

**CHARACTERISTICS**

Epoxy primer, MIO pigmented, thixotropic, high solid, cures at low temperatures, two component: I component symbol 7423-076-XX0, component II symbol 8222-076-000 (winter hardener) or 8222-078-000 (summer hardener). Semi-gloss, flexible coating, tough and resistant to mechanical factors, water, salt and alkali solutions, oil, fuel oil, diesel, motor gasoline and some organic solvents. When exposed to sun radiation, the tint of the coating may change.

In case there is a need to get short curing time, it is recommended to use 8222-077-006 hardener.

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

- steel or concrete constructions operating in sea, coastal and industrial environment,
- steel, cast iron or concrete constructions exposed to destructive mechanical factors.

The phenalkamine-based hardeners: 8222-076-000 and 8222-077-006, enables curing even in temperatures below 0°C.

The hardener 8222-078-000, polyamide-based, cures in temperatures above +5°C.

**PROPERTIES**

Density (approx.), g/cm <sup>3</sup>	1,5
Flash point, °C	18
Typical dry film thickness, µm	100
Typical wet film thickness, µm	130
Theoretical coverage at 100µm, dm <sup>3</sup> /m <sup>2</sup>	0,13
Volume solids (about), % vol.	76
Recommended number of coats	1 - 2
Volatile Organic Compounds, g/dm <sup>3</sup>	290

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

**COLOUR**

250 red oxide                      820 ash 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 Sa 2½ for submerged areas or at least St 3 according to PN-ISO 8501-1 for external surfaces. For internal surfaces - at least St 2 according to PN-ISO 8501-1. Porous surfaces should be primed with tinted EPINOX<sup>®</sup> 76 paint.

- Coating gets the highest mechanical and chemical resistance by applying directly to sandblast cleaned steel surfaces (cleanliness at least Sa 2½ according to PN-ISO 8501-1).
- Coating of epoxy paint dry, salt-, dust- and grease-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	19

When using 8222-077-006 hardener the mixing proportions are:

	by weight	by volume
component I	100	100
component II	16	24

Mix thoroughly components before use.

Priming porous surfaces after thinning with Thinner 564 (up to 20%).

Minimum temperature of the paint: 15°C.

**Pot life:**

Temperature	Hardener 076	Hardener 078	Hardener 077-006
30°C	1,5 h	1,5 h	1 h
20°C	3,5 h	3,5 h	2 h
10°C	5 h	5 h	3 h
0°C	10 h	-	4 h

**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	0,48 - 0,63 mm
Nozzle pressure	20 - 25 MPa

**THINNING**

When necessary (for example – thickening of product, application in low temperature, application of low film thickness) use Thinner 564 up to 5% (see Technical Information). For cleaning tools: Thinner 564.

**APPLICATION  
CONDITIONS**

Application and curing conditions	Hardeners 076 and 077-006	Hardener 078
minimum surface temperature (surface at least 3°C higher than dew point)	-5°C (surface frost- and ice-free)	+5°C
minimum temperature of paint itself	15°C	15°C
ambient temperature not lower than	-10°C	+5°C
relative air humidity below	95%	85%
good ventilation		

Drying time (in 20°C):	With hardener 076	With hardener 078	With hardener 077-006
Dust dry	2 h	6 h	3 h
Touch dry	6 h	8 h	4,5 h
Dry for transport	10 h	16 h	6 h

Overcoating intervals:					
In temperature	20°C	10°C	5°C	0°C	-5°C
<b>With hardener 076</b>					
Minimum, h	5	6	9	14	24
Maximum, h	In internal conditions unlimited				
	In external conditions with sun radiation exposition 1 month*				
<b>With hardener 078</b>					
Minimum, h	8	16	24	-	
Maximum, h	In internal conditions unlimited				
	In external conditions with sun radiation exposition 2 months*				
<b>With hardener 077-006</b>					
Minimum, h	4,5	5	8	12	20
Maximum, h	In internal conditions unlimited				
	In external conditions with sun radiation exposition 1 month*				

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.

\*Given indications relates to next coating of Epinox<sup>®</sup> 76. In case of topcoats, especially other than epoxy, operating in external conditions, the maximum overcoating time should be 1 month.

In case of chalking, it is recommended to remove degradation products.

Full cure:					
In temperature	20°C	10°C	5°C	0°C	-5°C
With hardener 076, days	2	3	6	12	18
With hardener 078, days	7	14	21	-	-
With hardener 077-006, days	2	3	5	10	16

**SUBSEQUENT COAT**

**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 200  $\mu\text{m}$ . Changing the thickness of the coating changes the theoretical consumption, thickness, weight of dry coating, drying time, time of recoating and finishing work.
- Single coating of dry film thickness 160 – 200  $\mu\text{m}$  (wet film thickness 250 - 320 $\mu\text{m}$ ) can be used as a stand-alone protection of internal surfaces, for example ship's holds.
- 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.*