

## PRODUCT SPECIFICATIONS

**Product Description** A two component epoxy polyamide shop primer pigmented with zinc phosphate rust-inhibiting pigments.

**Design Feature**

- As a shop primer for the protection of blast-cleaned steel against corrosion during fabrication and assembly.
- Extremely fast drying for easy and quick handling of coated steel.
- Provides weathering and corrosion protection for up to 6 months.
- Product complies with DNV : Standards for Certification 2.9 (Type Approval Programme 1-602.2 :2009)

**Physical Characteristics**

Recommended Application Data		Wet [µm]	Dry [µm]	m²/l
Theoretical Coverage		90	25	11.2
Volume solids	:	28 ± 2%		
Dry Film Thickness Range	:	25 µm		
Flash Point	:	4 °C		
Finish	:	Matt		
Colour Range	:	Red Oxide, Grey		
Standard Packing Size	:	20 litres set (15.0 litres Base : 5.0 litres Hardener)		
Mix Ratio (by volume)	:	3 Base : 1 Hardener		

**Application Method**

AIRLESS SPRAY : Tip Size : 0,43 – 0,53 mm (17 – 21 thou)  
 Recommended method of application Pressure : 75 bar / 1100 psi

AIR SPRAY : Recommended. Use suitable proprietary equipment.

BRUSH OR ROLLER : Not recommended. However, may be used for touch-up purposes.

**Drying & Curing Time**

Ambient Temperature	Touch Dry	Hard Dry	Full Cure	Overcoating Interval		Pot Life
				Min.	Max.	
15 °C	5 mins.	8 mins.	7 hari	10 hours	Indefinite	15 hours
25 °C	4 mins.	6 mins.	7 hari	5 hours	Indefinite	12 hours
35 °C	3 mins.	4 mins.	7 hari	3 hours	Indefinite	10 hours

**Useful Information**

THINNER : SOLVALUX 7-45 or 7-77

CLEANER : SOLVALUX 7-45 or 7-77

STORAGE : Store in a cool dry shaded area.

SHELF LIFE : One year minimum when stored as prescribed in the MSDS.

## Surface Preparation

The service life span and the service performance of EPILUX 68 is directly related to the degree of surface preparation.

### STEEL

- Remove all wax, oil and grease by solvent cleaning in accordance with the guidelines given by SSPC-SP1.
- Where necessary removes weld spatter and round off all rough weld seams and sharp edges to a smooth surface.
- Abrasive blast clean to a minimum standard of Sa2½ (ISO 8501-1:1988) or SSPC-SP10.
- Any surface defects revealed by blast cleaning should be ground, filled or treated in a suitable manner.
- An average surface profile of 35 - 50 microns is recommended. A rounded surface profile is recommended. Angular abrasives may produce excessive peaks in the profile that may protrude through the primer and lead to corrosion.
- After blasting, remove dust from the surface. The surface to be coated must also be clean and dry.
- Apply Epilux 68 immediately after blasting to prevent oxidation and recontamination of the steel surface. In case of oxidation or recontamination, re-blast to the required standard.

To avoid condensation of moisture onto substrate prior to coating application, relative humidity should not exceed 85% and substrate temperature should be more than 3°C above Dew Point.

## Suitable Top Coats

Epilux 610, Epilux 78, Epilux 218, Epilux 58, Epilux 58HS, Epimastic 3000HS, Epimastic 3100, Epimastic 5100, Epilux 15HS, Epilux 18HS, Epilux 155, Luxol 5000, Epilux 4, Luxathane 5075, Luxathane 5150HS, Luxathane 5000 HB.

## Notes

Product will not cure adequately at temperatures below 10 °C.

## Safety Precaution

- Avoid contact with eyes and skin. Wear suitable protective clothing such as overalls, goggles, dust mask and gloves. Use barrier cream.
- This product contains low flash point solvents, do not use in poorly ventilated areas especially in confined tank interiors.
- Ensure that there is adequate ventilation in the area where the product is being applied. Do not breathe in vapour or spray mist.
- This product is flammable. Keep away from sources of ignition. Do not smoke.
- Take precautionary measures against static discharge.
- In case of fire, blanket flames with foam, carbon dioxide or dry chemicals.

## First Aid

- Eyes** : In the event of accidental splashes, flush eyes with warm water immediately and seek medical advice.
- Skin** : Wash skin thoroughly with soap and water or approved industrial cleaner. Do Not Use solvents or thinners.
- Inhalation** : Remove to fresh air, loosen collar and keep patient rested.
- Ingestion** : In case of accidental ingestion, DO NOT INDUCE VOMITING. Obtain immediate medical attention.

For further safety information, please refer to our **Material Safety Data Sheet (MSDS)**

The information provided on this data sheet is not intended to be complete and is provided as general advice only. It is the responsibility of the user to ensure that the product is suitable for the purpose for which he wishes to use it. As we have no control over the treatment of the product, the standard of surface preparation of the substrate, or other factors affecting the use of this product, we are not responsible for its performance nor would we accept any liability whatsoever or howsoever arising from the use of this product unless specifically agreed to in writing by us. The information contained in this data sheet may be modified by us from time to time, and without notice, in the light of our experience and continuous product development.