

**CHARACTERISTICS**

Modified epoxy primer, cured with polyamide, two component: I component symbol 7429-060-XX0, component II symbol 8222-897-000. 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.

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

- steel, aluminium or galvanised constructions operating in sea, urban and industrial environment,
- steel, cast iron and aluminium constructions operating in immersion.

**PROPERTIES**

Density (approx.), g/cm <sup>3</sup>	1,4
Flash point, °C	21
Typical dry film thickness, µm	40
Typical wet film thickness, µm	80
Theoretical coverage at 100µm, dm <sup>3</sup> /m <sup>2</sup>	0,08
Volume solids (about), % vol.	48
Recommended number of coats	1 - 3
Volatile Organic Compounds, g/dm <sup>3</sup>	450

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

**COLOUR**

250 red oxide                      930 dark 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 2½ for constructions used in immersion and in the aggressive environment, when long term protection is needed;
  - Sa 2 for constructions used in atmospheric conditions; well attached tarnish rust is acceptable;
  - St 3 for constructions used in atmospheric conditions.Dry, salt-, grease-, dust- and poor-attached-rust-free surface.
- 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 mechanical tools 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.

**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	24	40

Mix thoroughly components and wait 15 minutes (at 20°C) before use.  
Pot life in 20°C: 6h

**APPLICATION METHODS**

Airless spray, brush.

Airless spray parameter:

Nozzle size	0,38 - 0,48 mm
Nozzle pressure	10 - 15 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,
- relative air humidity below 85%,
- good ventilation.

**Drying time (in 20°C):**

dust dry	- 1 h
touch dry	- 5 h

**Overcoating intervals:**

temperature	20°C	10°C
minimum	8h	16h
maximum	unlimited*	

\* It is a rule, that unlimited overcoating interval is for epoxy coatings. 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.

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	20°C	10°C
time	7 days	14 days

**SUBSEQUENT COAT**

OLIVA's epoxy, coal-tar 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 35 to 60 µm. Changing the thickness of the coating changes the theoretical consumption, thickness, weight of dry coating, drying time, time of recoating and finishing work.
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**SHELF LIFE**

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

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**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.

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*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.*