

Description	Two components surface tolerant high solids polyamine cured modified epoxy primer / coating
Principal Characteristics	<p>Self priming surface tolerant to lower grades of steel preparation for atmospheric exposure Particularly well suited as maintenance coating for steel structures Excellent corrosion resistance Good flexibility and abrasion resistance Resistance to splash of a wide range of chemicals Compatible with various aged coatings Good recoat ability with epoxy-, polyurethane - and most chlorinated rubber-, alkyd-and acrylic paints When exposed to sunlight some discoloration may occur Good curing at temperature down to -5°C</p>
Recommended use	Special for maintenance coating with the minimum surface preparation when blasting are not permitted because of structure, health and safety reason
Specification data at 20 °C	
Gloss	Semi gloss
Colour	Red brown, Light Grey
Specific gravity	1.50 ± 0.15 [g/mL]
Solids by volume	82 ± 2 %
Recommended	<p>Dry film thickness : 75-150 micron (depends on system and application method) Wet film thickness : 91.5-182.9 micron</p>
Coverage theoretical	10.9 m ² / litre - 75 micron; 5.46 m ² / litre - 150 micron
Drying time	<p>Touch dry : 4 Hours at 30 °C Hard dry : 20 Hours</p>
Potlife	6 Hours (after mixing components)
Full cure	7 days
Flash Point (DIN 53213)	Base = 50 °C, Hardener = 35 °C
Painting interval	<p>Min : 12 hours Max : 7 days at 30 °C</p>
VOC	200 g/litre (base), 336 g/litre (hardener)
Service Temperature	<p>Continue : 100°C Periodic up to : 120°C</p>
Shelf Life	12 months (cool and dry place)

Surface Preparation

Substrate	Recommended
New Steel	ISO Sa2 ½
The surface to be painted	Must be clean, free from rust, oil grease or other foreign matter using wash, detergent, or solvent wipe.

Suitable top coat : SIMATHANE GLOSS

Application instruction

Condition	Recommended		
Temperatur	Min -5°C, max 50°C		
Relative humidity	Max 85 %		
Substrate temperature	should be at least 3°C above dew point.		
Mixing ratio	Base : Hardener = 4 : 1 [byvolume] temperature of the mixture should be above 15°C		
Thinner	Sima Thinner 44-00 should be added after mixing the components, and stir well before use preferable by means of mechanical mixer. Too much solvent result in lower sag resistance and slower cure.		
Method of application 1. Airless spray 2. Air Spray 3. Brush	Thinner	Nozzle Orifice	Nozzle Pressure
	Max 10 %	0.48-0.53 mm	15 Mpa (150 Bar / 2100 psi)
	10-15%	1.8 - 2.0 mm	0.3-0.4Mpa(3-4Bar;43- 7psi)
	0 - 5 %	-	-

Over coating table for most epoxy and polyurethane paints

Substrate Temperature	5°C	10°C	20°C	32°C	40°C
Min. interval	48 hours	24 hours	16 hours	8 hours	6 hours
Max. interval	9 months	9 months	4 months	2 months	1 month
Surface should be dry and free from any contamination * For polyurethane paint the minimum over coating time should be raised by 50%					

Over coating table for chlorinated rubber-, vinyl-, and alkyd paints :

Substrate Temperature	5°C	10°C	20°C	32°C	40°C
Min. interval	48 hours	24 hours	16 hours	8 hours	6 hours
Max. interval	21 days	21 days	10 days	7 days	7 days

- Surface should be dry and free from any contamination
- Best intercoat adhesion occurs when the subsequent coat is applied before the preceding coat is fully cured
- If this time is exceeded it may be necessary to roughen the surface

Curing table at 125 microns for SIMACOVER EP UNICOAT :

Substrate temperature	5°C	10°C	15°C	20°C	32°C	40°C
Touch dry	15 hours	10 hours	8 hours	6 hours	4 hours	2 hours
Dry to handle	48 hours	24 hours	20 hours	16 hours	8 hours	5 hours
Full cure	25 days	15 days	10 days	7 days	4 days	2 days

Packing and size instruction

Packing size (two packs product) : 5 and 20 litres

Storage

The product must be storage in accordance with national regulation. Preferred storage condition are to keep the containers in the dry space provided with adequate ventilation. The containers should be sealed tightly.

Safety Precaution

Wear suitable protective clothing such as overalls, goggles, dust mask and gloves. Ventilation shall be maintained from coating application until the completion of curing in order to remove residue of solvents and promote curing. Do not breathe the vapour or spray. This product is flammable. Keep away from sources of ignition. Do not smoke.

HEALTH AND SAFETY: For detailed information on the health and safety hazards and precaution for use of this product, please see the SAFETY DATA SHEET (SDS).

The information in this data sheet is to the best our knowledge connects at date printing. The company reserves the right to the modify data without notice. Any change in data will normally be followed by issued of new data sheet. The user should check the data of printing and if more than 12 months have elapsed, then the data should on only be used after checking with our nearest self-office to establish that they are still valid. Since condition of application and services may be beyond our control, no liability can accept on basis of this data.