

EPICOL HOTWELL PRIMER L1143

PRODUCT DESCRIPTION

A specially designed amine adduct cured epoxy (two pack) both decorative and protective. Use as part of the Epicol Hotwell system.

USES

Primer in the Epicol Hotwell system for the protection of gritblasted iron and steel in immersion conditions up to 95°C.

TECHNICAL PROPERTIES

Colour	Red Oxide		
Finish	Matt		
Curing Agent	Hotwell Curing Agent		
Mix Ratio	3 Base : 1 Curing Agent by volume		
Specific Gravity	1.22		
Volume Solids	46%		
Recommended Film Thickness	110 WFT / 50µ DFT		
Theoretical Spreading Rate	9.2 m ² /litre		
Application Method	Brush, Spray		
Flash Point	> 23°C		
VOC	470g/litre		
Drying Times	10°C	20°C	30°C
Touch Dry	1 ½ hours	1 hour	40 minutes
Hard Dry	10 hours	7 hours	5 hours
Full Cure	14 days	10 days	6 days
Minimum Overcoat	26 hours	20 hours	16 hours
Maximum Overcoat	32 hours	26 hours	22 hours

Do not expose to immersion conditions until the system is fully cured.

CERTIFICATION/APPROVALS

RECOMMENDED SYSTEMS

Use as a primer in the Epicol Hotwell system.

SURFACE PREPARATION

Steel: Oil and grease should be removed by solvent cleaning according to SSPC- SP1. Remove weld spatter and smooth weld seams and sharp edges as applicable. Abrasive blast cleaning to minimum SA 2½. Power tool cleaning to minimum ST2. Please note that better surface preparation always results in longer lifetime expectations. Apply Epicol Hotwell Primer immediately after the steel has been blasted and the quality of preparation has been approved.

Repair: Existing systems should be roughened and dry and free from loose paint, salt, grease and other contaminants prior to overcoating. Corroded and/or damaged areas should be power tool cleaned to ST2 or better or blast cleaned to SA2.

PRODUCT APPLICATION

Mixing	Mix 3.75 litre Base with 1.25 litres Curing Agent. Mix thoroughly. Pot life 5 hours @ 20°C.
Thinners	Thinner No.11
Brush	Suitable. Thin with up to 5% Thinner No.11 if required.
Roller	Not recommended.
Conventional Spray	Not recommended.
Airless Spray	Suitable. Thin with up to 5% Thinner No.11 if required.
Air Assisted Airless Spray	Suitable. Thin with up to 5% Thinner No.11 if required.
Cleaner	Thinner No.11
Cleanup Considerations	All equipment should be cleaned immediately after use with Thinner No.11 It is advisable that equipment should be cleaned/flushed during the course of application, the frequency of which will depend on the volume of material used and timescale over which applied. Ensure all waste materials (including packaging) are disposed of in accordance with local regulations.

HEALTH, SAFETY & ENVIRONMENTAL

This product must be used in accordance with the Material Safety Data Sheet supplied by Spencer Coatings Limited. The user must observe local health, safety and environmental regulations when using this product. Consult Spencer Coatings Limited if there are any concerns over the suitability of this product.

PACK SIZES

5 litre composite packs.

PACK WEIGHTS

5 litre : 6.5 kg.

STORAGE CONDITIONS

Store in a cool, dry, shaded area. Minimum shelf life 12 months in unopened containers.

LIMITATIONS

Do not apply this product if the RH exceeds 90% or if the substrate is within 3°C of the dew point.

DISCLAIMER

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It is the user's responsibility to ensure that this sheet is current prior to using the product.