

CHARACTERISTICS

Epoxy primer, thixotropic, low temperature cured, two component: I component symbol 7429-080-XX0, component II symbol 8222-080-000. The coating can be applied on wet and poorly prepared surfaces, is not sensitive to water (rain) when cured to touch dry degree. The coating is flexible and mechanically resistant. The coating resistant to water, salt 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 or self-protection of (when high decorative value of coating is not required):

- steel, aluminium or concrete constructions operating in sea and industrial environment,
- steel constructions and elements or concrete elements operating in immersion.

For renovation of:

- old alkyd-, acrylic-, polyvinyl-, chlorinated rubber, epoxy- and polyurethane coatings.

PROPERTIES

Density (approx.), g/cm ³	1,5
Flash point, °C	21
Typical dry film thickness, µm	100
Typical wet film thickness, µm	130
Theoretical coverage at 100µm, dm ³ /m ²	0,13
Volume solids (about), % vol.	80
Recommended number of coats	1 - 3
Volatile Organic Compounds, g/dm ³	280

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

COLOUR

250 red oxide 820 ash grey 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 cleaned to the degree of cleanliness according to PN-ISO 8501-1:
 - Sa 2½ for constructions used in the aggressive environment, where long term protection is needed;
 - St 3 for constructions used in the industrial environment;
 - St 2 for constructions used in coastal and urban environment and for internal exposure.

Surface dry and without any contamination (grease-, salt-, dust-free). It is possible to use it on wet surfaces. Porous surfaces primed with tinted EPIRUSTIK® 2000 paint.

- 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 immersion, St 3 for external exposure. For internal surfaces cleanliness 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.
- Dry aluminium surface, tarnished, grease-, salt- and dust-free.
- Old coating grease-, salt- and dust-free. It is recommended to remove all loose parts and rust, wash it down with water under pressure. It is recommended to make small scale trials before application on wet surfaces or old coatings.
- 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	18	30

Mix thoroughly components and wait 10 minutes (in 20°C) before use.

Priming porous surfaces after thinning with Thinner 779 (15-20%).

Minimum temperature of the paint: 15°C.

Pot life in 20°C - 2,5 h,

APPLICATION METHODS

Airless spray, brush. When using a brush it is recommended to dilute paint (3% of Thinner 779) and it may be necessary to apply several layers to achieve recommended coating thickness. For wet and rusted surfaces it is recommended to apply first layer by brush.

Airless spray parameter:

Nozzle size	0,48 - 0,63 mm
Nozzle pressure	15 - 20 MPa

THINNING

Not required.

When necessary (for example – thickening of product) use Thinner 779 (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 surfaces and surfaces with 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):

temperature	20°C	10°C	5°C	0°C	-5°C	-10°C
dust dry	3h	7h	10h	13h	20h	28h
touch dry	6h	10h	16h	24h	34h	42h

Overcoating intervals:

temperature	20°C	10°C	5°C	0°C	-5°C
minimum	8h	12h	16h	24h	34h
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 EPIRUSTIK® 2000 coating. 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	-10°C
minimum	3 days	6 days	10 days	25 days	32 days	38 days

SUBSEQUENT COAT

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

In case of painting in unfavourable conditions (high humidity, insufficient ventilation) before painting with following paint it is recommended to wash it down coating with water.

EPIRUSTIK® 2000 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 70 to 170 µm. 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 good as possible and apply successive layers of paint before full curing of previous layers to achieve the best protection.
- It is not recommended to apply EPIRUSTIK® 2000 on wet or covered with water 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 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.