

CHARACTERISTICS

Modified epoxy primer, fast curing with amine adduct, two component: I component symbol 7429-061-XX0, component II symbol 8222-061-000. Can be applied on wet and not well cleaned surfaces, humidity insensitive. The coating cures very fast even in low temperatures and is not sensitive to water (rain) when cured to touch dry degree.. High reactive coating with long pot life. Flexible coating, with good adhesion to surfaces and resistant to mechanical factors. The coating resistant to weathering, 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.

PRODUCT USE**For priming of:**

- steel constructions, thermally sprayed steel, aluminium, galvanised or concrete operating in sea, coastal and industrial environment,
- steel and cast iron constructions operating in immersion.

PROPERTIES

Density (approx.), g/cm ³	1,3
Flash point, °C	21
Typical dry film thickness, µm	40
Typical wet film thickness, µm	80
Theoretical coverage at 40µm, dm ³ /m ²	0,08
Volume solids (about), % vol.	51
Recommended number of coats	1 - 3
Volatile Organic Compounds, g/dm ³	380

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

COLOUR

250 red oxide 840 metallic 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 cleaned to the degree of cleanliness according to PN-ISO 8501-1:
 - Sa 2 for constructions used in immersion and in the aggressive environment, when long term protection is needed;
 - St 3 for constructions used in industrial environment;
 - St 2 for constructions used in atmospheric conditions and for internal surfaces.
- Dry, salt-, grease-, dust- and poor attached rust-free surface. It is possible to use on wet surfaces.
- 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 at least Sa 2 according to PN-ISO 8501-1 for immersion and St 3 for surfaces in atmospheric conditions. For internal surfaces St 2 is acceptable.

- Shopprimed coating without visible defects, roughened mechanically. Surface dry, salt-, dust- and grease-free.
- No 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 zinc corrosion products free (white rust free) and any contaminant-free. 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 EPIRUST[®] 2002, EPIRUST 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), 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	15	22

Mix thoroughly components before use.

Pot life in 20°C: 8h

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	0,38 - 0,48 mm
Nozzle pressure	15 - 20 MPa

THINNING

Not recommended.

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),
- minimum temperature of paint itself +15°C,
- ambient temperature not lower than -10°C,
- relative air humidity below 95%,
- good ventilation.

The coating can be applied on wet and cold surfaces (temperature below dew point). The wet surfaces means:

- surfaces after hydroblasting;
- cold surfaces with temperature below dew point, without water observed.

Drying time (in 20°C):

- dust dry - 25 min,
- touch dry - 50 min,

Overcoating intervals (depending on coatings and exposure conditions):

epoxy coatings							
temperature	30°C	20°C	10°C	5°C	0°C	-5°C	-10°C
minimum	35 min	40 min	1h	3 h	5h	9 h	15 h
maximum	unlimited						

vinyl, acrylic, polyurethane coatings							
temperature	30°C	20°C	10°C	5°C	0°C	-5°C	-10°C
minimum	50 min	60 min	2 h	4 h	6 h	10 h	20 h
Maximum for C1 to C4 corrosive environment	unlimited						
Maximum for C5 corrosive environment	6 h	24 h	2 days	3 days	7 days	12 days	26 days

Due to higher sensitivity of topcoats to surface cleanness, overcoating time should be short, preferably as short as full cure coating time in related temperature.

To obtain good intercoat adhesion surface cleanest is needed. It is important in case of long overcoating intervals. When the coating was applied in unfavourable conditions (high humidity, insufficient ventilation) it is recommended to wash primer surface down with water and dry.

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.

Full cure:

temperature	40°C	30°C	20°C	10°C	5°C	0°C	-5°C	-10°C
time	3,5 h	14 h	38 h	60 h	4 days	8 days	14 days	28 days

SUBSEQUENT COAT

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

ADDITIONAL INFORMATION

- Depending on destination and type of construction, other thickness of a single layer can be assumed than recommended in information. Typical dry film thickness range using airless spray is from 35 to 90 microns. 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 best as possible and to apply successive layers of paint before full curing of previous layers to achieve best protection.
- It is not recommended to apply EPIRUST® 2002 on wet or covered with drops surfaces.

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 health threatening substances are emitted. It is important to avoid inhaling the fumes of the product and contact with the eyes and skin. Use only in well ventilated rooms. Detailed information on dangerous substances contained in the products and threats connected with them are included in the specification cards of the dangerous substances, which we make 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.