

PRODUCT DATASHEET

Epidac 2

HB Zinc Phosphate Primer

PRODUCT INFORMATION

Reference Number:

79-LINE

Coating type:

2-pack epoxy with anti-corrosive pigmentation.

Typical uses:

High-build epoxy primer for use on steel and galvanised surfaces.

Colours available:

Grey (79-458)

White (79-485)

Appearance:

Sheen

Features and benefits:

- Excellent corrosion protection using phosphate pigmentation
- Suitable for external environments (C3-CS5M/I)
- High-level of adhesion to both mild and galvanised steelwork
- Can be over-coated by a wide range of topcoats
- Low VOC's – EPA compliant to PG6/23
- High build and sag resistance

TECHNICAL INFORMATION

Theoretical coverage:

7.33m² per litre at 75 microns dry film thickness

Film thickness:

	Wet film thickness	Dry film thickness
Typical:	140 microns	75 microns
Range:	90-230 microns	50-125 microns

Sag tolerance:

320 microns wet film thickness

Recommended Top Coats:

2-Pack Polyurethane Finish (85-LINE)

2-Pack Acrylic Finish (81-LINE/82-LINE/83-LINE)

Dacsil 200 Polysiloxane Finish (200-LINE)

V.O.C.:

402grm/ltr EPA Method 24

223grm/kg calculated from formulation to satisfy EU Solvent Emissions Directive

May vary with colour.

% Volume solids:

55% calculated from laboratory formulation

May vary with colour.

Drying time:

Temp.	Touch dry	Firm dry	Overcoat	Full cure
5°C	5-7 hrs	Overnight	Overnight	7-10 days
10°C	4-6 hrs	Overnight	Overnight	7-10 days
15°C	3-5 hrs	Overnight	Overnight	7-10 days
20°C	2-4 hrs	Overnight	Overnight	7-10 days

Drying time will vary with temperature, air movement, etc.

SURFACE PREPARATION

Paint preparation before use:

Stir the base component thoroughly, then add the activator to the base in the ratio mentioned below. Mix the activator and base until they become homogenous.

Surface preparation:

All surfaces to be coated should be clean, dry, and free from contamination. Prior to paint application all surfaces should be assessed and treated in accordance with ISO 8504:2000. The surface should also be suitably primed.

Mixing ratio by volume:

6-parts base to 1-part activator

Steel:

Abrasive blast to Sa2.5 (ISO 8501-1). New steel, free of millscale and/or rust should be degreased with Dacrylate Thinner R5 or R9.

Galvanised steel:

Degrease and pre-treat with Dacrylate T-Wash (150-23)

APPLICATION

Application conditions:

This material should preferably be applied at temperatures more than 10°C. Relative humidity should not exceed 90% and in these conditions good ventilation is essential. Substrate temperature should be at least 3°C above the dew point and always above 5°C.

At application temperatures below 10°C, drying and curing times will be significantly extended, and spraying characteristics may be impaired.

Airless spray:

Tip size: 15-17 thou (0.38-0.43mm)
Tip pressure: Minimum 2000psi (135bar)

Conventional spray:

Tip size: 55 thou (1.4mm)
Tip pressure: 40-60psi (2.76-4.14bar)

Brush application:

Small areas and sections can be brushed. Use a full wet brush. Do not attempt to 'brush out' or 'lay-off'.

Roller application:

This product is not suitable to be rolled.

Thinning:

Up to 10% of Dacrylate Thinner R9 may be required when conventional spraying the product to achieve optimum spray characteristics.

Clean-up:

Clean all equipment after use with Dacrylate Thinner R9. Do not allow product to remain in hoses, guns, or spray equipment. All surplus product should be disposed of in accordance with appropriate regional regulations/legislation.

STORAGE AND PACKAGING

Storage:

Under cover within temperature range of 5°C to 32°C. Keep containers dry and tightly sealed to avoid moisture contamination.

Shelf life:

2 years or longer in unopened containers when stored under cover within a temperature range of 5°C to 32°C.

Pot life (at 20°C):

8 hours

Packaging:

5 and 20 litre composite packs

HEALTH AND SAFETY

Please refer to the following data sheets:

79-458B 10600 Epidac 2 HB ZP Base

79-A458 11010 Epidac 2 HB ZP Primer Activator

All work involving the application and use of this product should be performed in compliance with all relevant national, health, safety & environmental standards, and regulations

ADDITIONAL NOTES

The application and spray information given above is intended as a guide only. As conditions vary from job-to-job, it is the applicators responsibility to ensure all equipment in use has been set up to give the best results.

Fully compliant to Environmental Protection Act (1990) as required by Guidance Note PG6/23 (97), Clause 20(d), when used as a tie-coat, sealer or blast primer.

IMPORTANT INFORMATION

The information supplied in this product datasheet is not intended to be exhaustive. Any person using the product for any other purpose than that specifically recommended in this product datasheet, without first obtaining written confirmation from Dacrylate Technical Services as to the suitability of the product for the intended purpose does so at their own risk. All advice given about the product is correct to the best of our knowledge, however we have no control over the condition of the substrate, preparation or the many factors affecting the use and application of the product. Therefore, unless specifically agreed in writing to do so, we do not accept any liability at all for the performance of the product or for (subject to the maximum extent permitted by law) any loss or damage arising out of the use of the product.

Dacrylate warrants its products to be free from defects in material and workmanship. Dacrylate's obligations and buyer's exclusive remedy relating to the products shall be limited, at Dacrylate's option, to either replace the products not conforming the warranty or the credit of the buyers account in the invoiced amount of the non-conforming product. Any claim under this warranty must be made by the Buyer to Dacrylate in writing within five (5) days of the Buyer's discovery of the claimed defect, but in no event later than the expiration of the applicable shelf life, or one year from the delivery date, whichever is earlier. The Buyer's failure to notify Dacrylate of such non-conformance as required herein shall bar the Buyer from recovery under this warranty.

The information detailed in this datasheet is liable to modification from time-to-time in the light of experience and our programme of product development. Before use, it is the customers responsibility to check with Dacrylate Customer Services, quoting the product reference number and version reference at the bottom of the data sheet, to ensure that they have in their possession the latest issue.

Technical product datasheets are available from our website at www.dacrylate.co.uk, and should be the same as this datasheet. Should there be any discrepancies between this document and the website version, then please contact Dacrylate Customer Services.

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