



## DESCRIPTION

- a universal two pack adhesion promoting, polyamide cured epoxy primer
- approved to APAS-2971
- conforms to AS/NZS 3750.13

## PRINCIPAL CHARACTERISTICS

- general purpose epoxy primer in protective coating systems for steel and non ferrous metals
- excellent adhesion to steel, galvanized steel, non ferrous metals and fibreglass
- excellent flow and wetting properties
- excellent water and corrosion resistance
- cures at temperatures down to +5°C
- suitable for touching up of weld seams and damages of epoxy coatings during construction
- long recoating intervals are possible when overcoating with epoxy and polyurethane coatings
- can be overcoated with most alkyd, chlorinated rubber, epoxy, two component polyurethane and catalysed acrylic coatings
- suitable on wet blast cleaned substrates (damp or dry)
- suitable for immersion in fresh and salt water
- compatible with cathodic protection systems
- cure with Epinamelel EH100 standard hardener or Epinamelel EH120 low temperature hardener

## COLOURS AND GLOSS

- Olive Green and Grey - semi gloss

## BASIC DATA AT 25° C

- solids content ..... approx. 55% by volume
- mix ratio ..... 4A:1B by volume
- typical film thickness (per coat) ..... 75 - 200 microns(dry), 135 - 365 microns(wet), depending on coating system
- theoretical spreading rate ..... 7.3 m<sup>2</sup>/l for 75 microns(dry), 2.8 m<sup>2</sup>/l for 200 microns(dry)
- touch dry after..... 1 - 2 hours (Epinamelel EH100)
- overcoating..... refer to overcoating table for details
- full cure after..... 7 days (Epinamelel EH100), 3 days (Epinamelel EH120)
- shelf life (cool and dry place)..... at least 12 months

## RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURE

- all surfaces to be coated must be clean and free from chalking and contamination
- oil and grease should be removed from all surfaces in accordance with AS 1627.1 solvent cleaning
- mild steel; blast clean in accordance with AS 1627.4 to Sa 2½ minimum (AS 1627.9), surface profile 40-70 microns
- if oxidation occurs between blasting and application, the surface should be reblasted to the specified visual standard
- surface defects revealed by the blast cleaning process should be ground, filled or treated in the appropriate manner
- mild steel; power tool clean in accordance with AS 1627.2 to St 2 minimum (AS 1627.9), (atmospheric exposure only)
- steel; wet blast clean to achieve a surface similar to Sa 2½ (AS 1627.9), profile 35-50 µm (atmospheric exposure only)
- galvanised steel; lightly blast using an inert grit or power tool clean to achieve a roughened uniform flat appearance
- aluminium; lightly blast clean using an inert grit and achieve a surface profile of 35-50 microns
- aluminium; mechanically abrade using 80 grit paper/disc



- stainless steel; blast clean using an inert grit and achieve a surface profile of 35-50 microns
- stainless steel; mechanically abrade using 80 grit paper/disc
- fibreglass; mechanically abrade using 120 grit paper/disc
- ZINCALUME<sup>®</sup> or COLORBOND<sup>®</sup>; lightly sand the surface
- hot metal spray; high pressure water wash
- previous suitable coat; dry and free from any contamination and sufficiently roughened if necessary
- substrate temperature must be at least 5°C during surface preparation, application and curing and at least 3°C above dew point

#### INSTRUCTIONS FOR USE

- mixing ratio by volume: 4A : 1B
- mix with EpinameL EH100 standard hardener or EpinameL EH120 low temperature hardener
- induction time - none
- pot life at 25°C - 6 hours (EpinameL EH100). Do not use after this time even if the mix is still liquid
- stir the components and mixed product well using a mechanical mixer
- the temperature of the mixed product must be above 15°C, otherwise extra thinner may be required to obtain application viscosity
- too much thinner will result in lower sag resistance and slower cure
- thinner should only be added after mixing the components
- freshly catalysed material should not be added to product that has been mixed for some time
- for recommendations outside those contained in this data sheet, refer to WattyL

#### APPLICATION

- **AIRLESS SPRAY**
  - recommended thinner ..... Thinner L760
  - volume of thinner ..... up to 5%
  - nozzle orifice..... approx. 0.46 mm (0.018 inch)
  - nozzle pressure ..... 15 MPa (2100 psi)
- **AIR SPRAY**
  - recommended thinner ..... Thinner L760
  - volume of thinner ..... up to 15%
  - nozzle orifice..... 1.5-2mm
  - nozzle pressure ..... 0.3 - 0.4 MPa (50 - 60 psi)
- **BRUSH/ROLLER**
  - recommended thinner ..... Thinner L760
  - volume of thinner ..... up to 5%

The maximum dry film thickness that can be achieved when brushing/rolling is 50 microns  
Multiple coats may be required to achieve the recommended dry film thickness
- **CLEANING SOLVENT** ..... Thinner L760

#### SAFETY PRECAUTIONS

- flammable. Avoid contact with heat and naked flame
- avoid contact with skin and eyes
- use gloves, mask and goggles during application
- provide adequate ventilation when using in confined spaces
- this product is intended for use in industrial situations by professional applicators in accordance with the advice given on this sheet. All work involving the use and application of this product should be carried out in compliance with all relevant Health, Safety & Environmental standards and regulations and must not be used without reference to the Material Safety Data Sheet (MSDS)



**ADDITIONAL DATA**

**Overcoating table - with two pack epoxy, polyurethane coatings**

Substrate temperature	Epinamel EH100				Epinamel EH120			
	5°C	15°C	25°C	35°C	5°C	15°C	25°C	35°C
Minimum interval	36 hrs	10 hrs	8 hrs	6 hrs	2 hrs	1½ hrs	1 hr	30 min
Max interval when NOT exposed to direct sunlight	6 mth	6 mth	6 mth	4 mth	1 mth	1 mth	1 mth	16 days
Maximum interval when exposed to direct sunlight	3 mth	3 mth	3 mth	2 mth	16 days	16 days	16 days	7 days

- surface must be dry and free from chalking and contamination
- when using EpinameL EH120 for immersion applications the minimum overcoating times applicable for EpinameL EH100 must be observed

**Overcoating table - with chlorinated rubber, alkyd and catalysed acrylic coatings**

Substrate temperature	Epinamel EH100			
	5°C	15°C	25°C	35°C
Minimum interval	16 hrs	6 hrs	5 hrs	3 hrs
Maximum interval	21 days	14 days	10 days	5 days

- surface must be dry and free from chalking and contamination

**Curing table**

Substrate temperature	Epinamel EH100			Epinamel EH120		
	Touch dry	Dry to handle	Full cure	Touch dry	Dry to handle	Full cure
5°C	5 hrs	6 hrs	21 days	2 hrs	3 hrs	9 days
15°C	2½ hrs	3 hrs	10 days	1½ hrs	2 hrs	5 days
25°C	1½ hrs	2 hrs	7 days	45 min	1 hr	3 days
35°C	45 min	1 hr	5 days	30 min	45 min	2 days

- adequate ventilation must be continuously maintained during application and curing

**Pot life (at application viscosity)**

Paint temperature	Epinamel EH100	Epinamel EH120
15°C	10 hrs	6 hrs
25°C	6 hrs	3 hrs
35°C	3 hrs	1½ hr

**CUSTOMER SERVICE HOTLINE 132101 (Aust)**

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