

**CHARACTERISTICS**

Epoxy primer, containing active anticorrosion pigment - zinc phosphate, two component: I component symbol 7429-022-XX0, component II symbol 8222-077-001 (winter hardener version) or 8222-077-002 (summer hardener version). Can be applied on not well cleaned surfaces. The coating is not sensitive to water (rain) when cured to touch dry degree. Cures at temperatures down to -10°C. Semi-gloss, flexible coating, tough and resistant to urban, marine and industrial environment. When exposed to sun radiation, the tint of the coating may change.

**PRODUCT USE****For priming of:**

- steel, thermally sprayed steel, aluminum, galvanized or concrete constructions operating in sea, coastal and industrial environment.

**PROPERTIES**

Density (approx.), g/cm <sup>3</sup>	1,4
Flash point, °C	21
Typical dry film thickness, µm	100
Typical wet film thickness, µm	160
Theoretical coverage at 100µm, dm <sup>3</sup> /m <sup>2</sup>	0,16
Volume solids (about), % vol.	62
Recommended number of coats	1 - 2
Volatile Organic Compounds, g/dm <sup>3</sup>	350

Given data may vary slightly for different colours as well as due to normal manufacturing tolerances.

**COLOUR**

400 green                      810 light grey

**SURFACE PREPARATION**

- Before cleaning of surface, it is recommended to wash it with water with addition of OLICLEAN 123 and then rinse with fresh water.
- Steel surface dry, salt- and grease-free, cleaned to the degree of cleanliness according to PN-ISO 8501-1, at least St 3 for external surfaces. For internal surfaces at least St 2 according to PN-ISO 8501-1. Porous surfaces should be primed with thinned EPINOX<sup>®</sup> 22 paint.
- Coating gets highest mechanical and chemical resistance when applied directly to sandblasted steel surfaces (cleanliness at least Sa 2½ according to PN-ISO 8501-1).
- Steel surface primed with shopprimer should be dry and free of contamination. Rust, mechanical, thermal damage or any defects of surface should be cleaned to at least St 3 according to PN-ISO 8501-1 for external surfaces. For internal surfaces cleanliness at least St 2. Shopprimed coating without visible defects, roughened mechanically. Surface dry, salt-, dust- and grease-free.
- Not stabilized hot dip galvanized steel surfaces and dry aluminium surfaces, should be tarnish with non-metallic abrasive. All contamination eg. oil, grease, fluxing agent, etc should be removed. Galvanized surface should be contaminant-free.

- Stabilized hot dip galvanized steel surfaces should be without any products of zinc corrosion (white rust free) and without any contaminants. For cleaning hot water, water under pressure, steam, abrasives or manual mechanic tool cleaning can be used. The surface for painting should be dry, dust-, grease- and salt-free.
- Thermally sprayed galvanized and aluminium surfaces should be dry and primed immediately with thin layer of diluted Epinox<sup>®</sup> 22 or shopprimer, before any condensation occurs. The surface for painting should be dry, dust-, grease- and salt-free.
- Concrete surface fully cured (minimum 28 days at 20°C), clean, without cracks, crevices and laitance, sand blasted or cleaned with wire brush. Surface must be dry (relative humidity max. 4%), fat-, salt-, dust- and inclusions-free. Before painting it is recommended to prime surface using diluted varnish EPINOX<sup>®</sup> 12.

**PAINT PREPARATION**

Stir thoroughly component I, mix with component II according to the following mixing proportions:

	by weight	by volume
component I	100	100
component II	12	20

Mix thoroughly components before use.

For priming porous surfaces dilute paint with Thinner 564 (up to 20%).

Minimum temperature of the paint before painting: 15°C.

Pot life in 20°C:

8h (winter version)

6h (summer version)

**APPLICATION METHODS**

Airless spray, brush. When using a brush it may be necessary to apply several layers to achieve recommended coating thickness.

Airless spray parameter:

Nozzle size	0,43 - 0,58 mm
Nozzle pressure	20 - 25 MPa

**THINNING**

Not required.

When necessary (for example – thickening of product) use Thinner 564 (see Technical Information).

For cleaning tools: Thinner 564.

**APPLICATION CONDITIONS****Application and curing conditions:**

- minimum surface temperature: -5°C (surface frost- and ice-free) and at least 3°C higher than dew point,
- minimum temperature of paint itself +15°C,
- ambient temperature not lower than -10°C (for winter version) or +5°C (for summer version),
- relative air humidity below 95%,
- good ventilation.

**Drying time (in 20°C):**

dust dry - 1,5 h  
touch dry - 4 h

**Overcoating intervals:**

temperature		20°C	10°C	5°C	0°C	-5°C
minimum	winter version	4h	4,5h	6h	8h	14h
	summer version	4h	8h	12h	-	-
maximum	unlimited*					

Given indications relates to the recommended coating thickness, drying in good ventilation conditions. Overcoating times may be different with a change of temperature, ventilation, number of layers and the thickness of the coating.

\*If the coating is not chalked and is free of any contamination, there is no limit for overcoating. The best intercoat adhesion is when following coat is applied before the first one is totally cured. If the coating was exposed to atmospheric conditions or long-term solar radiation, the surface preparation should be focused on.

**Full cure:**

temperature		20°C	10°C	5°C	0°C	-5°C
minimum	winter version	2 days	3 days	6 days	12 days	18 days
	summer version	7 days	14 days	28 days	-	-

**SUBSEQUENT COAT**

OLIVA's epoxy, vinyl, acrylic or polyurethane paints.

**ADDITIONAL INFORMATION**

- Depending on application and type of construction, other thickness of a single layer can be assumed instead of recommended. Typical dry film thickness range using airless spray is from 80 to 150 µm. Changing the thickness of the coating changes the theoretical consumption, thickness, weight of dry coating, drying time, time of recoating and finishing work.
- In high corrosive environment it is recommended to prepare surface as good as possible and to apply following layers of paint before full curing of previous layers to achieve best protection.
- Please note that increasing degree of cleanliness of surface results exceeding of coating's durability.

**SHELF LIFE**

The storage stability is shown on the label. Store in cool place and in tightly closed can.

**CAUTION!**

During application and drying of the coating flammable and harmful substances are emitted. It is important not to inhale the fumes of the product and to avoid contact with the eyes and skin. Use only in well ventilated rooms. Detailed information about dangerous substances in the products and threats are included in the safety data sheet, which are available at the Customers' request.

*The information of this data sheet is normative, based on laboratory tests and our experience. It is available for our Customers' convenience. We accept however, no liability for the actual application work, as this is to great extend dependent on the conditions during handling and application. We accept no liability for any damage from misapplication of the product. The technical terms in the instruction are explained at the beginning of the catalogue. We reserve the right to include changes in the instruction without prior notice.*