

EP300

2K Waterbased Epoxy Primer

Description

EP300 is a waterbased 2-component epoxy primer specially developed for application on trains, machines and commercial vehicles.
Composition based on epoxy.

Products

EP300	2K WB Epoxy Primer - ca. RAL 7035
EP300R	2K WB Epoxy Primer - ca. RAL 3012
EP300B	2K WB Epoxy Primer - ca. RAL 1011
EP350	WB EP Primer Activator
EP351	WB EP Primer Activator Slow
EP355	WB EP Primer Activator Fast
EP390	Standard Reducer
HT300	Imron® HydroTopCoat Reducer

Features

- Gives very good corrosion protection.
- Very good adhesion on metal substrates as listed below.
- High mechanical resistance.
- Good filling properties.

Substrates

- Abraded or shot blasted, Aluminium, Steel, Stainless Steel, GRP's, Polyester putty, fully cured old finishes

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Surface preparation

- Substrates must be free from all contaminants, rust and corrosion.
- Because of the wide variety of substrates and their manufacturing processes, a preliminary test should be carried out on the respective substrate to ensure that the pretreatment is sufficient to guarantee a perfect adhesion. For information on substrate and respective surface preparation, refer to the supplier's specifications.

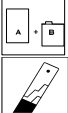

Substrate preparation for coating:

- Before application, the substrates need to be cleaned with a waterbased silicone remover.

VOC value ready for use (EU Directive 1999/13/EC)

- < 150 g/l (RFU at highest level)







Product preparation

 Mixing ratio	EP300 EP350 EP351/EP355 Thinner	Volume		Weight	
		2	7	100	100
		1		35	
			1		10
Thinner	EP390/HT300				
 Potlife at 20°C	2 hours (not visible)				
Recommended dry film thickness	40-80 µm (max. 120 µm)				

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



Application with WB EP Primer Activator EP350

		Application viscosity DIN 4 at 20°C (s)	Thinner (% by weight)	Spray nozzle (mm)	Pressure (bar)	Number of coats
	Gravity feed	30-40	20-25	1.4-1.8	3-4	1-2
	Suction feed					
(High pressure spraying)						
	HVLP	30-40	20-25	1.4-1.8	0.7 at nozzle	1-2
(Low pressure spraying)						
	Pressure pot Feed pump	30-40	20-25	1.2-1.4	3	1-2
(High pressure spraying)						
	Airless	DIN 6 20-40	5-10	Airless 0.33	170-200	1-2
	Airmix			Airmix 0.28 0.33	3-4 min. 120 (material)	
	Electrostatic	According to the advice of the Axalta Technical Representative.				

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Application with WB EP Primer Activator EP351/EP355

		Application viscosity DIN 4 at 20°C (s)	Thinner (% by weight)	Spray nozzle (mm)	Pressure (bar)	Number of coats
	Gravity feed	30-50	15-20	1.4-1.8	3-4	1-2
	Suction feed					
(High pressure spraying)						
	HVLP	30-50	15-20	1.4-1.8	0.7 at nozzle	1-2
(Low pressure spraying)						
	Pressure pot Feed pump	30-50	15-20	1.2-1.4	3	1-2
(High pressure spraying)						
	Airless	DIN 6 20-50	5-15	Airless 0.33	170-200	1-2
	Airmix			Airmix 0.28 0.33	3-4 min. 120 (material)	
	Electrostatic	According to the advice of the Axalta Technical Representative.				

Drying

Air drying at 20°C	Overnight
Forced drying	Flash time: 30 minutes (till completely flat).
Drying time and temperature	30-40 minutes (depending on activator used). 60-80°C object temperature

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Recoatability

Recoatability	Recoatability at 40 µm DFT with Imron® HydroTopCoat and with solventborne topcoat. Recoating with Imron® HydroTopCoat <ul style="list-style-type: none"> • Minimum flash time before recoating: until flat + 2 hours. Recoating with solventborne topcoat <ul style="list-style-type: none"> • Minimum flash time before recoating: until flat + 30 minutes.
Remarks	Max flashtime before recoating with above mentioned topcoats: 3 days. After 3 days, sanding is required.


Product Data

	Solids	Density	Theoretical coverage		Theoretical material consumption	
	Weight (%)	(kg/l)	(at 40 µm)		(at 40 µm)	
Ready for use	+/- 1	+/- 0.01	m ² /l	m ² /kg	ml/m ²	g/m ²
Activator EP350 EP300 : EP350 + EP 390 100 : 35 + 25% (by weight)	52	1.30	10.5	8.1	95	124
Activator EP351/EP355 EP300 : EP351/5 + HT300 100 : 10 + 20% (by weight)	59	1.40	11.7	8.4	85	119

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Remarks

	<ul style="list-style-type: none"> • Stir primer thoroughly before use for 3 to 4 minutes. • Before adding the reducer for viscosity correction, the activator has to be accurately mixed-in into the paint with a mechanical mixer for 3 to 4 minutes. • Preferably, a blade of 1/3 the size of the container is used. • Avoid air entrapment while stirring. • The spray equipment has to be from stainless steel. All stirring rods / containers in use have to be from stainless steel or plastic. • Material is frost-sensitive. • Material must be stored at a temperature between 5°C and 35°C. • Material has to be at room temperature (18-25°C) before use. • Activated material should not be returned to original can of non-activated material. • Close can of activator tightly immediately after use, as these products will react with humid air and water and lose their hardening effect. • Type of tape: tape suitable for waterborne products is required (local supplier to be contacted).
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Safety	<p>Consult the Safety Data Sheet prior to use. Observe the precautionary notices displayed on the container.</p>
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Storage conditions	<ul style="list-style-type: none"> • Refer to the label of the original can.
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Information

The information provided herein corresponds to our knowledge on the subject at the date of its publication. This information may be subject to revision as new knowledge and experience becomes available. The data provided fall within the normal range of product properties and relate only to the specific material designated; these data may not be valid for such material used in combination with any other materials or additives or in any process, unless expressly indicated otherwise. The data provided should not be used to establish specification limits or used alone as the basis of design; they are not intended to substitute for any testing you may need to conduct to determine for yourself the suitability of a specific material for your particular purposes. Since Axalta cannot anticipate all variations in actual end-use conditions Axalta makes no warranties and assumes no liability in connection with any use of this information. Nothing in this publication is to be considered as a license to operate under or a recommendation to infringe any patent rights.

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