EPINAMEL® PR250

P30.01

Description

- A universal two-pack adhesion promoting, polyamide cured epoxy primer.
- Approved to APAS-2971.
- Conforms to AS/NZS 3750.13 Type 2 and 3.

Product Characteristics

- General purpose epoxy primer in protective coating systems for steel and non-ferrous metals.
- Excellent adhesion to steel, galvanized steel, non-ferrous metals and fibreglass.
- Excellent flow and wetting properties.
- Excellent water and corrosion resistance.
- Cures at temperatures down to +5°C.
- Suitable for touching up of weld seams and damages of epoxy coatings during construction.
- Long recoating intervals are possible when overcoating with epoxy and polyurethane coatings.
- Can be overcoated with most alkyd, chlorinated rubber, epoxy, two component polyurethane and catalysed acrylic coatings.
- Suitable on wet blast cleaned substrates (damp or dry).
- Suitable primer for immersion systems (in fresh and salt water) when applied over suitably prepared surfaces.
- Suitable with well-designed cathodic protection systems.
- Cure with Epinamel EH100 standard hardener or Epinamel EH120 low temperature hardener.

Colours and Gloss

- Olive Green (contains aluminium flake pigmentation) and Lightbox Grey - semi gloss.

Recommended Film Thickness (Per Coat)

	Minimum	Maximum	Typical
Dry film thickness (µm)	50	200	75
Wet film thickness (µm)	90	365	135
Theoretical spreading rate (m^2/l)	11	2.8	7.3

Basic Data at 25°C

Solids content approx.	55% by volume
Mix ratio	4A:1B by volume
Touch dry after	1.5 hours (Epinamel EH100) 1 hour (Epinamel EH120)
Full cure	7 days (Epinamel EH100) 3 days (Epinamel EH120)

Surface Preparation

- All surfaces to be coated must be clean and free from chalking and contamination.
- Oil and grease should be removed from all surfaces in accordance with AS 1627.1 solvent cleaning.

MILD STEEL

- Blast clean in accordance with AS 1627.4 to Sa 2½ minimum (AS 1627.9), surface profile 40-70 microns.
- If oxidation occurs between blasting and application, the surface should be re-blasted to the specified visual standard.
- Surface defects revealed by the blast cleaning process should be ground, filled or treated in the appropriate manner.
- Power tool clean in accordance with AS 1627.2 to St 2 minimum (AS 1627.9), (atmospheric exposure only).
- Wet blast clean to achieve a surface similar to Sa 2½ (AS 1627.9), profile 35-50 µm (atmospheric exposure only).

GALVANISED STEEL

- Lightly blast using an inert grit or power tool clean to achieve a roughened uniform flat appearance.

ALUMINIUM

- Lightly blast clean using an inert grit and achieve a surface profile of 35-50 microns.
- Mechanically abrade using 80 grit paper/disc.

STAINLESS STEEL

- Clean using an inert grit and achieve a surface profile of 35-50 microns.
- Mechanically abrade using 80 grit paper/disc.

FIBREGLASS

- Mechanically abrade using 120 grit paper/disc.

ZINCALUME® or COLORBOND®

- Lightly sand the surface.

HOT METAL SPRAY

- High pressure water wash.

PREVIOUS SUITABLE COAT

- Dry and free from any contamination and sufficiently roughened if necessary.
- Substrate temperature must be at least 5°C during surface preparation, application and curing and at least 3°C above dew point.

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Application Instructions

- Mixing ratio by volume: 4A:1B.
- Mix Epinamel PR250 Part A with Epinamel EH100 Standard (Std) Part B or Epinamel EH120 Low Temperature (LT) Part B only.
- Induction time – none.
- Pot life at 25°C - 6 hours (Epinamel EH100). Do not use after this time even if the mix is still liquid.
- Stir the components and mixed product well using a mechanical mixer.
- The temperature of the mixed product must be above 15°C, otherwise extra thinner may be required to obtain application viscosity.
- Too much thinner will result in lower sag resistance and slower cure.
- Thinner should only be added after mixing the components.
- Freshly catalysed material should not be added to product that has been mixed for some time.
- Wattyl recommends the use of coating inspection reports in compliance with AS/NZS 3894.10,11,12 refer to Information Sheet I-20 for more information
- For recommendations outside those contained in this data sheet, refer to Wattyl.

Application Methods

	AIRLESS SPRAY	AIR SPRAY	BRUSH/ROLLER
Recommended thinner	Thinner L760	Thinner L760	Thinner L760
Volume of thinner	0-10%	0-10%	0-10%
Tip	0.46-(0.018 inch)	1.8-2.0mm	• The maximum dry film thickness that can be achieved when brushing/rolling is 50 microns. • Multiple coats may be required to achieve the recommended dry film thickness. • Nylon/polyester or natural bristle brushes recommended. • Recommended roller cover should be 10mm woven with a solvent resistant core.
Fluid/ Atomised pressure	15 MPa (2100 psi)	0.3-0.4 MPa (50-60 psi)	
Pump	30:1		
Hose	¼" ID (6.3mm)		
Filter	60 mesh		

CLEANING SOLVENT | Thinner L760

- If spraying for extended periods or if stopping work it is recommended to intermittently flush out spray lines.

Safety Precautions

- Flammable. Avoid contact with heat and naked flame.
- Avoid contact with skin and eyes.
- Use gloves, mask and goggles during application.
- Provide adequate ventilation when using in confined spaces.
- This product is intended for use in industrial situations by professional applicators in accordance with the advice given on this sheet. All work involving the use and application of this product should be carried out in compliance with all relevant Health, Safety & Environmental standards and regulations and must not be used without reference to the safety data sheet (SDS).

Additional Data

OVERCOATING TABLE

Overcoating interval for Epinamel PR250 cured with Epinamel EH100 Standard Part B when top coating with compatible **two-pack epoxy and polyurethane coatings.**

Interval	5°C	15°C	25°C	35°C
Min	36 hrs	16 hrs	8 hrs	6 hrs
Max*	3 mths	3 mths	3 mths	2 mths

**Maximum overcoating interval is double the time stated above for coatings not exposed to direct sunlight*

Overcoating interval for Epinamel PR250 cured with Epinamel EH100 Standard Part B when top coating with compatible **chlorinated rubber, alkyd and catalysed acrylic coatings.**

Interval	5°C	15°C	25°C	35°C
Min	16 hrs	6 hrs	5 hrs	3 hrs
Max*	21 days	14 days	10 days	5 days

Overcoating interval for Epinamel PR250 cured with Epinamel EH120 Low Temperature Part B when top coating with compatible **two-pack epoxy and polyurethane coatings.**

Interval	5°C	15°C	25°C	35°C
Min	12 hrs	6 hrs	3 hrs	2 hrs
Max*	28 days	21 days	14 days	7 days

**Maximum overcoating interval is double the time stated above for coatings not exposed to direct sunlight*

Overcoating interval for Epinamel PR250 cured with Epinamel EH120 Low Temperature Part B when top coating with compatible **chlorinated rubber, alkyd and catalysed acrylic coating.**

Interval	5°C	15°C	25°C	35°C
Min	6 hrs	4 hrs	2 hrs	1 hr
Max*	10 days	7 days	5 days	3 days

- When using Epinamel EH120 Part B for immersion applications the minimum overcoating times applicable for Epinamel EH100 Part B must be observed.

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- Surface must be dry and free from chalking and contamination prior to overcoating. If overcoating interval is exceeded, the surface must be dry and free from chalking and contamination and sufficiently roughened.

CURING AND POTLIFE TABLE

Epinamel PR250 cured with Epinamel EH100 Standard Part B.

Paint temperature	5°C	15°C	25°C	35°C
Dry to handle	12 hrs	6 hrs	2.5 hrs	1 hr
Full cure	21 days	10 days	7 days	5 days
Potlife (at applicable viscosity)	-	10 hrs	6 hrs	3 hrs

Epinamel PR250 Cured with Epinamel EH120 Low Temperature Part B.

Paint temperature	5°C	15°C	25°C	35°C
Dry to handle	7 hrs	3 hrs	1.5 hrs	1 hr
Full cure	9 days	5 days	3 days	2 days
Potlife (at applicable viscosity)	-	6 hrs	3 hrs	1.5 hrs

- Adequate ventilation must be continuously maintained during application and curing.

Precautions

- For recommendations outside those contained in this data sheet, refer to Wattyl.
- Epoxy coatings characteristically chalk or discolour on exterior exposure- this does not detract from their protective performance. For exterior atmospheric coating systems requiring colour retention and resistance to chalking, topcoat with a suitable product. Such products may include Poly U400, Poly U750 or Paracryl IF540. Ensure the system is suitable for your intended application.

Product Compatibility

PRIMERS

- Galvit ES510

TOPCOATS

- Epinamel EB600
- Epinamel DTS680
- Epinamel DTM985
- Epinamel TL770SF
- Duranamel BR22
- Poly U400 (colours)
- Poly U750
- Paracryl IF540 (colours)

Storage and Packaging

- Shelf life at least 12 months.
- All components shall be stored in a dry internal environment at between 5°C and 35°C.
- Packaging: 20 litre kit (16 litre Part A, 4 litre Part B)
  5 litre kit (4 litre Part A, 1 litre Part B)
- Product line: 2012.

For the most up to date information, please visit our website at www.wattylpc.com.au, or contact us at Australia 132 101 (Australia) 0800 825 7727 (New Zealand).

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