MEGENAX® 2-COMPONENT EPOXY PRIMER

PRODUCTINFORMATION

Designation of type	⇒ EP 710	State of 4/18
Product description	⇒ 2-component epoxy primer with very good protection against corrosion ⇒ High chemical resistance ⇒ Excellent adhesion to steel, aluminium, zinc, stainless steel, GFRP and so on ⇒ High stability on vertical surfaces ⇒ Recoatable with all 1- and 2-component top coats	
Application area	⇒ General industry, steel industry, heavy protection against corrosion	
Binder	⇒ Polyaminoamide-curing epoxy resin	
Substrate/Preparation	⇒ Steel: at least degrease, better hand or eccentric sanding St 2-3 (P80- P220) or sand blasted to Sa 2 ½ DIN EN ISO 12944, part 4 ⇒ Cast iron: sand blasted to Sa 2 ½ DIN EN ISO 12944, part 4 ⇒ Aluminium: sweeping or hand sanding ⇒ Hot dip galvanized: sweeping, hand sanding or wetting agent washing DIN EN ISO 12944, part 4 ⇒ Stainless steel: at least degrease, slight sanding or pickling ⇒ GFRP, hard-PVC: slight sanding, for example with Scotch-Brite type A (fine) ⇒ All surfaces dry, free of fat, oil, grease and dirt	
Processing	⇒ Brushing, rolling undiluted, max. 10 % thinner VS 50; because of the fast drying brush marks are possible ⇒ Gravity feed gun: 1.6-2.0 mm nozzle, 3-4 bar atomisation pressure, 15-20 % thinner VS 50 ⇒ HVLP: 1.7-2.2 mm nozzle, 1.5-2.0 bar atomisation pressure, 10-15 % thinner VS 50 ⇒ Double-diaphragm-pump: 1.0-1.2 mm nozzle, 2-4 bar atomisation pressure, material pressure 0.8-2.0 bar, 10-15 % thinner VS 50 ⇒ Airmix: 0.28-0.33 mm nozzle, 3-4 bar atomisation pressure, material pressure from 70 bar up, 10-15 % thinner VS 50 ⇒ Airless: from 0.33 mm nozzle up, material pressure from 150 bar up, 5-10 % thinner VS 50 ⇒ Electrostatic: optional adjustable ⇒ Dependent on film thickness 1-2 spraying cycles, 3-6 minutes intermediate flash off time ⇒ Ambient temperature at least + 10° C, relative air humidity: max. 75 % ⇒ Object temperature: at least. + 10° C and at least 3° C above the dew point	
Viscosities	⇒ Coating, rolling, airless: 25-35 s / 6 mm DIN (hardened) ⇒ Compressed-air spraying: 25-40 s / 4 mm DIN	
Mixing ratio	⇒ 10 : 1 by weight ⇒ Allow to pre-react for approx. 30 minutes to improve the curing process	
Hardener	⇒ SO 010 B, thoroughly mix primer and hardener, then thin if necessary	
Pot life	⇒ 12-15 hours, no processing under +10° C	

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Thinner	⇒ VS 50	
Drying time at 20° C	⇒ Dust-dry	after approx. 15 minutes
	⇒ Tack-free	after approx. 30-60 minutes
	⇒ Ready for installation	after 4-6 hours
	⇒ Complete drying	after 1-2 days
Recoatability	⇒ Depending on the film thickness after a few hours or 1-2 days with good ventilation	
	⇒ With all 1- and 2-component top coats	
	⇒ In case of doubt, check the recoatability before coating	
Colour	⇒ Light grey	
Degree of gloss	⇒ Flat	
Specific weight	⇒ Approx. 1.45 g/cm³	
Solid matter content	⇒ Approx. 72 % (percent by weight)	
Solvent content	⇒ Approx. 28 % (percent by weight)	
Film thickness	⇒ 50-120 µm dry film thickness / 120-290 µm wet film thickness	
	⇒ At sand blasted to Sa 2½ (roughness depth 45 µm) at least 60 µm dry film thickness	
Theoretical coverage	⇒ Approx. 7,0 m²/kg at 50 µm dry film thickness	
Practical consumption	⇒ Compressed-air spraying:	approx. 0.20 kg/m² or 4.9 m²/kg at 50 µm dry film thickness
	⇒ Airless:	approx. 0.29 kg/m² or 3.5 m²/kg at 80 µm dry film thickness
VOC-value ready to use	⇒ 460 g/l	
	⇒ Limiting value paint material for buildings: 500 g/l	2004/42/IIA(j)(500)460
	⇒ Limiting value car repair coating: 540 g/l	2004/42/IIB(c)(540)460
	⇒ Limiting value industrial coating: no specification Coating of other metal and plastic surfaces	
Standard packaging	⇒ Primer	10 kg
	⇒ Hardener	1 kg
Shelf life	⇒ Primer and Hardener at + 10 to + 30 °C and unopened packaging 1 year	
Material safety data sheet	⇒ Primer No. 004, hardener No. 057	
Flash point	⇒ > + 23° C	