

# 1. EPX-040

## 2K Epoxy Primer ZNP

**DESCRIPTION** Two-component epoxy anticorrosive primer.  
Possible colors: grey, beige.

**PRODUCT FEATURES**

- can be used on ferrous metal, galvanized steel and aluminium;
- zinc phosphate is used as an anticorrosive pigment;
- great adhesion, body and filling property;
- is used as a primer coating in epoxy and acrylic-urethane systems;
- is used for surfaces subject to abrasion and mechanical and/or chemical exposure.

**SURFACE PREPARATION**

All surfaces must be clean, dry and free from contamination. During application and drying, the ambient air, surface and paint temperatures must not fall below +5°C, and the relative air humidity must not exceed 80%. The temperature of the surface to be painted must remain at least 3°C above the dew point.

Steel: blast clean to Sa 2½ or hand clean to St 3.

Galvanized steel: use Scotch-Brite® abrasive cloth and degrease.

Aluminium: sand with P280-320 sandpaper, clean and degrease.

Pre-existing coatings: remove old layers by sandblasting or mechanical grinding with P240-320 sandpaper, clean and degrease.

### MIXING RATIO

		% in weight, g	% in volume, ml
Product	EPX-040	100	100
Hardener	HEP-914	6	10
Thinner	TEP-904	10-30	10-30

Volume solids comp. A+B 62±2 %  
Weight solids 65-80 %  
Approx. consumption A+B (DFT 50µ) 127 g/m<sup>2</sup>

Specific gravity A+B 1,40-1,50 kg/l  
Working viscosity (DIN 4) 28-32 sec  
Pot life (20°C) 4 h

### APPLICATION METHODS

- Apply in one to three layers.
- In order to obtain an even, non-porous finish at airless spraying the viscosity should be 50-60 sec. according to DIN4, the product is thinned depending on the temperature of the components and the required viscosity approximately 5-10% (by weight). Recommended nozzle tip is 0,011"-0,017" and pressure 120-160 bar. Spray angle shall be chosen according to the shape of the object.
- For gravity spraying, the product is thinned depending on the temperature of the components and the required viscosity approximately 20% (by weight). Recommended nozzle diameter is 1,6-1,8 mm and a pressure of 3-4 bar.

**DRYING TIME** (DFT 50 $\mu$ , relative humidity 65%)

Degree of drying	+10°C	+23°C	+35°C
Dust dry	2 h	1 h	30 min
Touch dry	6 h	4 h	2 h
Drying between layers	40 min	20 min	10 min
Before applying enamel	1 h	40 min	20 min
Complete cross-linking	10 d	7 d	5 d

Drying at 60°C – 30 min.

Drying time may vary according to the thickness applied and humidity. Suitable air exchange on the surface of the item facilitates drying.

**SUBSEQUENT LAYERS**

Maximum time for applying further coats: 15 days, subsequently after sanding.  
**Overlapped with acrylic Topcoat ACR-231 for 2-coats system.**

**SHELF LIFE**

12 months

**SAFETY MEASURED**

Contains organic solvents. Perform painting work with local and general ventilation. Use rubber gloves to protect your hands, and personal protective equipment to protect your respiratory organs. Store the product in a tightly closed container. Keep away from sources of ignition, heat, sparks, open fire, static electricity. Do not smoke nearby. Protect from the frost. Use explosion-proof equipment, lighting, intrinsically safe tools. Extinguish by spraying water or using an air-mechanical foam and powders. In case of contact with the skin, wash the contaminated areas with soap and water, dry and lubricate with a fat-based cream.

**For industrial and professional use only!**

The above information is not intended to be exhaustive or complete. The information is based on laboratory tests and practical experience, and it is given to the best of our knowledge. As a manufacturer we cannot control the conditions under which the product is being used or the many factors that have an effect on the use and application of the product. We disclaim liability for any damages caused by using the product against our instructions or for inappropriate purposes. We reserve the right to change the given information unilaterally without notice.

The product is intended for professional use only and shall only be used by professionals who have sufficient knowledge and expertise on the proper use of the product. The information above is advisory only. To the extent permitted by applicable law, we shall not approve of any liability for the conditions under which the product is being used or for the use or application of the product.

In case you intend to use the product for any other purpose than that recommended in this document without first getting our written confirmation on the suitability for the intended use, such use takes place at your own risk.

# 2. ACR-231

## 2K Acrylic Topcoat matt Antiscratch

**DESCRIPTION** Two-component matt acrylic Topcoat.  
Gloss level: 8-15%. Aliphatic isocyanate is used as a hardener.

**PRODUCT FEATURES**

- excellent weather and abrasion resistance;
- has very good anti-scratch effect;
- suitable for use as a matt topcoat of epoxy and acrylic-urethane systems exposed to atmospheric and/or chemical stress;
- recommended for painting vehicles, equipment, storage tank exteriors, steel frames and other steel structures, machinery.

**SURFACE PREPARATION**

All surfaces must be clean, dry and free from contamination. During application and drying, the ambient, surface and paint temperatures must not fall below +5°C and the relative air humidity must not exceed 80%. The temperature of the surface to be painted must remain at least 3°C above the dew point.

Primed surfaces: wet-on-wet, or drying, sanding P240-320 sandpaper, clean and degrease.

Pre-existing coatings: remove old layers by sandblasting or mechanical grinding with P240-320 sandpaper, clean and degrease.

### MIXING RATIO

		% in weight, g	% in volume, ml
Product	ACR-231	100	100
Hardener standard / fast	HAC-911 / HAC-912	22	30
(or) Hardener HS	HAC-913	16	22
Thinner standard / slow	TAC-901 / TAC-903	10-30	15-40

Volume solids comp. A+B 47±2 %  
Weight solids 50-60 %  
Approx.consump. A+B (DFT 50µ) 117 g/m<sup>2</sup>

Specific gravity A+B 1,00-1,10 kg/l  
Working viscosity (DIN 4) 22-30 sec  
Pot life (20°C) 4 h

### APPLICATION METHODS

- Apply in two layers.
- To obtain a smooth, non-porous coating when airless spraying, the viscosity should be 50-60 sec. according to DIN4. The product is diluted depending on the temperature of the components and required viscosity by approximately 5-10% (by weight). Recommended nozzle diameter is 0,011"-0,017" with a pressure of 120-160 bar. The spray angle is selected according to the shape of the object.
- For gravity spraying, the product is diluted depending on the temperature of the components and required viscosity by approximately 20% (by weight). Recommended nozzle diameter is 1,4-1,8 mm and a pressure of 3-4 bar.

**DRYING TIME** (DFT 50 $\mu$ , relative humidity 65%)

Degree of drying	+10°C	+23°C	+35°C
Dust dry	30 min	20 min	10 min
Touch dry	6 h	4 h	2 h
Drying between layers	15 min	5-7 min	5 min
Complete cross-linking	10 d	7 d	5 d

Drying at 60°C – 30 min.

Drying time may vary according to the thickness applied and humidity. Suitable air exchange on the surface of the item facilitates drying.

**SHELF LIFE** 24 months

**SAFETY MEASURED** Contains organic solvents. Perform painting work with local and general ventilation. Use rubber gloves to protect your hands, and personal protective equipment to protect your respiratory organs. Store the product in a tightly closed container. Keep away from sources of ignition, heat, sparks, open fire, static electricity. Do not smoke nearby. Protect from the frost. Use explosion-proof equipment, lighting, intrinsically safe tools. Extinguish by spraying water or using an air-mechanical foam and powders. In case of contact with the skin, wash the contaminated areas with soap and water, dry and lubricate with a fat-based cream.

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