



<b>Reference</b>	E86
<b>Description</b>	Two-component high-solids epoxy primer based on zinc phosphate.
<b>Recommended use</b>	<p>Thixotropic primer to protect steel structures against corrosion in an aggressive environment. Good resistance against water, oils and light chemicals. Can be applied in high film thicknesses.</p> <p>APECOAT PRIMER HS E86 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>
<b>Composition</b>	Epoxy - special polyamide - zinc phosphate
<b>Support</b>	Steel, hot-dip galvanisation treated with a suitable primer
<b>Colour</b>	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
1-2 hours	4 hours	6 hours	12 hours

**Mixing ration** By volume: 83/17

**Dry volume weight** ± 70%

**Theoretical coverage** For 100µ dry: 7.0 m<sup>2</sup>/liter

**VOC** < 290 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	Roller	Brush	Airless
	%	0-3	0-3	0-5
Cleaner	Thinner 118			
Temperature substrate	+3°C above dew point			
Relative humidity and temperature	Maximum 85% RH Minimum +5°C			
Processing time	4 hours			

## SUBSTRATE

Preparation	<b>Steel</b>
	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 St3, apply the first coat with a brush to obtain good penetration of the paint.
	<b>Hot dip galvanisation</b>
	Remove zinc Salts with hard brush and water followed by light sweep blasting with a non-metallic medium until mat surface.
Maximum dry temperature	<b>Old, sound, well-adhering paints</b>
	Remove contaminants, degrease and sand the surface. Remove any rust to St3. Always test compatibility of the old paint with the subsequent coat.
	100°C

## SYSTEM: EXAMPLE

1 <sup>e</sup> coat	Apecoat Primer HS E86	120 μ
2 <sup>e</sup> coat	Apecoat MIO HS E96	120 μ
3 <sup>e</sup> 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

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**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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Please ensure that you have the latest version of the Technical data sheet.

**Date:** 03/01/2018

**Edition:** E86.01.EN