

Technical Data

CHEMTECH EPOXY PRIMER



Product description

Chemtech Epoxy Primer is a two-pack zincphosphate pigmented epoxy primer for epoxy linings.

Recommended use

Interiors of tanks.

Film thickness and spreading rate

	Minimum	Maximum	Typical
Film thickness, dry (μm)	25	60	40
Film thickness, wet (μm)	70	170	115
Theoretical spreading rate (m^2/l)	14	5.8	8.8

Physical properties

Colour	Red
Solids (vol %)*	35 \pm 2
Flash point	22°C \pm 2 (Setaflash)
Gloss	Glossy
Water resistance	Very good
Abrasion resistance	Very good
Solvent resistance	Excellent
Chemical resistance	Excellent

*Measured according to ISO 3233:1998 (E)

Surface preparation

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

Bare steel

Cleanliness: Blast cleaning to min. Sa 2 ½ (ISO 8501 1:1988). Roughness: using abrasives suitable to achieve Grade Medium G (50 - 85 μm , Ry5) (ISO 8503-2).

Other surfaces

The coating may be used on other substrates. Please contact your local Jotun office for more information.

Condition during application

The temperature of the substrate should be minimum 10°C and at least 3°C above the dew point of the air, temperature and relative humidity measured in the vicinity of the substrate. The coating should not be exposed to oil, chemicals or mechanical stress until fully cured.

Application methods

Spray	Use airless spray
Brush	Recommended for stripe coating and small areas, care must be taken to achieve the specified dry film thickness.

Application data

Mixing ratio (volume)	1 parts Comp. A (base) to be mixed thoroughly with 1 part Comp. B (curing agent)
Mixing	½ hour prior to use
Pot life (23°C)	8 hours (Reduced at higher temp.)
Thinner/Cleaner	Jotun Thinner No. 17
Guiding data airless spray	
Pressure at nozzle	15 MPa (150 kp/cm ² 2100 psi)
Nozzle tip	0.46-0.69 mm (0.018-0.027")
Spray angle	40-80°C
Filter	Check to ensure that filters are clean.

Drying 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 (Outdoor exposure or free circulation of air)
- * Typical film thickness
- * One coat on top of inert substrate

Substrate temperature	10°C	23°C	40°C
Surface dry	4 h	2 h	1 h
Through dry	12 h	6 h	3 h
Cured	14 d	7 d	3 d
Dry to recoat, minimum ¹	12 h	6 h	3 h

¹ Provided the surface is free from chalking and other contamination prior to application, there is normally no overcoating time limit. Best intercoat adhesion occurs, however, when the subsequent coat is applied before preceding coat has cured. If the coating has been exposed to direct sunlight for some time, special attention must be paid to surface cleaning and mattening/removal of the surface layer in order to obtain good adhesion.

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.

Typical paint system

Blastcleaning to Sa 2½.

Chemtech Epoxy Primer 40 µm (Dry Film Thickness)

All pittings to be filled with epoxy filler:

Chemtech 340 in one or two layer system:

One layer system:

Chemtech 340: A+B plus 450 g/m² glass mat 1500-1800 microns.

Two layer system:

Chemtech 340: A+B plus 300 g/m² glass mat 2500-3000 microns.

A 30g/m² surface tissue can also be used in addition to the final layer.

Other systems may be specified, depending on area of use

Storage

The product must be stored in accordance with national regulations. Storage conditions are to keep the containers in a dry, cool, well ventilated space and away from source of heat and ignition. Containers must be kept tightly closed.

Handling

Handle with care. Stir well before use.

Packing size

10 L. Comp. A and 10 L. Comp. B

Packing may vary from country to country according to local requirements.

Health and safety

Please observe the precautionary notices displayed on the container. Use under well ventilated conditions. Do not breathe or inhale mist. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water and medical attention sought immediately.

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.

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