

EPOCOAT 21 PRIMER

TECHNICAL DATA SHEET 5/24

PROPERTIES AND RECOMMENDED USAGE

Paint type

EPOCOAT 21 PRIMER is a two-component polyamide cured fast drying epoxy primer.

Typical and recommended uses

As a primer on blast cleaned steel surfaces in epoxy paint systems in corrosivity classes C2 - C5. Suitable also for zinc-, aluminium and stone based substrates. Can also be overcoated with polyurethane paints. The paint provides the opportunity to extended recoating times.

Chemical resistance

Used in recommended paint systems and correctly applied withstands continuous immersion to water, mineral- and fuel oil, kerosene and non-alcoholic petrol as well as occasional splashes and spillage of weak process chemicals.

Colour

Red, grey, beige, black and offwhite*
*white colour contains zinc phosphate

Finish

Matt

TECHNICAL DATA

Volume solids*	53 ± 2 %
Total mass of solids*	980 g/l
VOC value*	420 g/l

* Values are calculated

Mixing ratio

Resin	4 parts by volume
Cure	1 parts by volume

Pot life (+23 °C)

approx. 3 h after mixing

Packaging

	Volume (l)	Size of container (l)
Comp. A	8 / 16	10 / 20
Comp. B	2 / 4	2 / 4

Drying time 70 µm

	+10 °C	+23 °C
Surface dry	30 min	15 min
To touch	4 h	1 h
To recoat		
- same type of paint	6 h	2 h
- polyurethanes	8 h	3 h
- immersion service	24 h	16 h
- Normadur Aqua DTM	-	4 h
Fully cured	12 d	7 d

Drying times are typical on recommended film thicknesses at given temperatures.

Calculated theoretical coverage and recommended film thickness

Dry	Wet	Coverage
50 µm	95 µm	10.5 m ² /l
70 µm	135 µm	7.4 m ² /l
100 µm	190 µm	5.3 m ² /l

Practical coverage

Depends on wind conditions, structure to be painted, roughness of the surface and application method.

Thinner

OH 17, OH 31 (slow)

Cleaner

OH 17

APPLICATION INSTRUCTIONS

Surface preparations

All solid impurities that could prevent adhesion should be removed from the surfaces to be painted. Remove salts and other water soluble impurities using fresh water with brush, high pressure-, steam- or alkali cleansing. Remove grease and oils by alkali-, emulsion- or solvent cleansing (SFS-EN ISO 8504-3, SFS-EN ISO 12944-4). The surfaces should be rinsed carefully with fresh water after cleansing. Old, painted surfaces, in which maximum overcoating interval has expired, additional roughening with suitable method is recommended. The place and time for the surface preparation should be chosen correctly, to avoid contamination and moistening of the treated surface before the paint application.

Steel surfaces

Blast cleaning to minimum of Sa 2½ (SFS ISO 8501-1, SFS-EN ISO 8504-2).

Shop primed surfaces

Damaged or corroded surfaces should be blast cleaned to a minimum of Sa 2½. (SFS-ISO 8501-2, SFS-EN ISO 12944-4).

Aluminium surfaces

Remove grease, anodizing residues and other contaminants. Sand-sweeping before painting improves adhesion. When exposed to immersion sweep blast cleaning to Sa S is required.

Galvanized surfaces

Remove grease, zinc salts and other impurities. Sand sweeping before painting improves adhesion. Thinning is recommended.

Primer

EPOCOAT 21 PRIMER, NORMAZINC SE

Top coat

EPOCOAT 210, EPOTEX HB, NORMADUR HB, NORMADUR 65 HS, NORMADUR 90 HS, NOREPOX HS

Disclaimer

The above information is given to the best of our knowledge based on laboratory tests and practical experience. However, as the paint is often used under conditions beyond our control, we cannot guarantee anything but the quality of the paint itself. We reserve the right to change the given data without notice. Please contact our office for more specific information. The product is intended for professional use only. If there are deviations in the different language versions of the technical data sheets, the English version applies.

Environmental conditions during application

The surface should be dry and clean. During application and drying time the temperature of the paint, air, and surface should be above +10 °C and the relative humidity below 80 %. The surface temperature should be min 3 °C above the dew point of the air.

Method of application

Use airless spray or brush. Stir resin and cure separately and then mix both components thoroughly. The mixing ratio is 4 : 1 (resin : cure) by volume. If needed, 0 - 10 % thinner (OH 17) may be added. High pressure airless spray with a nozzle tip of 0.013" - 0.018" orifice. Spray angle depending on the object to be painted. In order to ensure the best possible performance of the product, it is recommended that the paint is at room temperature before the application.

Storage and shelf life

The product must be stored in original sealed containers at temperatures from 5 °C to 30 °C. The storage conditions are to keep the containers in a dry, well ventilated space away from source of heat and ignition. When stored as described above, the unopened component A will keep up to 2 years and unopened component B to 3 years from the date of manufacture. The manufacturing date found in the label is also the batch number of the paint.

Safety

Please follow the environmental and safety instructions displayed on the container and Safety Data Sheet. Use under well ventilated conditions. Do not breathe or inhale mist, use respirator mask. Avoid skin contact. Spillage on the skin should immediately removed with suitable cleanser, soap or water. In case of contact with eyes, rinse immediately with plenty of clean water and if necessary seek medical advice.