



DATA SHEET

EPOXY FIXING PRIMER

PR20

Epoxy dual component fixing primer for all surfaces.

CHARACTERISTICS

This primer gives excellent adhesion to polyester, aluminium and steel, as well as good protection against corrosion. It serves as a base for epoxy treatment cycles as well as for fixing antifoulings on new polyester hulls.

PHYSICAL CHARACTERISTICS

Hardening mechanism: Chemical reaction between compounds A and B and evaporation of the solvent.
Density: 1.45 (base) / 0.917 (hardener)
Flash point: 27.5°C
Dry extract (weight): 73 % (base) / 38 % (hardener)
Viscosity: 125 +- 20 p A6V10 (base) / 63'' +- 5'' NF4 (hardener)
Thickness of the dry film per layer: 40 microns
Recommended total thickness: 40 microns
Practical coverage per layer: 8 m²/l
Finish : Mat green

PREPARATION OF THE SURFACE

On new aluminium or steel hulls: Sandblast the surface, dust well and apply the **PR20** primer immediately.

On new gel-coat: Clean with the de-waxer/grease remover **DCR900**, leave to dry and apply the primer.

PREPARATION OF THE PAINT

Mixing thoroughly mix the base and the hardener separately. Then, mixing base, hardener and thinner. Let the mixture mature for 15-20 minutes before use.

Mixing ratio by volume: Base: 65 / Hardener: 35 / Thinner: 0 to 10

Thinner for spray gun, brush and roller: **Thinner for PR20** (ex D200)

Length of mixture's pot life: About 8 hours at 20°C.

APPLICATION

Apply one 40-microns layer of epoxy primer **PR20** (dry film). Leave to dry 6 hours mini, 20 hours maxi before applying the epoxy undercoat **SC20** or leave to dry 6 hours mini (12 hours maxi) before applying antifouling on the polyester.

CHARACTERISTICS FOR USE

Application material: Brush, roller and spray gun.
For brush and roller: 5% dilution.
For spray gun: 5 to 10% according material.
Temperature range for use: 10 to 30°C
Relative Humidity: Below 80%

Reminder: The temperature of the surface must be at least 3°C above the dew point in order to avoid the formation of condensation.

Drying (at 20°C):

Away from dust: 30 minutes
Dry to touch: 4 hours
Over-coating: With an antifouling during 6 hours mini / 12 hours maxi by antifouling
..... With an epoxy or a polyurethane paint during 20 hours (a light sanding is necessary after 20 hours).
Full polymerisation: 10 days at ambient temperature.

Times indicated above increase if the temperature of use and the support is lower than 21°C, conversely they decrease if the temperature is higher than 21°C.

CHARACTERISTICS OF THE POLYMERISED PRIMER

Water resistance: Excellent.
Adhesion: Excellent.

PACKING AND STORAGE

Packaging : 750 ml and 2.5 litres
Storage : 12 months in original closed packaging stored in a dry place.

PRECAUTIONS FOR USE

Use protective gloves, solvent protective masks and clothes.

Work in a ventilated area; an accumulation of solvents can catch fire if exposed to a naked flame or a spark.

HEALTH AND SAFETY

See data sheet

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