

**DESCRIPTION**

- a two pack adhesion promoting, polyamide cured epoxy primer suitable for use as a prefabrication / preweld primer

**PRINCIPAL CHARACTERISTICS**

- provides excellent short term corrosion protection to steel
- excellent welding properties
- minimal fuming and splatter when cutting or welding
- excellent adhesion to steel
- excellent flow and wetting properties
- cures at temperatures down to +5°C
- suitable for overcoating with selected protective coating systems
- compatible with cathodic protection systems
- cure with Epiname! EH100 standard hardener or Epiname! EH120 low temperature hardener
- for use of Epiname! PR250 as a standard epoxy primer refer to technical data sheet P30.01

**COLOURS AND GLOSS**

- Olive Green only – semi gloss

**RECOMMENDED FILM THICKNESS (PER COAT)**

	Minimum	Maximum	Typical
Dry film thickness microns	15	20	15
Wet film thickness microns	27	36	27
Theoretical spreading rate m <sup>2</sup> /l	36.7	27.5	36.7

**BASIC DATA AT 25°C**

- solids content approx.....55% by volume
- mix ratio .....4A:1B by volume
- touch dry after .....1 - 2 hours (Epiname! EH100)
- full cure .....7 days (Epiname! EH100)  
3 days (Epiname! EH120)
- temperature resistance .....95°C (dry), 35°C (wet)

**SURFACE PREPARATION**

- all surfaces to be coated must be clean and free from contamination
- oil and grease should be removed from all surfaces in accordance with AS 1627.1 solvent cleaning

**MILD STEEL**

- blast clean in accordance with AS 1627.4 to Sa 2½ minimum (AS 1627.9), surface profile 40-70 microns
- if oxidation occurs between blasting and application, the surface should be reblasted to the specified visual standard
- surface defects revealed by the blast cleaning process should be ground, filled or treated in the appropriate manner
- substrate temperature must be at least 5°C during surface preparation, application and curing and at least 3°C above dew point

**APPLICATION INSTRUCTIONS**

- mixing ratio by volume: 4A : 1B
- mix Epiname! PR250 Part A with Epiname! EH100 Standard (Std) Part B or Epiname! EH120 Low Temperature (LT) Part B
- induction time - none
- pot life at 25°C - 6 hours (Epiname! EH100). Do not use after this time even if the mix is still liquid
- stir the components and mixed product well using a mechanical mixer
- product shall be thinned 30% with Thinner L760 to allow application at the nominated film build
- thinner should only be added after mixing the components
- freshly catalysed material should not be added to product that has been mixed for some time
- adherence to the nominated dry film thickness is critical to ensure adequate weld through properties of the coating
- Valspar recommends the use of coating inspection reports in compliance with AS/NZS 3894.10,11,12 refer to Information Sheet I-20 for more information
- for recommendations outside those contained in this data sheet, refer to Valspar

**APPLICATION METHODS**

- **AIRLESS SPRAY**
  - recommended thinner .....Thinner L760
  - volume of thinner .....30%
  - nozzle orifice approx. ....0.46 mm  
(0.018 inch)
  - nozzle pressure .....15 MPa (2100 psi)
- **AIR SPRAY**
  - recommended thinner ..... Thinner L760
  - volume of thinner ..... 30%
  - nozzle orifice ..... 1.5-2.0mm
  - nozzle pressure ..... 0.3-0.4 MPa (50-60 psi)
- **CLEANING SOLVENT**.....Thinner L760
- If spraying for extended periods or if stopping work it is recommended to intermittently flush out spray lines.

**SAFETY PRECAUTIONS**

- flammable. Avoid contact with heat and naked flame
- avoid contact with skin and eyes
- use gloves, mask and goggles during application
- provide adequate ventilation when using in confined spaces
- this product is intended for use in industrial situations by professional applicators in accordance with the advice given on this sheet. All work involving the use and application of this product should be carried out in compliance with all relevant Health, Safety & Environmental standards and regulations and must not be used without reference to the Material Safety Data Sheet (MSDS)

**ADDITIONAL DATA**

**Overcoating Table**

Overcoating interval for EpinameL PR250 cured with EpinameL EH100 Standard Part B when top coating with compatible **two pack epoxies**

Interval	5 °C	15 °C	25 °C	35 °C
Min	36 hrs	10 hrs	8 hrs	6 hrs
Max*	3 mths	3 mths	3 mths	2 mths

\*Maximum overcoating interval is double the time stated above for coatings not exposed to direct sunlight

Overcoating interval for EpinameL PR250 cured with EpinameL EH120 Low Temperature Part B when top coating with compatible **two pack epoxies**

Interval	5 °C	15 °C	25 °C	35 °C
Min	2 hrs	1½ hrs	1 hr	30 min
Max*	16 days	16 days	16 days	7 days

\*Maximum overcoating interval is double the time stated above for coatings not exposed to direct sunlight

**Overcoating Procedure**

- all damaged, corroded and burnt area shall be reblasted and spot primed before application of protective coating system
- if maximum overcoating interval is exceeded, the entire surface shall be whip blasted before application of protective coating system
- surface must be dry and free from contamination
- prefabrication primer shall be overcoated with a full coat of EpinameL epoxy primer forming part of the subsequent protective coating system
- when using EpinameL EH120 for immersion applications the minimum overcoating times applicable for EpinameL EH100 must be observed

**Curing and Potlife Table**

**EpinameL PR250 Cured with EpinameL EH100 Standard Part B**

Paint temperature	5 °C	15 °C	25 °C	35 °C
Dry to handle	6 hrs	3 hrs	2 hrs	1 hr
Full cure	21 days	10 days	7 days	5 days
Potlife (at application viscosity)		10 hrs	6 hrs	3 hrs

**EpinameL PR250 Cured with EpinameL EH120 Low Temperature Part B**

Paint temperature	5 °C	15 °C	25 °C	35 °C
Dry to handle	3 hrs	2 hrs	1 hr	45 min
Full cure	9 days	5 days	3 days	2 days
Potlife (at application viscosity)		6 hrs	3 hrs	1½ hrs

- adequate ventilation must be continuously maintained during application and curing

**PRECAUTIONS**

- for recommendations outside those contained in this data sheet, refer to Valspar
- epoxy coatings characteristically chalk or discolour on exterior exposure- this does not detract from their protective performance.

**PRODUCT COMPATIBILITY**

**Primers**

- n/a

**Topcoats**

- EpinameL PR250
- EpinameL EB600
- EpinameL DTM985

**STORAGE AND PACKAGING**

- shelf life at least 12 months
- all components shall be stored in a dry internal environment at between 5 °C and 35 °C
- packaging 20 Litre kit (16 Litre Part A, 4 Litre Part B), 5 Litre Kit (4 Litre Part A, 1 Litre Part B), 1 Litre kit (800mL Part A, 200mL Part B (EpinameL EH100 only)
- product line: 2012



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ISO 9001

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