

AMOTHERM[®] STEEL PRIMER EPOXY SB

Anti-corrosive steel primer for fire-proofing systems

Rev. October 2020

Solvent-based epoxy polyamide anti-corrosive primer for reactive systems

Characteristics: solvent-based dual-component air-drying primer based on epoxy resins and zinc phosphate, applicable with one coat in high layer thicknesses, application at ambient temperature.

Applications: special anti-corrosive primer which promotes adhesion of AMOTHERM STEEL paint coatings on steel, galvanised steel or iron surfaces treated with inorganic galvanising coatings. Suitable for steel surfaces, outdoor use, industrial atmospheres and harsh environmental conditions. Can also be used indoors and outdoors as an intermediate adhesion layer on pre-existing polyurethane- or epoxy-based paints.

Technical data *

Paint coating:	dual-component product
Colour:	grey
Mass by volume:	1350 - 1450 g/l
Test viscosity:	75 sec +/- 5 sec (FORD 4)
Dry residue in weight:	62 - 63 %
Mixing ratio:	5:1
Pot life	approx. 24 hours
Drying time:	<ul style="list-style-type: none"> ▪ touch dry 2 hours ▪ hard dry 24 – 36 hours
Recoatable:	can be over-painted after at least 6-8 hours, Max. time: unlimited
Storage:	at least 1 year in the original closed container at a temperature of >5 °C.
Packaging:	as per price list

(*) The information given refers to the mixture of the two components

The technical data given above refer to the results obtained for the standard grey formula. The product application details were obtained in normal environmental conditions (temperature 20 °C and relative humidity 60%) and refer to the application of a wet film with a thickness of 100 micron. Different thicknesses and/or different environmental conditions may lead to considerable variations in the information given above.

How to apply

Detailed information about the use of AMOTHERM PRIMER EPOXY SB at all operative stages in the life cycle of the product, can be found in the Safety Data Sheet (SDS). Further information and instructions for applying the product can be found in the USER MANUAL. The technical documentation is available on the company website and can be downloaded at www.amonncolor.com

A summary of the standard operating conditions for the correct application of this protective system is given below.

Surface preparation:

- New steel: sandblast surface to grade SA 2^{1/2}.
- Galvanised steel: remove any dirt and all solid particles on the zinc surface with a scraper or similar tool. Wash the surface with a suitable solvent to completely remove all solid residue.

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- Treated steel: surfaces with pre-existing anti-corrosive treatments still attached to them need to be cleaned thoroughly by pressure washer or an equivalent cleaning method with suitable washing solvents; check compatibility and adhesion before applying a new, uniform coat of epoxy primer.

Application quantity: the recommended quantity is approx. 150-200 g/m² (110-140 micron of wet film corresponds to 60-70 micron of dry film).

Product preparation: prepare the product just before use by combining the two components and mixing them thoroughly before use. Use all the product within 24 hours of preparing it.

Dilution: see table below

Application: by spray, roller or brush. As a general rule, 200 g/m² are applied in a single coat using a spray or in two coats using a roller or brush, leaving at least 6 hours between them.

Summary of application methods:

METHOD	% dilution (with epoxy thinner)	Pressure	nozzle
<i>Roller / Brush</i>	<i>0 - 5%</i>	---	---
<i>Air spray</i>	<i>0 - 10%</i>	<i>2.5 – 3.5 atm</i>	<i>1.8 – 2.1 mm</i>
<i>Airless spray*</i>	<i>0 - 5%</i>	<i>120 – 160 atm</i>	<i>0.013 - 0.017 inch</i>

- Use an airless pump for spray application:
- Pneumatic pump with a minimum compression ratio of 30:1
- Electric pump with motor power of at least 1.9 KW

Do not work in temperatures below 5 °C and when relative humidity is above 60%. Make sure the area is well-ventilated to ensure the film is able to dry out thoroughly. Do not apply if it is raining, windy or if there is mist, high humidity or in direct sunlight.

Notes:

Only apply when the temperature of the surface is at least 3 °C above the dew point.

Tool cleaning: with Stufex 006 thinner for epoxy products immediately after use.

The instructions provided in this document are consistent with the most recently available information on the development and use of our product. Because we have no control over the onsite use and application of the product, we may only be held liable for the quality of the product as supplied.