

IRON OXIDE EPOXY PRIMER 838

TITAN



Product Code: 838

Description

Two pack epoxy-polyamide primer. High performance concerning hardness, toughness and adhesion on several types of surfaces.

Fields of Application

Rust-preventive multi-purpose primer for different kinds of metallic structures.

Technical Data

Product Type	Epoxy polyamide
Finish	Matt
Colour (UNE EN ISO 11664-4)	Red and grey
Density (UNE EN ISO 2811-1)	1.58 - 1.62 Kg/l
Coverage	8 - 10 m ² /l (35 - 45 dry μ)
Drying at 23°C 60 % RH (UNE 48301)	4 - 5 hours
Recoat time at 23°C 60% RH (UNE 48283)	Minimum: 10 hours, Maximum: 7 days
Mixing Rate	Base: 4 parts, Hardener: 1 part
Pot Life at 23°C	6 hours
Methods of Application	Brush (Just patch), Air Spray-Gun and Airless (The data quoted are only hints)
Thinning	Brush: 5%, Air Spray-Gun: 5 - 10%, Airless: 0 - 5%
Nozzle Diameter	Air Spray-Gun: 2.5 -3 mm., Airless: 0.015"
Nozzle Pressure	Air Spray-Gun: 3 - 4 bar, Airless: 150 - 175 bar
Thinner	873 Thinner.
Equipment Cleaning	873 Thinner.
Recommended Thickness (UNE EN ISO 2808)	40 dry μ
Flash Point (UNE EN ISO 3679)	27 °C
Volume Solids (UNE EN ISO 3233-3)	45 - 47%
Pack sizes	4 l. For 10 l, a minimum order of 200 l is required

Variations in temperature, humidity, thickness, tinting or surface type, etc. may lead to changes in drying, in coverage or in

other properties.

Directions for use

GENERAL REMARKS:

Carefully stir the product in the pack, preferably with a mechanical shaker. The surfaces to be painted have to be clean, dry and sound. Let the mixture to dry for 15 minutes before using it in order to help to remove air.

If exceeding the maximum overcoating limit, to ensure the maximum adhesion between coats a light blasting is required. (Sand Sweeping), to confer a light roughness to the primed surface.

BARE SURFACES:

Steel: Remove rust by sandblasting up to Sa 2 ½ grade of the ISO 8501-1 standard or by means of manual or mechanical cleaning, up to ST3 grade of this same standard. Degrease, dust off and remove rests of rust. Apply the required number of coatings to reach the recommended thickness level. Finish with the topcoats according to requirements.

In C3 or even tougher environments (according to ISO 12944), apply 831 Epoxy Primer instead of 838 Iron Oxide Epoxy Primer.

Galvanised steel or non-ferrous metals: Carefully clean and degrease before applying one coat of this primer. Depending on the galvanised surface type, it will be necessary to open pores.

Other surfaces. Seek advice.

MAINTENANCE OF PREVIOUSLY COATED SURFACES IN POOR CONDITION:

For poorly adhered systems and/or showing rust, remove them by sandblasting up to Sa 2 ½ grade of the ISO 8501-2 standard or by means of manual or mechanical cleaning, up to ST3 grade of this same standard. Patch with this primer, preferably by brush. Apply a full coat of this primer and then the finishing product, according to specifications.

If there is a large poorly adhered surface, thoroughly remove old coats and proceed as for bare surfaces.

Precautions

Always read the pack label before use. For more information, please refer to the Safety Data Sheet.

Store in tightly closed containers protected from sources of heat and temperatures below 0°C. Shelf life: 36 months in original unopened packaging.

Waste management: Follow local legal regulations. Help to protect the environment, do not empty into drains, dispose of this material and its container at hazardous or special waste collection points. Calculate the amount of product you will need to avoid waste and extra costs. Collect the leftover material and keep it well stored for a new use.

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Any technical sheet is automatically cancelled by a subsequent sheet or five years after the issue date. We guarantee the quality of our products. However, we disclaim any liability in relation to factors other than the coating itself or in relation to an unsuitable use or application method. In case of doubt, please refer to our technical service before applying the products.



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