

Haftprimer EPE

Adhesion-primer with chromate-free anti-corrosive pigments (zinc-phosphate) on epoxy-ester resin basis

Field of application

- Best adhesion on difficult substrates.
- Especially for multiple layer systems based of PUR.
- Fast overcoat intervall by 10-20µm dft.

Product properties

- Silicon-free
- Contains zincphosphate
- Coating systems for high temperatures
- Good elasticity
- Tolerant to a contaminated support
- Recoatability: universal

Technical Specification

Colours	Reddish. Colour deviation (Colour deviations may occur in the range of high temperatures due to the restricted temperature resistance of the pigments)
Flash point	>23 °C
Temperature stability	-20 up to 200 (short-term up to 300) °C
Gloss	Mat
Potential dry film thickness in one working process	10 up to 30 µm
Viscosity	Appr. 60 sec running time (DIN 4 mm pot)
Density in kg/l	1,32
Solid content in %	61
Solid volume in %	39
Theoretical spreading capacity	<ul style="list-style-type: none"> • 26 m²/l at 15 µm DFT • 19,7 m²/kg at 15 µm DFT
Recommended film thickness	50 µm WFT corresponds to 20 µm DFT
Drying (DIN EN ISO 1517)	15 µm DFT
Dust-dry (Tg1)	After 15 min
Touch-dry (Tg4)	After 25 min
Dry (Tg6)	After 45 min
Cured chemically	After 7 days
Interval for overcoating	<ul style="list-style-type: none"> • after 30 min with single-component topcoats • after 30 min with two component topcoats
Note	<ul style="list-style-type: none"> • The specifications are based on standard atmospheric conditions 23/50, DIN 50014. • Lower temperatures and/or higher humidity will prolong drying and hardening.

Safety information (See Security Data Sheet)

VOC-level	Appr. 515 g/l
Solvent content	Appr. 40 % by weight
Aromatic content	Appr. 35 % by weight

Storage

Storage	<ul style="list-style-type: none"> • In dry, cool rooms, if possible frost-proof • Ensure good ventilation
Shelf life	<ul style="list-style-type: none"> • 6 month from date of delivery when in unopened original containers in cool and dry conditions

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Application methods

Airless spraying	<ul style="list-style-type: none"> • Flow pressure 180 bar • Nozzle size 0,09 inch (2,29 mm) • Spraying angle according to the geometry and size of the object to be laquered
Compressed air spraying	<ul style="list-style-type: none"> • Spraying pressure 3 - 5 bar • Nozzle size 1,3 - 1,5 mm • Adjust to spraying viscosity (appr. 30 s DIN 4 mm) adding appr. 3 % Derozink-Verdünnung (two component products: after mixing)
Electrostatic application	<ul style="list-style-type: none"> • Can be applied as delivered
Dipping	<ul style="list-style-type: none"> • Can not be applied as delivered
Other methods	<ul style="list-style-type: none"> • Roller and brush application for repair work is possible
Thinner	<ul style="list-style-type: none"> • Max. 5% Derozink-Verdünnung
Cleaning	<ul style="list-style-type: none"> • Rinse immediately with Derozink-Verdünnung • Residues are dissolvable with Derozink-Verdünnung
Preparation of support	<ul style="list-style-type: none"> • If necessary clean with high pressure-cleaner and turbo-cleaner-solution • Mill scale, welding residues, dust, soluble residues from chemical pretreatments and zinc reaction products which might reduce adhesion have to be carefully and thoroughly removed
General remarks	<ul style="list-style-type: none"> • During coating and drying the humidity should be min. 10 % / max. 85 % • During coating and drying the environmental temperature should be min. 5°C / max. 30°C • Object temperature at least 3° C above dew point.
Example for a system	<ul style="list-style-type: none"> • Primer coat: Haftprimer EPE • Intermediate coat: 2K-Derocryl Haftgrund EG HS • Finish coat: Miscellaneous

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