

CHARACTERISTICS

Epoxy primer, thixotropic, aluminium pigmented, two component: I component symbol 7421-060-XX0, component II symbol 7421-060-000. The semi-gloss coating with good adhesion to surfaces, flexible and resistant to mechanical factors. The coating resistant to water, salt solutions, oil products and some organic solvents. When exposed to sun radiation, the tint of the coating may change.

PRODUCT USE**For priming:**

- steel, cast iron or aluminium constructions operating in water, in sea, urban and industrial environment,
- thermally sprayed steel constructions operating in urban and industrial environment.

For self-protection of:

- steel, thermally sprayed steel or aluminium constructions operating in atmospheric environment, where high decorative value of coating is not required.

PROPERTIES

Density (approx.), g/cm ³	1,2
Flash point, °C	23
Typical dry film thickness, µm	100
Typical wet film thickness, µm	150
Theoretical coverage at 100µm, dm ³ /m ²	0,15
Volume solids (about), % vol.	67
Recommended number of coats for priming	1 - 2
for self-protection	2 - 3
Volatile Organic Compounds, g/dm ³	330

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 2½ for constructions used in immersion and aggressive environment, where long term protection is needed;
 - Sa 2 for constructions used in the industrial environment; well attached tarnish rust is acceptable;
 - St 3 for constructions used in atmospheric environment; surface with corrosion should be primed with EPIRUST® or thinned EPIRUSTIX® (10-15% of thinner 564);
- Surface dry and without any contamination (grease-, salt-, dust-free).
- Dry aluminium surface, tarnished, grease-, salt- and dust-free.
- Coating of epoxy paint dry, salt-, dust- and grease-free.
- Thermally sprayed surfaces should be dry and primed immediately with thin layer of diluted shopprimer, before any condensation occurs.

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	33	45

Mix thoroughly components and wait 15 minutes (in 20°C) before use.
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 564) and 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 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: +10°C and at least 3°C higher than dew point,
- relative air humidity below 80%,
- good ventilation.

Drying time (in 20°C):

dust dry	- 4 h
touch dry	- 14 h

Overcoating intervals:

temperature	20°C	10°C
minimum	14h	28h
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 EPIRUSTIX®. 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
minimum	7 days	14 days

SUBSEQUENT COAT

OLIVA's 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 60 to 150 μm . Changing the thickness of the coating changes the theoretical consumption, thickness, weight of dry coating, drying time, time of recoating and finishing work.

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.