



Reference	E85
Description	Two-component fast curing high-solids epoxy primer based on zinc phosphate.
Recommended use	<p>Thixotropic primer to protect steel structures against corrosion in an aggressive environment. Good resistance against water, oils and light chemicals.</p> <p>Ultra-quick drying at low temperatures (in comparison with polyamide hardeners)</p> <p>Can be applied in high film thicknesses.</p> <p>APECOAT PRIMER HS E85 is used as a primer in high-quality epoxy polyurethane systems, with good performance on substrates that are not that well prepared.</p> <p>NOTE: Epoxy paints that are exposed to weathering will chalk and can change colour. The discoloration can already take place during construction.</p>
Composition	Epoxy - special polyamide - zinc phosphate
Support	Steel, hot-dip galvanisation and metallisation after suitable surface preparation
Colour	Limited range of colours

TECHNICAL INFORMATION AT 20°C AND 60% RH

Density ± 1.60 kg/l

Drying time Drying time (80 µ dry)

Dust free	Tack free	Recoatable with epoxy coatings	Recoatable with polyurethane coatings (*)	
		Minimum	Minimum	Maximum
1-2 hours	3 hours	6 hours	12 hours	3 months

(*) free of impurities and chalking

Mixing ration By volume: 16/4

Dry volume weight ± 70%

Theoretical coverage For 100µ dry: 7.0 m²/liter

VOC <310 g/liter

The values in this technical data sheet are typical values and can differ from batch to batch.

RECOMMENDED USE

Recommended thickness	Application method	Roller	Brush	Airless
	Dry (μ)	60-80	60-100	80-200
Thinner	Thinner 118 / 31-67	Roller	Brush	Airless
	%	0-3	0-3	0-5
Cleaner	Thinner 118 / 31-67			
Temperature substrate	+3°C above dew point			
Relative humidity and temperature	Maximum 85% RH Minimum +5°C			
Processing time	2 hours			

SUBSTRATE

Preparation	Steel
	Remove any grease and contaminants, grit blast to Sa 2.5 and remove dust from the substrate. Can also be applied on a suitable primer. On manually prepared substrates to St ₃ , apply the first coat with a brush to obtain good penetration of the paint.
	Old, sound, well-adhering paints
	Remove contaminants, degrease and sand the surface. Remove any rust to St ₃ . Always test compatibility of the old paint with the subsequent coat.
	Hot-dip galvanization
	Degrease if necessary and remove impurities and zinc salts. Light sweep blasting with a non-metallic medium until mat surface.
	Dependant on the steel type and the dimensions of the structure, the layer thickness of the galvanisation can increase. Pores can thus form in the zinc layer. These can be difficult to seal with paint afterwards. It is therefore always advisable to spray a representative test piece with the complete paint system in order to validate the substrate.
	Metallisation
	The pores of the metallization are filled by means of a mistcoat. This is a diluted coat of paint that is applied immediately after metallization. As a rule, the Apecoat MIO HS E96 is diluted with \pm 40 volume percent thinner. The mistcoat is applied to full saturation of the surface by means of different cross layers with about 10 minutes in between. The paint penetrates the metallization and the layer thickness of this layer is not counted. Depending on the method of metallization and layer thickness, the porosity can vary greatly, so that the amount of mistcoat has to be adjusted. It is therefore always advisable to spray a representative test piece with the complete paint system in order to validate the substrate.
Maximum dry temperature	100°C

SYSTEM: EXAMPLE

1 ^e coat	Apecoat Primer HS E85	120 μ
2 ^e coat	Apecoat MIO HS E95	120 μ
3 ^e coat	Acrydur HB Finish A39	80 μ

SAFETY DATE

Flash point °C	Between 21°C and 55°C
Packaging	20 liter (16 liter base + 4 liter hardener)

See MSDS for further information.

SHELF LIFE

Shelf life	24 months in original and sealed containers in a dry, covered storage space – temperature between 5 and 35 °C.
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