



TRIMITZPOX PRIMER 471

Epoxy Primer

Product Description	Polyamide cured inhibitive epoxy primer.	
Recommended Use	Epoxy primer with recommended epoxy topcoat for the protection of steel in aggressive industrial and marine environments such as structural steel, tank exterior, bridges, chemical plants, food processing installations.	
Characteristics	<ul style="list-style-type: none"> • Pigmented with zinc phosphate, free of lead and chrome pigment. • Tough epoxy film reduces cost of site touch-up by minimizing handling and erection damage. • Fast drying, may be topcoated in 3 hours at 25°C. • Good abrasion resistance which minimises mechanical damage. • Resists weathering without a topcoat for extended period (6 months maximum). • Ideal as a shopprimer. 	
Physical Data	Colour Gloss Level Volume Solid Dry Film Thickness Number of Coat Theoretical Coverage Temperature Resistance VOC Flash Point Shelf Life Pack Size	White and Red Flat Approx. 49% 50 microns per coat 1 9.80 sq.m/ltr for 50 microns Continuous : 85°C (dry) Intermittent : 123°C (dry) 422 g/ltr Base : 47°C Hardener : 28°C At least 12 months 5 litres unit : Base : 4 litres , Hardener : 1 litre 20 litres unit : Base : 16 litres , Hardener : 4 litres
Surface Preparation	Dry abrasive blast in accordance with ISO - Sa 2.5 or SSPC - SP 10 "Near White". Blast to achieve an anchor profile of 25 - 50 microns as determined with a Keane Tator Surface Profile Comparator. Remove abrasive residue or dust from surface.	
Application Data	Application Methods Airless Spray Nozzle Tip Nozzle Pressure Conventional Spray Nozzle Tip Nozzle Pressure Mixing Ratio By Volume Thinner Cleaner Surface Temperature	0.46 - 0.58 mm (0.018 - 0.023 inch) 10 MPa (approx. 1400 psi) 1.8 - 2.0 mm (0.071 - 0.079 inch) 0.3 MPa (approx. 43 psi) Base : Hardener = 4 : 1 Thinner Trimitz 920 Thinner Trimitz 930 Should be 10°C - 49°C, at least 3°C above the dew point to prevent condensation

**TRIMITZPOX PRIMER 471****Epoxy Primer****Drying Time**

Touch Dry	2 hours at 25°C, 1 hour at 32°C
Through Dry	4 hours at 25°C, 2 hours at 32°C
To Topcoat	
Minimum	4 hours at 25°C, 2 hours at 32°C
Maximum	6 months (roughened and dry)
Full Cure	7 days

Pot Life 8 hours at 25°C, 4 hours at 32°C

System Compatibility**Topcoat**

- TrimitzpoX 485
- TrimitzpoX 483
- TrimitzpoX finish 466
- Trimitzthane 580

For other suitable intermediates or topcoats, please consult Trimitz Protective Coating.

Safety Precaution

Keep away from heat, spark and open flames. Avoid breathing of vapour on skin and eye contact. Keep container closed and store in cool, ventilated area when not in use.

Proper ventilation and protective measures must be provided during mixing, application and drying, to keep vapour concentration within safe limits and to protect against toxic hazard.

Necessary safety equipment must be used and ventilation requirements carefully observed, especially in confined or enclosed spaces, such as tank interior and building.

Disclaimer

The information in this product data sheet is given to the best of our knowledge based on laboratory testing and practical experience. If the product is used under condition beyond our control, we cannot guarantee anything but the quality of the products it self. The information in this product data sheet is liable for modification from time to time in the light of experience and our policy of continuous product development, and without further notice.
