



zandleven coatings

MONOPOX[®] Refinish PRIMER

epoxy

Two components fast drying epoxy primer.

- Easy to apply using electrostatic equipment
 - Recoatable with a 2 pack finish coat after 30 minutes of drying/evaporation
 - Application and hardening is possible at high relative humidity up to 90%.
 - After hardening excellent mechanical resistance and elasticity.
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- When exposed direct to sunlight, coating will chalk.

Product information

Finish	Semi-flatt
Color	beige
Mass density	approx. 1.4 kg/L (mixed product)
Solids content by volume	approx. 52 volume % (mixed product)
VOC	approx. 415 gr./L (volatile organic compound)
Recommended film thickness	60-80 µm d.f.t. per layer 115-155 µm w.f.t. per layer (undiluted)
Theoretical spreading rate	At 60 µm d.f.t. 8.7 m ² /L At 80 µm d.f.t. 6.5 m ² /L
Practical spreading rate	Depending on several factors like shape of object, profile of surface, method of application, application circumstances and experience. A few guiding principles are: Brush/roller :85-90% of the theoretical spreading rate Spraying :50-70% of the theoretical spreading rate
Flashpoint ISO 1523	Base 27°C Hardener 2V4 30°C Thinner FGM 631 26°C Thinner WTD 107 14°C
Dry temperature resistance	120°C
Durability	At least 12 months, provided that it has been stored in closed original packing at a dry and cool spot.

Drying times

For d.f.t. up to 60 µm
Dust dry
Manageble
Complete hardening
Recoatable:
Minimum interval
Maximum interval

30°C	20°C	10°C
20 minutes	30 minutes	45 minutes
30 minutes	45 minutes	60 minutes
10 days	14 days	28 days
20 minutes	30 minutes	60 minutes
3 days	7 days	14 days

Film thickness, ventilation, temperature and relative humidity are of great influence on the drying times.



Application instructions

Mixing ratio

Volume:	Base – hardener 2V4	5:1
Weight:	Base – hardener 2V4	89:11

Mixing instructions

Base and hardener should be mixed and applied at temperatures above 10°C. At lower temperatures extra thinner is needed, which gives a slighter resistance against sagging and which will delay hardening. The components should be mixed homogeneously, with a mechanical blender. Pay attention to the side and bottom of the can.

Induction time

At 20°C not necessary
At 10°C at least 10 minutes

Pot life after mixing

20 litre packing: approx. 10 hours at 10°C
 approx. 4 hours at 20°C
 approx. 2 hours at 30°C

Application instructions

During application and hardening, the temperature should be at least 5°C, in order obtaining the maximum chemical- and mechanical properties

Application and curing at lower temperature (down to -5°C) is possible but requires much more time. A fully cure product will be obtained much later.

The substrate must be free of water, moist and ice. The substrate temperature should be at least 3°C above dewpoint.

Application of this product interior requires suitable ventilation in order to ensure drying of the paint, health legislation and safety

Usage information

Type of thinner

Recommended thinner
(depending on application
and equipment)

Nozzle orifice

Nozzle pressure

Maximum attainable d.f.t.

Cleaning of tools

Airless-spray	Airspray
FGM 631 / WTD 107	FGM 631 / WTD 107
0 – 10 vol. %	0 – 10 vol. %
0.23 – 0.33 mm 0.009 – 0.013 inch	1.0 – 1.5 mm
80 – 160 bar	2 – 3 bar
100 µm	60 µm
Thinner FGM 631 / WTD 107	

Surface conditions

Steel

New steel:

Blasting according to the ISO standard 8501-1:2007 Sa 2½.
Roughness profile Ra 10-12 µm Rz 50-60 µm.
Surface must be clean and dry.

Aluminium:

Degrease thoroughly followed by inert seep blasting or sanding

Stainless Steel:

Degrease thoroughly followed by inert sweep blasting or sanding

Damage repair or maintenance:

The surface has to be cleaned thoroughly using a suitable cleaning agent or using steam equipment

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Product Characteristics

No coating work shall be carried out when the temperature of the surface is less than 3°C above dewpoint and when the substrate temperature is below 5°C.

Due to the presence of solvents, applying this product in confined spaces, adequate ventilation has to be ensured.

At low temperature and under humid conditions, amine blushing can occur, which can effect the intercoat adhesion negatively. Prior to the application of the next layer, the previous layer must be checked for this phenomena.

Discoloration or loss of gloss or other surface defects, can occur during drying and curing by condensation and or early water spotting. In particular bright and "full" colours.

This coating product is based on epoxy technology. It is recommendable that it should be overcoated with a durable finish.

Maximum film build in one coat is best attained by airless spray. Application by other techniques, it may be necessary to apply multiple coats in order to achieve the total specified dry film thickness.

Ventilation rules**Minimum required quantity of air to comply with:**

	MAC	10 % LEL
Monopox Refinish PRIMER	2165 m ³ /L	86 m ³ /L
Thinner FGM 631	3995 m ³ /L	160 m ³ /L
Thinner WTD 107	4085 m ³ /L	168 m ³ /L

MAC = Maximum Accepted Concentration

LEL = Lower Explosion Limit

Also consult the safety information sheets

Additional and applicable information (www.zandleven.com)

- General guidelines
- Material Safety Data Sheet
- information curing agents en thinners
- Color surcharge
- General terms and conditions of delivery

*Zandleven*

These data have been drawn up to the best of our knowledge and were correct at the date of issue. However we cannot accept full responsibility, because de choice of products and circumstances during elaboration of the systems fall outside our judgement. This documentation sheet will not automatically be replaced in case of modification. English language text is a translation. In case of doubt the Dutch language original text has to be consulted as the authoritative text.