

CODE: EP-216

PRODUCT NAME:

Polyamide Cured Epoxy Shop Primer

DESCRIPTION:

EP-216 is a two component polyamide cured red oxide epoxy shop primer suitable for controlled cathodic protection of steel during fabrication and assembly. It would be a weathering protection for 3 to 6 months. EP-216 is compatible with most overcoating systems.

TECHNICAL DATA:

Binder	Epoxy resin
Pigment	Red Iron Oxide
Finish	Flat
Shade	Red brown
Specific gravity after mixing	1.3±0.1Kg / Lit
Volume solid	40±3 %
Flash point	25 °C
Typical dry film thickness	30-50 Microns per one coat
Number of coat	One
Mixing ratio by weight	Base : 100 parts Hardener : 16 parts
Application method	Conventional or airless spray , brush , roller
Thinner / Cleaner	T-200
Weight of added thinner	15-20%
Induction Time at <25 °C	30 minutes
Theoretical spreading rate (at 30 microns)	13 M ² /Lit
Packing	Base : 25 Kg Hardener : 4 Kg
Shelf life	12 Months

Drying Time

Temp	Touch dry	Hard dry	Overcoat	
			Min	Max
15°C	120 minutes	20 hours	18 hours	6 months
25°C	90 minutes	15 hours	15 hours	6 months
40°C	60 minutes	12 hours	10 hours	6 months

Note: Drying times are dependent on applied film thickness; all data in this catalogue are reported at recommended DFT.

Pot life

Temp of paint	15°C	25°C	40°C
Pot life	10 hours	8 hours	4 hours

Surface preparation

All surfaces to be coated clean dry and free from contamination. Prior to paint application all surfaces should be assessed and treated in accordance with ISO 8504:1992.

Where necessary, remove weld spatter, and where required smooth weld seams and sharp edges.

Oil or grease should be removed in accordance with SSPC-SP1 solvent cleaning.

Abrasive Blast cleaning

Abrasive blast clean to Sa2 ½ (ISO 8501-1:1988) or SSPC-SP10. If oxidation has occurred between blasting and application of 216, the surface should be reblasted to the specified visual standard. Angular surface profile of 30-50 microns is recommended.

-Surface preparation shall not take place in the following conditions:

- At temperature below 5 °C.
- When the relative humidity greater than 85%.
- When the metal surface temperature is less than 3 °C above the dew point.
- Outside day light hours on exterior locations.

- Apply EP-216 as soon as possible after surface preparation to prevent rusting.

Application Method

Material is supplied in two containers as a unit. Always mix a complete unit in the proportion supplied. Once the unit has been mixed it must be used within the working Pot life specified.

1-Agitate part A with a power agitator.

2-Combined entire contents of curing agent (part B) With Base (Part A) and mix thoroughly with power agitator.

Application Equipments

Air less Spray	Tip range 0.017-0.021 inch Total output pressure at spray tip not less than 141 Bar (2000 psi)
Air Spray	Nozzle orifice 1.8-2mm Nozzle pressure: 2-4 Bar (29-56 psi)
Brush	Typically 30mic can be achieved.
Roller	Typically 30 mic can be achieved.

Flush Equipment with recommended Cleaner before and after use.

ENVIRONMENTAL CONDITIONS:

- To prevent moisture condensation during application, surface temperature must be at least 3 °C above the dew point.
- Never apply coatings under reverse environmental condition.
- In hot climate, material temperature should be 20 to 25 °C prior to mixing; otherwise pot life becomes very short.
 - For satisfactory cure, air and surface temperature must be above 10 °C
 - Paint shall not be applied when wind speed is in excess of 7 m/s

Air temperature	10 to 40 °C
Surface temperature	10 to 50 °C
Material temperature	10 to 30 °C
Relative humidity	Max 80 %

Health and Safety:

This product is Flammable. Keep away from heat and open flame .Keep container closed .Use with adequate ventilation. Avoid prolonged and repeated contact with skin. If used in confined areas, observe the following precautions to prevent hazards of fire or explosion or damage to the health:

- 1-Circulate adequate fresh air continuously during application and drying.
- 2-Use fresh air masks and explosion proof equipment.
- 3- Prohibit all flames, sparks, welding and smoking.