



EPOXYKOR PRIMER 70

DESCRIPTION



Quick-drying polyamine-cured primer with ecological phosphate pigment. The product can be used for painting on steel, hot-dip galvanized steel and aluminum surfaces.

COLOUR



BF Grey, Grey, AST Beige, according to RAL

PROPERTIES

- very fast drying time
- very high resistance to chemical agents (including solutions of acids, bases, gasoline and diesel oil)
- very high resistance to mechanical factors
- water resistance
- resistance to inflammable substances
- temperature resistance up to 180°C (temporary increase to 200°C)
- increased resistance to stains
- resistance to aggressive factors of urban, sea and industrial atmosphere

USAGE

The product is used as a primer or supplementary interlayer of anti-corrosion protection in:

- infrastructure construction (bridges, flyovers, footbridges, railings, etc.),
- industrial construction (supporting elements, silos, sheets, containers, pipelines, load-bearing structures),
- mechanical and shipbuilding industry (sea parts of ships, agricultural, construction and mining equipment and machines),
- for temporary protection.

In the case of final painting, the product can be used on structures inside buildings or those that are not exposed to direct UV radiation.

SPECIFICATIONS



Brookfield viscosity	2000 -4000 mPas	for an ambient temperature of 20±2°C
Density	1,60 (±0,05)	g/cm ³
VOC content of volatile organic compounds	To 484	g/l
Solvent content	32	Weight %
Solid content	76 (±3)	Volume %
Covering power, color stability	The coating undergoes the chalking process under the influence of solar radiation.	



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Working temperature



In a dry atmosphere, the coating can be exposed to constant temperature of 180°C (a temporary increase up to 200°C is allowed).

Layer thickness

DFT " dry film thickness"	WFT " wet film thickness"	Theoretical consumption		Theoretical performance
[µm]	[µm]	[l/m ²]	[kg/m ²]	[m ² /l]
50	65	0,065	0,11	15,40
120	160	0,15	0,24	6,66
180	240	0,24	0,38	4,16

APPLICATION



Application method

Brush (small areas with the addition of 20% thinner), roller, pneumatic spray, airless spray.

Hydrodynamic spraying

Nozzle tip	Dilute %	Pressure
0,013 - 0,025 "	0 - 5 %	200 - 250 Bar

The width of the sprayed jet, the so-called spray angle, should be chosen taking into account the shape and size of the surface to be painted.

Air spraying parameters

Nozzle tip	Dilute %	Pressure
1,6 - 3,0 mm	5 - 15 %	2,5 - 5,0 Bar

The recommended product flow time measured with Ford Cup No. 4 for pneumatic spraying is within 60 - 75 seconds.

These parameters should be compared with those recommended by the spray gun manufacturer.

Thinner

THINNER EP production of Malchem.

Recommended number of layers

1-3

Coating enamels

EPOXYMAL 54, WINYMAX M, NEOMAL and products type PURMAL production of Malchem.

Surface preparation

Surface	Preparation
Steel	The surface should be cleaned at least to grade St 3 in accordance with PN-EN ISO 8501-1: 2008 (except for applications in the C5, for which the degree of cleaning is Sa 2½). Dry substrate, free from traces of corrosion, scale, dust, grease, oil, salt and any other contamination. To degrease the surface, it is recommended to use Cleanmal Top by MALCHEM.
Galvanized steel, aluminum	The hot-dip galvanized and aluminum surface should be cleaned of the above-mentioned contaminants, very thoroughly degreased with Clean Mal Top by Malchem and dried. In addition, it is recommended to lightly sweep the so-called abrasive. "Sweeping" or washing with water with the addition of ammonia (slightly alkaline pH) and rinsing thoroughly.



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Application conditions

- Temperature: minimum substrate -5°C, minimum 3°C above dew point temperature, minimum ambient -5°C
- Humidity: maximum relative air 80%
- Safety: efficient and adequate ventilation in the workplace

Mixing of components



Version IN PLANT		
	Component A: Base	Component B: Hardener 508
By weight	100	13
By volume	100	22

The above values indicate the capacity of the packaging, not the actual volume of the product in the packaging.

Ready to use

5 minutes (in temp. 20±2°C)

Pot-life of mixture

4 hours (in temp. 20±2°C)

Drying times

For layer DFT 120 (±10%) µm (in temp. 20±2°C and relative humidity 55±5%)	
Degree 1	1h 30 min
Degree 3	2h 30 min
Degree 5	4 h
Completely cure	7 days
Minimum for applying the next coat	1 h

For layer DFT 50 (±10%) µm (in temp. 20±2°C and relative humidity 55±5%)	
Degree 1	1 h
Degree 3	2 h
Degree 5	3 h
Completely cure	7 days
Minimum for applying the next coat	1 h

These parameters may vary with changing environmental conditions, the number and thickness of the layers. The negative effect on the curing of the coating is, first of all, insufficient temperature and high humidity (rain, condensation of water vapor).

ADDITIONAL INFORMATION

Storage



The material should be stored in original, tightly closed containers, away from possible sources of fire, in places exposed to direct sunlight or elevated temperatures, children should be protected from access to products, storage temperature: from 5°C to 30°C.

Shelf life



The minimum shelf life indicated on the package is the value of the indication, which depends on a number of factors - first of all, the method and temperature of storage. After exceeding the specified date, the quality of the product must be reviewed.

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COATINGS

Safety information



Information on the presence, detection of threats, actions during first aid and in case of fire, as well as environmental and legal regulations can be found in the safety data sheet, which can be obtained from the manufacturer Malchem.

Basic security measures

- Read the information on the product packaging.
- Efficient and appropriate ventilation at the workplace.
- Avoid contact with skin and inhalation of vapors.
- Use of costumes, gloves and masks.
- If the product comes in contact with skin, wash the area with warm water and soap or other detergent.
- In case of contact of the product with eyes, rinse immediately with water and seek medical advice immediately.

PRODUCT IS INTENDED FOR PROFESSIONAL USE ONLY

The above information is based on our current knowledge and experience. However, they are not completely exhaustive and complete. We provide them in good faith based on laboratory research and practical experience. However, due to the variety of methods, application and usage conditions, they should be verified in specific applications. The product is intended only for professional and industrial use by persons who have sufficient knowledge and experience in its use. The manufacturer cannot control the conditions under which the product is used. Under applicable regulations, we do not take responsibility for damages caused by using the product in a manner inconsistent with applicable standards and recommendations. Use of the product for purposes other than indicated in this document only and exclusively at the user's own risk. The product information provided is subject to change without notice.