DS 024

EPINOX 87

6 16.11.2015

PAINT TYPE

Epoxy epoxy primer, MIO pigmented, thixotropic, high solid, two component, cured in low temperatures (from -10°C).

USAGE

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.

SPECIAL PROPERTIES

Flexible and hard coating, with good adhesion to surfaces and resistant to mechanical factors. The coating resistant to 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.

TECHNICAL DATA

Mixing ratio

Base (Comp. A): 100 parts by volume
Hardener (Comp. B): UTWARDZACZ 087 19 parts by volume

Pot life; +20°C

3,5 h

Solids

81±2% by volume

Total mass of solids

abt. 1320 g/l

Volatile organic compounds (VOC)

abt. 290 g/l

Recommended film thickness and theoretical spreading rate

Dry film (µm)	Wet film (µm)	Theoretical spreading rate (m^2/l)
100	125	8,0
200	250	4,0

As many of the paint's properties will change if too thick coats are applied, it is not recommended that the product is applied to a film thickness that is more than double of the thickest recommended film.

Practical spreading rate

The values depend on the application technique, surface conditions, overspray, etc.

Drying time at +20°C / 50% RH (for 100 µm dry film thickness)

- **dust free (PN-C-81519)** after 2 h
- **touch dry (PN-C-81519)** after 6 h
- **fully cured** after 2 days

Overcoatable (for 100 µm dry film thickness)

Temperature	By itself		By topcoats	
	Min.	Max.	Min.	Max.
-5°C	24 h	1 month*	24 h	1 month
0°C	14 h	1 month*	14 h	1 month
+5°C	9 h	1 month*	9 h	1 month
+10°C	6 h	1 month*	6 h	1 month
+20°C	5 h	1 month*	5 h	1 month

*unlimited in internal conditions. 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. In case of chalking, it is recommended to remove degradation products.

Thinner

ROZCIEŃCZALNIK 564.

continuation is on the next page

Clean up ROZCIEŃCZALNIK 564.

Finish Matt

Colours 250 red oxide 820 ash grey 860 light grey* (check additional information)

SAFETY MARKINGS See Safety Data Sheet

DIRECTION FOR USE

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 cleaned to the degree of cleanliness according to ISO 8501-1: Sa 2½ for submerged areas or at least St 3 for external surfaces. For internal surfaces at least St 2. Porous surfaces should be primed with tinted Epinox 87 paint. Coating gets the highest mechanical and chemical resistance by applying directly to sandblast cleaned steel surfaces (cleanliness at least Sa 2½). Dry, salt-, grease- and dust-free surface.
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.

Mixing of the components

Take into consideration the pot life of the mixture when estimating the amount to be mixed at a time. Before painting the base and hardener are mixed in right proportions. Stir thoroughly down to the bottom of the vessel. Mixing by machine is recommended, for example a slow-rotating hand-drill equipment with a mixer. Inadequate stirring or incorrect mixing ratio results in imperfect curing and impaired film properties.

Application conditions

During the application and drying period the minimum temperature of the surface shall be above -5°C (frost- and ice-free surface), at least 3°C above the dew point of the ambient air. Minimum ambient air temperature -10°C. Maximum humidity 95%. Minimum paint temperature +15°C. Adequate ventilation during application and drying.

Application

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

ADDITIONAL INFORMATION

When preparing painting specification, depending on subject and type of construction, different dry film thickness than recommended can be assumed. During airless spray application typical dry film thickness range is between 80 and 200 µm. Different dry film thickness than recommended causes change in theoretical spreading rate, wet film thickness, weight of dry film thickness, drying time, overcoating time and ready for handling time. In high corrosive environment it is recommended to prepare surface as best as possible and to apply successive layers of paint before full curing of previous layers to achieve best protection. The 860 color contains active anticorrosive pigments (zinc phosphate, aluminium) and MIO. The color is available only on customers' request. The storage stability is shown on the label. Store in cool place and in tightly closed can.