812 EPOXY PRIMER

Description

812 EPOXY PRIMER is a 2-component anticorrosive epoxy-polyamide primer. It contains zinc phosphate as an active anticorrosive pigment. It is recommended to be used as an anticorrosive primer for steel constructions, fuel tanks in chemical plants, energy production plants, shipyards and harbor equipment. It is also available in a fast-drying formula (fast drying B component) which is specially designed for low temperatures applications.

Technical Information

Shade	Grey, red oxide
Mixing ratio	A:B-5:1 by weight (2,75:1 per volume)
Specific Weight	(A) 1,60 (±0,05) kg/lt, (B) 0,89 (±0,02) kg/lt, (A+B) 1,40 (±0,05) kg/lt (EN ISO 2811)
Solids	52 ±2% by volume 66 ±2% by weight (EN ISO 3251, non volitale)
Theoretical Coverage	4,95 m^2/kg (75μm film thickness)
Resistance to temperature	Up to 120 °C (service temperature)
VOC*	Ready to use maximum (+10% thinner): 495 g/lt EU LIMITS (2010): 500 g/lt Subcategory: j – Two pack performance coatings, primer coat for ferrous substrates, Type SB

Drying time 75μm, 60%RH

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Pot Life	Touch Dry	Drying	Total Drying	Recoating Min	Recoating Max
8 °C					
>16 hr	1 hr 40 min	5 ½ hr	4-5 days	5 ½ hr	No limits
20 °C					
12 hr	40 min	2 ½ hr	72 hr	2 ½ hr	No limits

It is also available in a fast drying version with the use of 812 B FAST EPOXY HARDENER (fast drying B component) which is specially designed for applications at low temperatures and does not require induction period.

812 FAST

Pot Life	Touch Dry	Drying	Total Drying	Recoating Min	Recoating Max
8 °C					
8-9 hr	1 hr	3 hr	2-3 days	3 hr	No limits
20 °C					
6-7 hr	30 min	1 ½ hr	48 hr	1 ½ hr	No limits

The above times are indicative and depend on the thinning percentage, relative humidity and temperature. After prolonged periods of exposure to weather conditions, cleaning and preparation of the surface is needed in order to be overcoated.

Surface Preparation

All applications on steel, including welding, cut with flame and smoothing, must be terminated before the preparation of the surface. All the remnants of the welding process must be removed. Cleaning of the surface from dust and other materials like oil, grease etc using detergent and water. The alkaline remnants of the recent welding joints as well as the traces of soap, must be removed with fresh water and rubbing. For better results, sandblast is recommended at least Sa 2, ISO 8501-1 or for prolonged exposure of the surfaces Sa 2 ½ with profile about 35μm.

Application

<u>812 EPOXY PRIMER</u>

5 parts of A component are mixed with 1 part of B component by weight and then thinner is added. **Application: approximately 20 minutes after mixing (induction period).**

<u>812 EPOXY PRIMER (FAST)</u>

5 parts of A component are mixed with 1 part of B component (FAST) by weight and then thinner is added. **No induction period is required.**

It must not be applied on surfaces previously coated with one component paint. It is

recoated with any type of final coating. It is applied with:
Air pistol, (diameter: 1,8-2,2 mm, pressure: 3-5 bar) after 10-15% thinning with thinner.
Airless (nozzle 0,019-0,023 in) after 5-10% thinning with thinner.

Suggested film thickness	50-120 μm
Application temperature	10-35 °C
Moisture	< 80% RH
Suggested thinners	1131-1120-1015 The choice of suitable thinner depends on the application method, the temperature and the humidity conditions. For the suitable choice, please contact with the technical department of our company

NOTE:
When applicable, products primarily meant for use as primers may have slight color variations from batch to batch.
Like all epoxy coatings (at the external use), at prolonged exposure to weather conditions, may present chalking and colour alteration. This incident occurs on the surface and doesn't affect the anticorrosive and protective properties of the product.

Storage

For 12 months in a dry and cool place (5-30˚C), protected from direct solar radiation, stored in the original unopened containers.

Packages

20 kg tinplate cans A component, 4 kg tinplate cans B component.

Consumption

The consumptions are theoretical, not including losses and are determined by weather conditions, the way of use and the type of complexity of the painted surface. Small surfaces or complex shape surfaces have as result higher consumption due to spray outside the surface. Factors such as inadequate skills of the applicator, losses due to atmospheric conditions, discarded paint due to exceeded shelf life in the cans, remains in the pumps and containers, etc., contribute to higher consumption.

Safety

Please consult the Material Safety Data Sheet. Available upon request.