

## Technical Data Sheet

# Shopprimer EPF

### Product description

Shopprimer EPF is an epoxy based quick drying primer.

### Typical use

To be used as a preconstruction primer on blast cleaned steel surfaces in automatic shoppriming plants to protect steel during transport, storage and production.

### Colours

Red

### Product data

Property	Test/Standard	Description
Solids by volume		25 ± 2 %
Flash point		-5 ± 2 °C
VOC-EU	calculated	650 g/l
Gloss level (60°)		Matt
Water resistance		Very good
Abrasion resistance		Very good
Solvent resistance		Very good
Flexibility		Good

### Typical film thickness per coat

	Dry film thickness (µm)	Wet film thickness (µm)	Theoretical spreading rate (m <sup>2</sup> /l)
Min	15	60	16,7
Max	50	200	5,0

**Note!** Dry film thickness measured on a smooth test panel.

### Surface preparation

All surfaces should be clean, dry and free from contamination. The surface should be assessed and treated in accordance with ISO 8504.

Steel surfaces:

Blast cleaning to Sa 2½ (ISO 8501-1:2007). Roughness: using abrasives suitable to achieve grade Fine to Medium G (30-85 µm, Ry5) (ISO 8503-2)

Other surfaces:

The coating may be used on other substrates. Please contact Nor-Maali Oy for more information.

## Conditions during application

A The temperature of the substrate should be minimum at least 3°C above the dew point of the air, temperature and relative humidity measured in the vicinity of the substrate. Recommended steel temperature: 30-40°C.

## Application

### Application methods

Spray: Use airless spray. Conventional spray recommended for touch-up purposes.  
 Brush: Recommended for touch up purposes.

### Product mixing ratio (by volume)

Shopprimer EPF Comp. A 2 parts  
 Shopprimer EPF Comp. B 1 part

### Thinner/Cleaning solvent

Jotun Thinner No. 3 (OH 03) (Fast evaporation)  
 Jotun Thinner No. 17 (OH 17) (Slow evaporation)

### Guiding data for airless spray

Nozzle tip (inch/1000): 0,015-0,021" (0,38-0,53 mm)  
 Pressure at nozzle (minimum): 10-15 Mpa (100-150 kp/cm<sup>2</sup>, 1500-2100 psi)  
 Spray angle: 40-95 °  
 Filter: Check to ensure that filters are clean

### Drying and Curing time

Drying times are generally related to air circulation, temperature, film thickness and number of coats, and will be affected correspondingly. The figures given in the table are typical with:

- Good ventilation
- Typical film thickness
- One coat on top of inert substrate

Substrate temperature	+23 °C	+40 °C
Surface dry	1-3 min	20-40 s
Dry to handle	4 min	1-2 min
Fully cured <sup>1</sup>	7 d	3 d
Dry to overcoat min	10 min	5 min
Dry to overcoat max <sup>1</sup>	-	-

<sup>1</sup>The surface should be dry and free from any contamination prior to application of the subsequent coat.

The given data must be considered as guidelines only. The actual drying time/times before recoating may be shorter or longer, depending on film thickness, ventilation, humidity, underlying paint system, requirement for early handling and mechanical strength etc. A complete system can be described on a system sheet, where all parameters and special conditions could be included.

## Pot life

Paint temperature	23 °C
Pot life	24-36 h

Reduced at higher temperatures.

## Typical paint system

**Shopprimer EPF 1 x 20-30 µm** (Dry Film Thickness - measured on a smooth test panel).

Normally overcoated with a choice of systems based on chlorinated polymers, vinyl or epoxy resins.

Other systems may be specified, depending on area of use.

## Storage

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 4 years from the date of manufacture. The manufacturing date found in the label is also the batch number of the paint.

## Handling

Handle with care. Stir well before use.

## Packaging

	Volume (litres)	Size of containers (litres)
Shopprimer EPF Comp. A	20 / 200	20 / 200
Shopprimer EPF Comp. B	10 / 200	10 / 200

## 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. **For detailed information on the health and safety hazards and precautions for use of this product, we refer to the Material Safety Data Sheet.**

## Disclaimer

The information in this data sheet is given to the best of our knowledge based on laboratory testing and practical experience. However, as the product is often used under conditions beyond our control, we cannot guarantee anything but the quality of the product 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.

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