

## Epifanes Metalprimer

### One-component anti-corrosive primer

<b>Type</b>	Air drying
<b>Base</b>	Alkyd- and urethane resin + zinc phosphate
<b>Properties</b>	One-component primer with excellent anti-corrosive properties.
<b>Field of application</b>	Steel: for interior and exterior use above the waterline. Repair and filling primer on existing one-component paint systems above the waterline.
<b>Colours</b>	White - grey
<b>Gloss</b>	semi gloss
<b>Density</b>	1,35 kg/dm <sup>3</sup>
<b>Viscosity</b>	120-130 sec. DIN-Cup 4 mm
<b>Solids contents</b>	55 +/- 2 vol. %
<b>VOC - level</b>	404 grams/liter
<b>Packing</b>	750ml. - 2000ml. - 4000ml.
<b>Shelf life</b>	In closed original container stored in a dark location between 5 - 25°C approx. 3 years.
<b>Conditions during application and drying</b>	Temperature                      minimal 10°C. - maximum 28°C. Relative air humidity           minimal 50% - maximum 75%
<b>Thinner for brush applications</b>	Epifanes Brushthinner for Paint & Varnish
<b>Thinner for conv. spray applications</b>	Epifanes Spraythinner for Paint & Varnish
<b>Thinner for airless spray applications</b>	Epifanes Thinner D-200
<b>Application tools</b>	Moltpren foam roller, soft, longhaired brush or conventional air spray
<b>Recommended filmthickness / coat</b>	80 µm wet = 45 µm dry    Do not apply higher wet film.  Recommended total film thickness 120 µm dry. (= 3 coats). Apply first coat on bare steel 20-25% using a stiff brush. This will provide a better bonding in the steel surface
<b>Application recommendations</b>	Stir well prior to use and during application. Do not overbrush. Do not apply wet-in-wet. Avoid excessive wet films to avoid the formation of curtains and through drying problems. Application by roller is advised. Avoid painting in direct sunlight or too much wind. A rapid loss of solvents will occur under these conditions and degrease the flowing ability. The application and drying should occur in well ventilated areas. Always secure sufficient air circulation for supply of fresh air and disposal of solvent fumes and in order to avoid drying problems.
<b>Theoretical coverage</b>	10-12m <sup>2</sup> per liter @ 45µm dry filmthickness
<b>Practicle coverage</b>	Dependent on condition of substrate, loss of material due to factors such as application technique, shape of object, circumstances during application.
<b>Substrate conditions</b>	Temperature of paint, object and work area during application and dryingshould not be lower than 10°C. Relative air humidity should not exceed 85%.

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**Application details**

	Air spray	Airless spray	Brush/Roller
Thinning volume	10 - 20%	5-10%	0-5%
Nozzle	1.5 mm-2.0 mm	0.018 - 0.021 "	
Pressure in bar	3 - 5	120-150	
Visc. DIN-cup 4 mm	20-24 sec.	60 - 80 sec.	

**Intercoat sanding**

For necessary intercoat adhesion, sand every coat of Epifanes Metalprimer Primer with P180-220 dry abasive paper.

**Drying times @ 20°C. / 65% RAH and 45 µm dry filmthickness**

Dustdry	Sandable by hand	Recoatable
2 hours	6 hours	12 hours

**Substrate condition**

Dry, free of contamination and rust , well degreased and sanded with P 60 dry. Apply first coat on bare steel 25% thinned immediately after surface preparation.

**Previously painted surfaces**

Well bonding, dry, clean, well degreased , sanded with P240-280 dry and dust free.

**Recoatability**

Epifanes Yacht Enamel - Epifanes Mono-urethane Yacht Paint  
 Epifanes Bilge Paint - Epifanes Nautiforte Yacht Paint  
 Epifanes Undercoat - Epifanes Multiforte

**Recoatibility limitations**

Do not apply epoxy filler / epoxy based primers and/or coatings on Epifanes Metalprimer.

**Suitable filler**

Epifanes Combi Filler (max. 1 mm per coat)

**Safety**

The user of this product should obey all all national laws and legislation concerning health, safety and environmental hazard. For more information on health and safety, refer to the Material Safety Data Sheet of this product.

Although the facts and suggestions in this product information sheet are based on our own research and field experiences and are believed reliable, we cannot simply be held responsible for performance or results obtained through the use of this product. Ineffectiveness or other unintended consequences may result, because of such factors as weather, conditions, presence or other materials or the manner of preparation, use or application all of which are beyond W. Heeren & Zoon's control. All such risks are assumed by user.

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