



Reference	E81-75
Description	Two-component high-build epoxy primer based on zinc phosphate.
Recommended use	Quick-drying thixotropic primer to protect steel structures against corrosion in aggressive environments. Good resistance against water, oils and light chemicals. Can be applied in high film thicknesses. APECOAT HB PRIMER E81-75 is used as a primer in high-grade epoxy polyurethane systems.
Approvals	Approved by NMBS/SNCB, Belgium's national Railway company.
Composition	Epoxy-Polyamide-Zinc phosphate
Support	Steel, metallisation, hot-dip galvanisation provided the surface is prepared.
Colour	Red-brown

TECHNICAL INFORMATION AT 20°C AND 60% RH

Density	± 1.48 kg/l			
Drying time	Drying time (60 µ dry)			
	Dust free	Tack free	Recoatable	
			Minimum	Maximum
	1-2 hours	4 hours	12 hours	7 days
Mixing ration	By weight: 86.5/13.5 By volume: 78.5/21.5			
Dry volume weight	± 60%			
Theoretical coverage	For 60µ dry: 10.0 m ² /liter			
VOC	355 g/liter			

The values in this technical data sheet are typical values and can differ from batch to batch.

RECOMMENDED USE

Recommended thickness	Application method	Roller	Brush	Airless
	Dry (μ)	50-70	50-70	60-150
Thinner	Thinner 118	Roller	Brush	Airless
	%	0-3	0-3	0-5
Cleaner	Thinner 118			
Temperature substrate	+3°C above dew point			
Relative humidity and temperature	Maximum 85% RH Minimum +5°C			
Processing time	8 hours			

SUBSTRATE

Preparation	Steel
	Remove any grease and contaminants, grit blast to Sa 2.5 and remove dust from the substrate. Can also be applied on a suitable prefabrication primer. On manually prepared substrates to St3, apply the first coat with a brush to obtain good penetration of the paint.
	Hot-dip galvanised
	Remove zinc salts with hard brush and water followed by light sweep blasting with a non-metallic blasting medium until mat surface.
	Metallisation
	Remove zinc salts, thin first coat with ~ 25% thinner 118 as colmatation layer.
	Old, sound, well-adhering paints
	Remove contaminants, degrease and sand the surface. Remove any rust to St3. Always test compatibility of the old paint with the subsequent coat.
Maximum dry temperature	100°C

SYSTEM: EXAMPLE

1 ^e coat	Apecoat Primer E81-75	100 μ
2 ^e coat	Apecoat HB MIO E93-75	120 μ
3 ^e coat	Acrydur HB Finish A2036	60 μ

SAFETY DATE

Flash point °C	Between 21°C and 55°C
Packaging	22.2kg

See MSDS for further information.

SHELF LIFE

Shelf life 24 months in original and sealed containers in a dry, covered storage space – temperature between 5 and 35 °C.

The information contained in this technical data sheet was obtained from sources, which are reliable to the best of our knowledge can in no case imply our liability.
Please ensure that you have the latest version of the Technical data sheet.

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