

Epifanes Metalprimer

One-component anti-corrosive primer

Type	Air drying
Base	Alkyd- and urethane resin + zinc phosphate
Properties	One-component primer with excellent anti-corrosive properties.
Field of application	Steel: for interior and exterior use above the waterline. Repair and filling primer on existing one-component paint systems above the waterline.
Colours	White - grey
Gloss	semi gloss
Density	1,35 kg/dm ³
Viscosity	120-130 sec. DIN-Cup 4 mm
Solids contents	55 +/- 2 vol. %
VOC - level	404 grams/liter
Packing	750ml. - 2000ml. - 4000ml.
Shelf life	In closed original container stored in a dark location between 5 - 25°C approx. 3 years.
Conditions during application and drying	Temperature minimal 10°C. - maximum 28°C. Relative air humidity minimal 50% - maximum 75%
Thinner for brush applications	Epifanes Brushthinner for Paint & Varnish
Thinner for conv. spray applications	Epifanes Spraythinner for Paint & Varnish
Thinner for airless spray applications	Epifanes Thinner D-200
Application tools	Moltpren foam roller, soft, longhaired brush or conventional air spray
Recommended filmthickness / coat	80 µm wet = 45 µm dry Do not apply higher wet film. Recommended total film thickness 120 µm dry. (= 3 coats). Apply first coat on bare steel 20-25% using a stiff brush. This will provide a better bonding in the steel surface
Application recommendations	Stir well prior to use and during application. Do not overbrush. Do not apply wet-in-wet. Avoid excessive wet films to avoid the formation of curtains and through drying problems. Application by roller is advised. Avoid painting in direct sunlight or too much wind. A rapid loss of solvents will occur under these conditions and degrease the flowing ability. The application and drying should occur in well ventilated areas. Always secure sufficient air circulation for supply of fresh air and disposal of solvent fumes and in order to avoid drying problems.
Theoretical coverage	10-12m ² per liter @ 45µm dry filmthickness
Practicle coverage	Dependent on condition of substrate, loss of material due to factors such as application technique, shape of object, circumstances during application.
Substrate conditions	Temperature of paint, object and work area during application and dryingshould not be lower than 10°C. Relative air humidity should not exceed 85%.

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Application details

	Air spray	Airless spray	Brush/Roller
Thinning volume	10 - 20%	5-10%	0-5%
Nozzle	1.5 mm-2.0 mm	0.018 - 0.021 "	
Pressure in bar	3 - 5	120-150	
Visc. DIN-cup 4 mm	20-24 sec.	60 - 80 sec.	

Intercoat sanding

For necessary intercoat adhesion, sand every coat of Epifanes Metalprimer Primer with P180-220 dry abasive paper.

Drying times @ 20°C. / 65% RAH and 45 µm dry filmthickness

Dustdry	Sandable by hand	Recoatable
2 hours	6 hours	12 hours

Substrate condition

Dry, free of contamination and rust , well degreased and sanded with P 60 dry. Apply first coat on bare steel 25% thinned immediately after surface preparation.

Previously painted surfaces

Well bonding, dry, clean, well degreased , sanded with P240-280 dry and dust free.

Recoatability

Epifanes Yacht Enamel - Epifanes Mono-urethane Yacht Paint
 Epifanes Bilge Paint - Epifanes Nautiforte Yacht Paint
 Epifanes Undercoat - Epifanes Multiforte

Recoatibility limitations

Do not apply epoxy filler / epoxy based primers and/or coatings on Epifanes Metalprimer.

Suitable filler

Epifanes Combi Filler (max. 1 mm per coat)

Safety

The user of this product should obey all 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.

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