

EP Metallgrund

R.68121

Customer: rail vehicle industry

Description

2K EP Corrosion Protection Primer Coating

EP Metallgrund is a 2K primer coating and is especially suited for the application on trains and commercial vehicles.

Composition based on epoxy resin.

Products

EP Metallgrund	Epoxy resin, solvent based
EP Activator R. 68619	Polyamin adduct
EP Thinner R.11511	EP Thinner

Colours

- Approx. RAL 3012, other colours on request.

Properties

- Provides a basic coating with mechanical resistance and excellent adhesion.
- Active anti-corrosive protection of steel and non-ferrous metal surfaces.
- Chromate and lead free.
- EG- and EGA-free.

Substrates

- Steel, aluminium, galvanised steel, glasfibre reinforced plastics (GRP), surfaces coated with polyester putty, firmly adhering old paintwork (after preliminary examination!).

For professional use only!

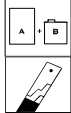

Surface preparation

- **Steel:** Remove any contamination. Surfaces should be dry and free from dirt, oil and grease. Blast cleaned to Sa 2 ½ according to DIN EN ISO 12944-4.
- **Aluminium/ galvanised Steel:** Remove any contamination. Surfaces should be dry and free from dirt, oil and grease. Prolonged contact with water has to be avoided. Sweep blast to Ra 5-10 µm (according to manufacturers advice). Only non-ferrous sanding agent is allowed.
- **Glasfibre reinforced plastics (GRP), surfaces coated with polyester putty, firmly adhering old paintwork** (after preliminary examination!): Remove any contamination. Surfaces should be dry and free from dirt, oil and grease. Surface sanding and cleaning if necessary.

VOC value ready for use (EU Directive 1999/13/EC) 493 g/l.







- 370 g/kg mixed.

Product preparation

	Mixing Ratio	Base component with EP Activator, R. 68619	Weight
			5 1
Application temperature		at least +15°C (surface and air temperature)	
Reducer		EP Thinner R.11511	
Relative Humidity		Max. 70% (application temperature should be at least at 3°C above the dew point).	
	Pot life at 20°C	Approx. 8 hours	
Recommended film thickness		60 µm (wet corresponds to approx. 140 µm).	

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Application

	Application viscosity AK 4 at 20°C (s)	Thinner (%)	Spray nozzle (mm)	Pressure (bar)	Number of coats
 Gravity feed	30	10 - 15	1.5 - 2.0	3.0 - 5.0	1 - 2
 Suction feed (High pressure spraying)					
 HVLP (Low pressure spraying)	30	10 - 15	1.5 - 2.0	0.7 at nozzle	1 - 2
 Airless Airmix	Thixotropic, not measurable	0 - 5 5 - 10	Airless 0.38 - 0.48 Airmix 0.33 - 0.48	approx. 180 at least 100 4 - 5 atomization	1 - 2
 Pressure pot Membrane pump (High pressure spraying)	30	10 - 15	1.5 - 1.8	3.0 - 4.0	1 - 2
Rolling	60	0 - 5	Only suitable for small surfaces.		
 Electrostatics	According to the advice of the Axalta Technical Representative. (see data sheet electrostatic spraying)				

Drying

Drying/Curing	15°C	20°C	25°C
Air drying	TG1 60 minutes TG6 16 hours	TG1 30 minutes TG6 10 hours	TG1 20 minutes TG6 8 hours
Dry to recoat	After approx. 16 hours		
Dry	14 days, then full mechanical and chemical load capacity.		

Forced drying	Flash off time: at least 30 min.
Drying temperature 60°C	TG6 2 hours
Forced drying	Flash off time: at least 30 min.
Drying temperature 80°C	TG6 1 hour

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Recoatability


Note	Recoatable with itself and Axalta® systems (solvent-based and waterbased) according to our technical advisory. Others on request. Sanding dry: ≥ grit 80.
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Product data

Package viscosity	6.800-7500 cp
Flash point	23°C
Heat resistance	dry: up to +120 °C direct heat

(Unreduced)	Solids	Solids	Density	Theoretical coverage	Theoretical material consumption
	Weight (%)	Volume (%)	(kg/l)	(at 60 µm) (m ² /kg)	(at 60 µm) (m ² /kg)
Mixed with activator	63	43	1.33	5.3	0.187

Important remarks

	Stir base component thoroughly, then add hardener at the specific mixing ratio. Stir fully using a powered mixer.		
Comments		Shelf Life (5-35°C)	Density
	EP Metallgrund	24	1.451
	EP Activator R. 68619	18	0.950
	EP Thinner R.11511	24	0.846

Safety

Consult the Safety Data Sheet prior to use.
Observe the precautionary notices displayed on the container.

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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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