



Paints Limited

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FOR SALES & TECHNICAL SUPPORT

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Product Name:	EPIDAC 2 HB FAST SET PRIMER
Reference Number:	79-498
Coating Type:	High Build Two-Pack Epoxy zinc phosphate primer reinforced with micaceous iron oxide pigmentation.
Typical Uses:	<p>For use on steel and galvanised surfaces especially where rapid over coating is required. Typical applications include lighting columns and general industrial plant.</p> <p>For site maintenance where rapid curing is an advantage.</p>
Colours Available:	Grey
Appearance of Dried Film:	Low Sheen Finish
Volume Solids:	55%
Dry Film Thickness:	Typical: 75 Microns Range: 50-100 Microns.
Theoretical Coverage:	7.3m ² per litre at 75 microns.
Drying Time At 20°C: (Will Vary With Temperature, Air Movement etc.)	Touch Dry: 30 mins. Firm Dry: 2-3 hours. Overcoat: 2 hours (single pack)/ 1 hour (two pack)
V.O.C.	390 gm/ltr.
Packaging:	5 litre composite packs.
Shelf Life:	2 years or longer in unopened containers when stored under cover in good storage conditions.
Storage:	Under cover within temperature range of 5°C to 32°C.
Surface Preparation:	Steel: Abrasive blast to Sa2½ (ISO 8501-1). New steel, free of millscale and/or rust should be degreased with Dacrylate Thinner R5. New Galvanised Steel: Normally applied direct to “weathered” galvanising or new galvanised steel pre-treated with ‘T’-Wash, ref: 150-23.

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Application Conditions: **Humidity**
Do not apply at relative humidities above 90%. Substrate temperature must be at least 3°C above dew point.

Temperature
Do not apply at temperatures below 5°C

Application: Thoroughly mix base component. Add activator and continue stirring until completely homogeneous.

Apply at an approximate wet film thickness of 140 microns to achieve a dry film thickness of 75 microns.

Airless Spray: Tip size:15-17 thou (0.38 – 0.43mm).
Tip Pressure: Min 2000 psi (135 Bar).

Conventional Spray:
May require up to 10% addition of Dacrylate Thinner R9 to achieve optimum application characteristics.

Brush: Small areas and sections can be brushed. Use a full wet brush. Do not attempt to 'brush out' or 'lay off'.

Mixing Ratio by Volume: 4 part base.
1 part activator.

Pot Life (At 20°C): 2 hours.

Clean-Up: Dacrylate Thinner R9

Health And Safety: Please see relevant MSDS sheet.

Data sheets are issued to supply **general information** on the product but without warranty. Since conditions of service and application are beyond our control, we cannot accept claims for loss, damage etc., based on this information. Dacrylate will not accept any claim for consequential or incidental damages.

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