TENAXON T 555 CS 6E557

Series 6E557 · Low-solvent 2K epoxy repair material with good adhesion on damp substrates

01 PRODUCT DESCRIPTION

TENAXON T 555 CS 6E557 is a low-solvent, two-component epoxy coating system characterised by very good adhesion on both dry and damp surfaces. It penetrates residual rust particularly well and is therefore ideally suited as a repair material for pre-damaged steel surfaces. The system forms a load-bearing, well-adhering base coat and enables economical refurbishment even under difficult conditions, such as residual moisture or remaining rust.

02 PRODUCT PROPERTIES

Binder system	Epoxy resin
Hardener system	hardener EP 30 7E555
Cleaning thinner	EP Thinner 5E403
Characteristics	Low solvent · Direct-to-metal · Good adhesion (also damp) · Penetrates residual rust
Color shade	Approx. RAL 7000, approx. RAL 9005 (further color shades on request)
Gloss	Glossy
Shelf life	Components A and B 12 months each in the unopened original container at +4 °C to +40 °C. Protect from frost and moisture.

Property	Comp. A	Comp. B	Mixture
Density · DIN EN ISO 2811-1 · +20 °C *1	Approx. 1.70 g/cm³	Approx. 0.97 g/cm³	Approx. 1.28 g/cm³
VOC content · IE Directive 2010/75/EU *1	Approx. 117.82 g/l	Approx. 134.83 g/l	Approx. 122.55 g/l
Solid content (wt.-%) · SDS *1	Approx. 90.30 %	Approx. 44.53 %	Approx. 82.06 %
Viscosity · DIN EN ISO 2555 · +20 °C	Approx. 6,000 mPas	Approx. 250 mPas	Approx. 3,500 mPas

*1 *Depending on color shade*

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03 APPLICATION

The following information may vary depending on the application. Please contact your direct contact person for more detailed information.

Substrate	Steel, zinc/aluminium, cement concrete/screed (further substrates on request)
Surface preparation	Ensure sufficient load-bearing capacity before application. **Steel:** Surface preparation to EN ISO 12944-4. Free of weld spatter, pores, laps, burrs, grease, oils and dirt. Blast-clean to Sa 2½, mean roughness Rz approx. 50–70 µm (G or operating mix GS). **Optional** primer: 1 × 30 µm Tenaxon T 569 (3E569), approx. 100 g/m² at 30 µm DFT. **Zinc/aluminium:** Clean and sweep-blast. Primer: 1 × 30 µm Tenaxon T 569 (3E569), approx. 100 g/m² at 30 µm DFT. **Cement concrete/screed:** Surfaces solid, clean, free of grease, oil, wax, sand, dust and release agents, textured, load-bearing, free of loose/sanding particles and standing water. **Optional** primer: Steopox 220 (2E220), approx. 300–500 g/m² depending on absorbency; if required broadcast with fire-dried quartz sand 0.1–0.3 mm.
Mixing ratio	82 : 18 by weight | 100 : 38 by volume
Mixing	Stir both components separately and homogenise if necessary. Pour component B into the container of component A and mix with an electric stirrer for at least 3 min at max. 700 rpm. Transfer into a clean container and mix again thoroughly for approx. 1 min.
Theoretical consumption	Approx. 350 g/m² (mixture) at 250 µm dry film thickness
Application method	Brush / float coater · Roller · Airless spray
Application conditions	**Air temperature** +8 °C to +30 °C **Relative humidity** max. 85 % **Surface temperature** min. +8 °C **Dew point** min. 3 °C below surface temperature
Pot life[*2]	Approx. 60 min
Recoating interval (with itself)[*2]	Min. 24 h | max. 3 months
DRYING[*2]	
Dust-dry (TG 1)	Approx. 12 h
Walkable / sandable	Approx. 24 h
Fully cured (mech. & chem.)	Approx. 7 days
Compatible systems	Primer steel and zinc/aluminium: Tenaxon T 569 (3E569) Primer cement concrete/screed: Steopox 220 (2E220) Further applications on request.

[*2] *Values refer to +20 °C; deviating ambient conditions may extend or shorten the times.*

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Note on epoxy resin: During curing, epoxy resin is sensitive to moisture. Exposure to moisture may lead to the formation of a carbamate layer (white spots). This has a purely visual effect. Affected areas can be treated with a 10–20 % citric acid solution.

04 NOTE

This product data sheet supersedes all previously published product data sheets. The information contained herein is based on practical experience under standard conditions and assumes proper storage and processing. Substrates, materials and working conditions may vary. Therefore, no warranty or liability can be derived from the information contained in this document or from verbal consultation. It is the buyer's responsibility to verify the product's suitability for the intended use. Preliminary trials are recommended. The relevant legal regulations, the leaflets of the BG RCI and the accident prevention regulations of the responsible employers' liability insurance association must be observed. In all other respects, our General Terms and Conditions of Sale and Delivery apply.

MODIFIED BY
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APPROVED BY
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