

CHARACTERISTICS

Epoxy primer, MIO pigmented, thixotropic, high solid, cures at low temperatures (down to -10°C), two component: I component symbol 7423-077-XX0, component II symbol 8222-077-000. Semi-gloss, flexible coating, tough and resistant to mechanical factors, also resistant to water, salt and alkali solutions, oil, fuel oil, diesel, motor gasoline and some organic solvents. Coating resistant to the elements occurring in the cathodic protection. Under the influence of the sun radiation, tint of the coating may change.

PRODUCT USE**For priming of:**

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

For self-protection of:

- steel or concrete constructions and elements, when high decorative value of coating is not required,
- steel tanks for most of chemical media, i.e. water, sewage, petroleum products,
- ship's holds and internal surfaces.

PROPERTIES

Density (approx.), g/cm ³	1,5
Flash point, °C	18
Typical dry film thickness, µm	100
Typical wet film thickness, µm	160
Theoretical coverage at 100µm, dm ³ /m ²	0,16
Volume solids (about), % vol.	65
Recommended number of coats	1 - 4
Volatile Organic Compounds, g/dm ³	300

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

COLOUR

250 red oxide	820 ash grey	990 black
420 green	860 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 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 thinned EPINOX[®] 77 paint.
- Coating gets highest mechanical and chemical resistance by applying directly to blast cleaned steel surfaces (cleanliness at least Sa 2½ according to PN-ISO 8501-1).

- Steel surface previously primed using shopprimer should be dry and free of contamination. Rust, mechanical, thermal damage or any defects of surface should be cleaned to Sa 2 according to PN-ISO 8501-1 for submerged surfaces, St 3 for external above-water surfaces. For internal surfaces at least St 2. Shopprimed coating without visible defects, abrasive blasted (submerged surfaces) or roughened mechanically (external surfaces).
- Surface dry, salt-, grease- and dust-free.
- Coating of epoxy primer dry, grease- and dust-free.
- Concrete surface fully cured (minimum 28 days at 20°C), rough, without cracks, crevices and laitance, jet cleaned or cleaned using a 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[®] 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.

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

Minimum temperature of the paint: 15°C.

Pot life in 20°C - 3,5 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

Not required.

When necessary (for example – thickening 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,
- relative air humidity below 95%,
- good ventilation.

Drying time (in 20°C):

dust dry	- 2 h
touch dry	- 6 h

Overcoating intervals:

temperature	20°C	10°C	5°C	0°C	-5°C
minimum	6h	7,5h	9h	14h	24h
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.

* It is a rule, that unlimited overcoating interval is for Epinox[®] 77. Due to higher sensitivity of topcoats to surface cleanness, overcoating time should be short. It is very important especially when applying non-epoxy systems or operating in aggressive environment.

Full cure:

temperature	20°C	10°C	5°C	0°C	-5°C
minimum	2 days	3 days	6 days	12 days	18 days

SUBSEQUENT COAT

OLIVA's epoxy, vinyl, acrylic or polyurethane paints. EPINOX[®] 77 can be used as a stand-alone protection for internal surfaces of tanks if applied for minimum coating thickness of 300µm.

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 µm. 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 µm (wet film thickness 250 – 320 µm) can be used as a stand-alone protection of internal surfaces, for example for ship's holds.
- In high corrosive environment it is recommended to prepare surface as good as possible and to apply successive 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.