

## Selection & Specification Data

<b>Generic Type</b>	Single pack etch primer
<b>Description</b>	EP-10 Etch Primer is an acid etching primer and corrosion inhibitor for ferrous metals. Through its acid content, which chemically etches the coating onto the surface of the steel, the primer combines chemically and physically with the substrate, leaving a tough, exceptionally hard film which is highly resistant to mechanical damage. This property, together with its fast drying time, ease of touch-up and corrosion resistance, make it very attractive to the steel fabricator and contractor.
<b>Features</b>	<ul style="list-style-type: none"> <li>- An excellent primer for use on ferrous metals</li> <li>- Due to its fast drying, EP-10 can be used as a shop primer where metal sections can be stacked approximately 30 minutes after painting</li> <li>- EP-10 can be overcoated with most conventional paint systems</li> <li>- Very good flexibility</li> <li>- Fair weathering</li> <li>- Good abrasion resistance</li> <li>- Can be topcoated with most conventional coating systems like alkyds, stoving enamels, epoxies and polyurethanes but is not suitable as a primer for nitro-cellulose lacquers. Consult StonCor Africa Technical Service for specific recommendations.</li> <li>- Not recommended for immersion or exposure to severe chemicals</li> </ul>
<b>Colour</b>	Red Oxide only
<b>Finish</b>	Low gloss
<b>Dry Film Thickness</b>	12 to 18 Microns
<b>Solids Content</b>	By Volume 19% ± 2%
<b>Theoretical Coverage Rate</b>	12.6m <sup>2</sup> /litre at 15 microns
	<b>NOTE:</b> Material losses during mixing and application may vary and must be taken into consideration when estimating job requirements.
<b>VOC Values</b>	As supplied                      950 g/l
<b>Temp Resistance</b>	<b>Non-immersion</b> Continuous                      60°C Non-continuous                75°C

## Substrates & Surface Preparation

<b>General</b>	Remove any oil or grease from surface to be coated.
<b>Hot Rolled Steel</b>	Millscale and rust should be removed by blast cleaning or by acid pickling followed by thorough rinsing and drying.
<b>Cold Rolled Steel</b>	Must be degreased either with solvent or preferably with a detergent solution followed by thorough rinsing.
<b>Galvanised Surfaces</b>	EP-10 is not suitable as a primer for galvanised iron.

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# EP-10 Etch Primer

## Application Equipment

**Spray** Use sufficient air volume for correct operation of equipment.

Use a 50% overlap with each pass of the gun. On irregular surfaces, coat the edges first, making an extra pass later.

**NOTE:** The following spray equipment has been found suitable, however equivalent equipment may be substituted.

**Conventional** Use 10mm minimum I.D. material hose. Hold gun 200 to 250mm from the surface and at a right angle to the surface.

<u>Mfr &amp; Gun</u>	<u>Fluid Tip</u>	<u>Air Cap</u>
Binks # 18 or # 62	63B	63PB
DeVilbiss P-MBC or JGA	FX	704

**Airless** Use 10mm I.D. material hose. Hold gun approximately 300 to 350mm from the surface and at a right angle to the surface.

<u>Mfr &amp; Gun</u>	<u>Pump *</u>
DeVilbiss JGB-507	QFA-514
Graco 205-591	President 30:1 or Bulldog 30:1
Binks Model 500	Mercury 5C

\* Teflon packings are recommended and are available from the pump manufacturer.

Use a .011 or .013" tip with 2000 psi (138 bar)

**Brush or Roller** For touch-up only. Thin as required with EP-10 Thinners. Use a natural bristle brush, applying full strokes, or use a short nap mohair roller with phenolic core.

## Mixing & Thinning

**Mixing** Mix to a smooth consistency before use.

**Thinning** Thin up to 50% by volume with EP-10 Thinners for spray and dipping application.

**NOTE:** Use of thinners other than those supplied or approved by StonCor Africa may adversely affect product performance and void product warranty, whether express or implied.

## Application Conditions

Condition	Material	Surface	Ambient	Humidity
Normal	16-29°C	16-29°C	16-32°C	40-60%
Minimum	7°C	4°C	4°C	0%
Maximum	43°C	49°C	43°C	85%

Do not apply when the surface temperature is less than 3°C above the dew point.

Special thinning techniques may be required above or below normal conditions.

## Curing Schedule

These times are at the recommended maximum dry film thickness of 18 microns. Higher film thicknesses will lengthen cure times.

Surface Temp. & 50% Relative Humidity	Before Topcoating
10°C	24 Hours
16°C	18 Hours
25°C	4 Hours
32°C	2 Hours

**Surface Dry** 20 Minutes at 25°C

## Cleanup & Safety

**Cleanup** EP-10 Thinners

**Safety** Read and follow all caution statements on this product data sheet and on the MSDS for this product. Employ normal workmanlike safety precautions. Hypersensitive persons should wear protective clothing, gloves and use protective cream on face, hands and all exposed areas.

**Ventilation** When used in enclosed areas, thorough air circulation must be used during and after application until the coating is cured. The ventilation system should be capable of preventing the solvent vapor concentration from reaching the lower explosion limit for the solvents used. In addition to ensuring proper ventilation, appropriate respirators must be used by all application personnel.

**Caution** This product contains flammable solvents. Keep away from sparks and open flames. All electrical equipment and installations should be made and grounded in accordance with the National Electric Code. In areas where explosion hazards exist, workmen should be required to use non-ferrous tools and wear conductive and non-sparking shoes.

## Packaging, Handling & Storage

<b>Shipping Weight (Approximate)</b>	EP-10 Etch Primer	<b>5 Litre</b> 6.5kg	<b>20 Litre</b> 26kg
<b>Flash Point (Pensky Martens Closed Cup)</b>	EP-10 Etch Primer	<22°C	
<b>Storage Temperature &amp; Humidity</b>	4 to 43°C 0 to 100% Store indoors		
<b>Shelf Life</b>	6 Months minimum when stored at 25°C		

\*Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers.



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