



zandleven coatings

MONOPOX® SHOPPRIMER

epoxy

A two components fast drying welding and transport epoxy primer, free from lead and chrome.

Manageable within 15 minutes at a surface temperature of 30 °C and a film thickness of 25 µm.

- Excellent welding properties, does not develop any harmful vapours.
- Term of protection about 6 months at a film thickness of 25 µm, depending on the roughness of the surface and atmospheric circumstances.
- After drying recoatable with practically any paintsystem.

Product information

Finish	Eggshell
Colour	Redbrown
Mass density	approx. 1.6 kg/L (mixed product)
Solids content by volume	approx. 50 volume % (mixed product)
VOC	approx. 350 gr./L (volatile organic compound)
Recommended film thickness	As welding primer 25 µm d.f.t. per layer Other applications 25-60 µm d.f.t. per layer 50-120 µm w.f.t. per layer (undiluted)
Theoretical spreading rate	At 25 µm d.f.t. 20.0 m²/L At 60 µm d.f.t. 8.3 m²/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 23 °C Hardener 2V4 30 °C Thinner FGM 631 26 °C Thinner WTD 107 14 °C
Dry temperature resistance	160 °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 25 µm

Dust dry

Manageable

Recoatable:

Minimum interval

Maximum interval

30 °C	20 °C	10-5 °C
10 minutes	15 minutes	½ hour
15 minutes	25 minutes	1 hour
2 hours	3 hours	8 hours
Unlimited, provided that the surface is dry and clean.		
Film thickness, ventilation, temperature and relative humidity are of great influence on the drying times.		



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Application instructions

Mixing ratio	Volume: Base – hardener 2V4	81,5:18,5
	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 will give a slighter resistance against sagging and which will delay hardening.	
Induction time	At 20 °C not necessary At 10 °C at least 10 minutes	
Pot life after mixing	20 litre packing:	approx. 16 hours at 10 °C approx. 8 hours at 20 °C approx. 5 hours at 30 °C
Optimal application circumstances	Temperature : 15-25 °C Humidity : 40-75%	

Technical and esthetical properties can change when the product has been applied under different conditions.

Usage information

Type of thinner
Recommended thinner (depending on application and equipment)
Nozzle orifice
Nozzle pressure
Typical d.f.t.
Cleaning of equipment

Airless-spray	Airspray
FGM 631 / WTD 107	FGM 631 / WTD 107
10 – 25 vol. %	10 – 25 vol. %
0.41 – 0.46 mm 0.016 – 0.018 inch	1.0 – 1.5 mm
140 – 160 bar	3 – 4 bar
60 µm	40 µm
Thinner FGM 631 / WTD 107	

Surface conditions

Steel

New steel:

Blasting according to the ISO norm 8501-1:1988 Sa 2½.

Roughness profile Ra 10-12 µm Rz 50-60 µm.

Surface must be clean and dry.

Repair and maintenance:

Clean the surface thoroughly with a suitable cleaning preparation or by means of steam cleaning.

Remove salts and other water-soluble impurity by spraying with clean tap-water under high pressure.

Remove rust a.o. by (water)blasting Sa 2½ or derust mechanical until St. 2-3.

Apply the advised paint system on a clean and dry surface.

- Mechanical or hand derusting gives less quality than (water)blasting and will result in less protection of the applied paint system.



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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.

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.

Safety description

See safety data sheet

Ventilation rules

Minimum required quantity of air to comply with:

	MAC	10 % LEL
Monopox shopprimer	2870 m³/L	85 m³/L
Thinner FGM 631	3995 m³/L	160 m³/L
Thinner WTD 107	4085 m³/L	168 m³/L

MAC = Maximum Acceptable Concentration

LEL = Lower Explosion Limit

Also consult the security information sheets

Pretreatment / Labeling / Technical Terms (downloadable from www.zandleven.com)

A 1 Labeling of paint products in the European Community

A 2 Physical data

A 4 General guidelines for steelpreservation

A 6 Pretreatment of construction steel

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.

