

PRODUCT NAME

Epiprime

ORIGINALLY ISSUED

22/09/2005

VERSION

3.0

PRODUCT CODE

PRIEPI

VERSION DATE

06/06/2024



PRODUCT DESCRIPTION

A Zinc Phosphate 2K Epoxy Primer offering excellent adhesion, water and chemical resistance combined with good corrosion protection.



IMPORTANT INSTRUCTIONS BEFORE USE

- Read and follow SDS, TDS and label instructions
- Stir all paints thoroughly before use
- Always use the same batch number on the same job
- Check colour & sheen. HMG will not accept any discrepancies arising after use
- Filter the product immediately before use
- Reduce emissions and maintain quality by replacing tin lid after use
- If in any doubt speak HMG Technical Service Department on (0161) 205 7631



MAXIMUM VOC CONTENT (RFU)

0.530K_g/L

REGULATIONS / COMPLIANCE

- 2004/42 IIB (C) 540



COLOUR RANGE

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GENERAL INFORMATION

Solids By Volume 47.00%
Coverage 12.5 square metres per litre @ 50 microns dft
Flashpoint 24°C
Temp Resistance 150°C approx (180°C for short periods) may tarnish. °C
Storage Store between 5°C - 25°C. When not in use, cans must be kept sealed
Shelf Life 12 months from delivery date in original sealed containers



CLEANING

Ensure surfaces to be coated are dry and must be cleaned using the appropriate HMG product to remove all traces of contaminants.

HMG produce a full range of cleaners, silicone removers, degreasers and preparatory cleaners suitable for the cleaning process.

Please refer to our website for Knowledge Base article Prep-Cleaning Techniques (KNB0009) and Preparatory Cleaners from the Product Guide.



SURFACE PREPARATION

Please refer to Knowledge Base for details on Surface Preparation.



HEALTH AND SAFETY

- Refer to SDS and tin label prior to use.
- Suitable respiratory equipment should be worn when spraying.

APPLICATION METHODS



MIXING RATIO

BRUSH		CONVENTIONAL SPRAY GUN		PRESSURE POT		AIRLESS/AIR-ASSISTED	
Base	4	Base	4	Base	4	Base	4
Hardener	1	Hardener	1	Hardener	1	Hardener	1
Thinner	up to 10%	Thinner	up to 30%	Thinner	up to 30%	Thinner	up to 10%



HARDENER OPTIONS

Hardener 9058 Standard Hardener 9060 Rapid Cure	Hardener 9058 Standard Hardener 9060 Rapid Cure	Hardener 9058 Standard Hardener 9060 Rapid Cure	Hardener 9058 Standard Hardener 9060 Rapid Cure
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THINNER OPTIONS

Thinner 2691 Thinner 2711	Thinner 2691 Thinner 2711	Thinner 2691 Thinner 2711	Thinner 2691 Thinner 2711
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VISCOSITY

		28-35	seconds B4 cup	28-35	seconds B4 cup	35-40	seconds B4 cup
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SPRAY GUN SETUP

	1.8-2.0	1.1-1.4	11-13 thou 40/50°
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NUMBER OF COATS (GUIDE ONLY)

1-2 Full Coats	1-2 Full Coats	1-2 Full Coats	1 Full Coat
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FLASH OFF

	10-15 mins between coats	10-15 mins between coats	10-15 mins between coats
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DRYING TIME								
	Touch dry	2hrs @20°C	Touch dry	2hrs @20°C	Touch dry	2hrs @20°C	Touch dry	2hrs @20°C
	Hard dry	24 hours	Hard dry	24 hours	Hard dry	24 hours	Hard dry	24 hours
	Hard dry	30mins @70°C	Hard dry	30mins @70°C	Hard dry	30mins @70°C	Hard dry	30mins @20°C
	Full dry	3-7 days	Full dry	3-7 days	Full dry	3-7 days	Full dry	3-7 days

RECOATABILITY / OVERCOATING							
 After 45 mins @ 20°C without flattening. After 8 hours @ 20°C either flat and recoat with itself or Topcoat.							

POT LIFE								
	8 hrs @ 20°C		8 hrs @ 20°C		8 hrs @ 20°C		8 hrs @ 20°C	

WET FILM THICKNESS*								
	105 microns		105 microns		105 microns		105 microns	

DRY FILM THICKNESS*								
	50 microns		50 microns		50 microns		50 microns	

* - HMG Technical Data Sheets indicate a Dry Film Thickness that will be achieved when applying a particular Wet Film Thickness. These values are a guide only and are not to be used as specifications. Film thickness will vary depending on actual use and specification. Great care should be taken to achieve the dft stated in the agreed specification and to avoid areas of excessively low or high thickness.

This information relates only to the specific material designated and may not be valid for such material used in combination with any other materials or in any process. Such information is to the best of HMG's knowledge and belief accurate and reliable as of the date indicated. However, no representation, warranty or guarantee is made as to its accuracy, reliability or completeness. It is the user's responsibility to satisfy themselves as to the suitability and completeness of such information for their own particular use. For professional use only.