100 seconds DIN-cup 4 mm |
| Solids Contents | 75 ± 2 vol. % |
| VOC-level | 439 grams/liter (mixed product) |
| Packing | 600ml. Component A + 150ml. Component B = 750ml. 1600ml. Component A + 400ml. Component B. = 2000ml. 3200ml. Component A + 400ml. Component B. = 4000ml. |

Shelf life
In closed unopened container stored between 41 - 77°F
Base component A 2 years after production date
Curing component B 1 year after production date

Rec. filmthickness 4 mil wet = 2-3 mil dry

| | | | |
|-----------------------------|--------------|--------------|--------------|
| Potlife after mixing | 59°F. | 68°F. | 77°F. |
| | 3 - 4 hours | 2 - 3 hours | 1 - 2 hours |

Thinner brush Epifanes D-601 Epoxy Thinner

Thinner spray Epifanes D-601 Epoxy Thinner

Thinning in general Thinning ratio depends on product temperature and working area. Avoid overthinning. For thinning ratios, refer to the Epifanes paint systems.

| Drying times at 65% RLV | 54°F. | 59°F. | 68°F. | 77°F. |
|-------------------------|----------|----------|---------|---------|
| Dust Dry | 4 hours | 2 hours | 1 hour | 30 min. |
| Recoatable | 18 hours | 12 hours | 6 hours | 4 hours |
| | 10 days | 7 days | 5 days | 4 days |

If subsequent coat is applied within 5 days, sanding is not required. After 5 days always sand with 120G before applying a fresh coat Epoxy Primer. Do not apply Epifanes Epoxy Primer below 54°F. The above mentioned drying times are indicative at 65% RAH and 2 mil dry film thickness. Drying also depends on the amount of ventilation and applied wet film thickness. Higher wet film thickness and/or limited ventilation results in longer drying times. Especially flat surfaces may take longer to dry due to high wet film thickness. Allow each paint coat sufficient time to dry. Do not apply wet-on-wet!



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APPLICATION

Conditions during application Temperature minimal 54°F. - maximal 82°F.
Relative air humidity minimal 50% - maximal 75%

Best results are achieved by roller, longhaired soft brush or by spray. Evenly distribute the paint over the surface and do not retip. Do not apply wet-on-wet. Do not apply excessive wet film thickness to avoid the formation of curtains and drying problems. Avoid painting in direct sunlight or too much wind. A rapid loss of solvents will occur under these conditions and decrease the flowing ability. The maximum difference in temperature between the surface and the paint is 38°F. In case the product “pulls” and is difficult to apply, 10% Thinner D-601 may be added. After drying, firmly sand the surface with 180G before applying the next coat. Always sand by hand.

| Guidelines for spray application | Nozzle | Pressure | Thinning ratio |
|----------------------------------|----------------|-------------|----------------|
| Air spray | 1.4mm | 45-60 psi | 10-15%. |
| Airless Spray | 0,419 - 0,525” | 170-250 bar | 0-2% |

| | | |
|---------------------------------------|--------------|--|
| Surface conditions | steel | Completely remove rust, grease, dirt and other contaminants. Remove salt and other water-soluble dirt by thoroughly rinsing with clean water and high-pressure cleaner or an emulsifier. Remove grease and oil by cleaning with water and ammonia or another suitable cleaning agent. Coarse sanding 60-80G. |
| | FRP | Degreased with Epifanes Fiberglass Cleaner and sanded 220G. |
| Additional remark | | Sand every coat with dry sandpaper 180-220G. On new aluminium it is recommended to apply 1 coat of Epifanes Washprimer AQ. |
| Existing painted surface | | Clean the surface well and degrease with Epifanes Spray Thinner. Follow by sanding the surface with 180-220G. Always clean and degrease again with Epifanes Spray Thinner for Paint & Varnish. |
| Theoretical coverage | | 100ft ² per liter @ 2 mil dry film thickness |
| Practicle coverage | | The total coverage is dependent on the wet film thickness, surface, application technique and use of any thinners. |
| Recoatable above the waterline | | Epifanes Poly-urethane Primer - Epifanes Poly-urethane Yacht Coating Epifanes Epoxy HB Coat |
| Recoatable below the waterline | | Epifanes Epoxy HB Coat - Epifanes Interimcoat |
| Fillers | | Epifanes Epoxy Filler 1500 - Epifanes Epoxy Finishing Filler |
| Safety | | The user of this product should obey all national laws and legislation concerning health, safety and environmental hazard. For more information on health and safety, refer to the Material Safety Data Sheet of this product. |

Although the facts and suggestions in this product information sheet are based on our own research and field experiences and are believed reliable, we cannot simply be held responsible for performance or results obtained through the use of this product. Ineffectiveness or other unintended consequences may result, because of such factors as weather, conditions, presence or other materials or the manner of preparation, use or application all of which are beyond W. Heeren & Zoon's control. All such risks are assumed by user.

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