

PRODUCT SPECIFICATIONS

Product Description

A two component epoxy anti-corrosive primer pigmented with zinc phosphate.

Design Feature

- A general purpose epoxy anti-corrosive primer suitable for use as a blast or holding primer.
- Excellent anti-corrosive performance.
- Good wetting properties and outstanding adhesion to blasted steel.
- Good chemical and abrasion resistance.
- Suitable for over-coating with epoxies vinyl and chlorinated-rubbers.
- Recommended for use as a tie-coat over inorganic zinc silicate coatings.

Physical Characteristics

Recommended Application Data		Wet [µm]	Dry [µm]	m ² /l
Theoretical Coverage		58	25	17.2
Volume Solids	:	43 % (based on ASTM D2697)		
Dry Film Thickness Range	:	25 µm to 50 µm		
Flash Point	:	28 °C		
Finish	:	Matt		
Colour Range	:	Red Oxide		
Standard Packing Size	:	5 L Set (3.75 L Base : 1.25 L Hardener) 20 L Set (15 L Base : 5 L Hardener)		
Mix Ratio (by volume)	:	3 Base : 1 Hardener		

Application Method

AIRLESS SPRAY	:	Tip Size	:	0.38 – 0.48 mm (15 – 19 thou)
Recommended method of application	:	Pressure	:	110 -160 kg/cm ² (1600 – 2300 psi)
CONVENTIONAL AIR SPRAY	:	May be used. May require additional dilution to achieve good atomisation.		
BRUSH OR ROLLER	:	May be used. However, additional coats may be required to achieve the recommended film thickness. Suitable for stripe coating, weld-seams, edges, corners, rivets, etc.		

Drying & Curing Time

Substrate Temperature	Touch Dry	Hard Dry	Overcoating Interval		Pot Life
			Min.	Max.	
15 °C	2 hours	8 hours	12 hours	Indefinite	10 hours
25 °C	1 hours	4 hours	6 hours	Indefinite	6 hours
35 °C	30 mins.	2 hours	4 hours	Indefinite	4 hours

Useful Information

THINNER	:	SOLVALUX 7-45 or 7-33 (Maximum 5% Addition)
CLEANER	:	SOLVALUX 7-77
STORAGE	:	Store in a cool dry shaded area.
SHELF LIFE AT 25 °C	:	12 months minimum when stored as prescribed in the MSDS.

Surface Preparation

The service life span and the service performance of EPILUX 610 are directly related to the degree of surface preparation.

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- 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. An average surface profile of 50 microns is acceptable but this average should not exceed 75 microns.
- Ensure that all surface defects detected after blast cleaning is ground, filled or treated in a suitable manner.
- After blasting, remove dust from the surface.
- Ensure that the surface to be coated is clean, dry and free from any contaminants.
- Apply Epilux 610 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 Primers

Epilux 68, Zincanode 300, Zincanode 330, Zincanode 668, Zincanode 685

Suitable Overcoats

Epilux 218, Epilux 58, Epilux 58HS, Epimastic 3000HS, Epimastic 3100, Epimastic 5100, Epilux 82, Epilux 15HS, Epilux 18HS, Steelshield 1200, Luxol 5000, Epilux 4, Luxathane 5075, Luaxthane 5150HS, Luxthane 5000HB, Epilux 155, Epilux 155SF, Epilux 518, Epilux 815, Epilux 816, Epilux 816SF

Notes

- For details of other systems, consult your Berger Paints representative.
- Common to all epoxies this product will experience chalking on prolonged exposure to sunlight. However, this phenomenon is not detrimental to coating performance.
- Exposure to very low temperatures, high humidity or water ponding during and/or immediately after application may result in incomplete cure and/or discolouration that may compromise subsequent intercoat adhesion.

Safety Precaution

- Avoid contact with eyes and skin.
- Wear suitable protective clothing such as overalls, goggles, dust mask and gloves. Use barrier cream.
- 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.

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