

## 2-component, anticorrosive epoxy primer

### Description

EPOXYCOAT-AC is a 2-component, colored epoxy system with solvents, offering high strength and abrasion resistance. It is highly resistant to organic and anorganic acids, alkalis, petroleum products, solvents, water, sea water etc. It offers excellent protection against corrosion of metal surfaces.

It is classified as a product for reinforcement corrosion protection according to EN 1504-7. Certificate Nr. 2032-CPR-10.11.

### Fields of application

EPOXYCOAT-AC is used as an active anti-corrosive & anti-rust coating on iron and steel surfaces, especially on surfaces that are going to be coated with the epoxy resins EPOXYCOAT-W, EPOXYCOAT-VSF, EPOXYCOAT and EPOXYCOAT-S. It may also be used solely as a final coating, if its redbrown or grey color is satisfying. Application examples include protection of silos, steel bridges, fences, iron roofs, pipes, reinforcement bars etc.

### Technical data

|                                |   |
|--------------------------------|---|
| Basis:                         | 2-component epoxy resin   |
| Colors:                        | RAL 3009 (redbrown)<br>RAL 7040 (grey)<br>other colors upon order |
| Viscosity:                     | 350 mPa·s at +23°C  |
| Density (A+B):                 | 1,40 kg/lit   |
| Mixing proportion (A:B):       | 100:13,5 by weight  |
| Pot life:                      | approx. 2,5 h at +20°C  |
| Minimum hardening temperature: | +8°C  |
| Walkability:                   | after 24 h at +23°C   |

Successive layer: after 3-24 h at +23°C

Final strength: after 7 days at +23°C

Adhesive strength: > 3 N/mm<sup>2</sup> (breaking point of concrete)

Shear adhesion (coated steel to concrete): Pass\*<sup>1</sup> (EN 15184)

Corrosion protection: Pass (EN 15183)

Glass transition temperature: ≥ 68 °C (EN 12614)

\*<sup>1</sup>: The test is considered to have been passed if the bond stress determined with the coated bars is in each case at least 80% of the reference bond stress determined for the uncoated bars.

\*<sup>2</sup>: The test is considered to have been passed if the coated zones of the steels are free of corrosion and if rust creep at the ground plate edge <1 mm.

Cleaning of tools:  
Tools should be cleaned with SM-25 solvent immediately after use.

### Directions for use

#### 1. Substrate

The surface to be coated should be:

- Dry and stable.
- Free of materials that prevent bonding, e.g. dust, loose particles, grease etc.
- Free of rust or any corrosion that may prevent bonding.

According to the nature of the substrate, it should be prepared by brushing, grinding, sand blasting, etc. Following this, the surface should be cleaned from dust.

## 2. Mixing of the components

Components A (resin) and B (hardener) are packed in two separate containers, having the correct predetermined mixing proportion by weight. The whole quantity of component B is added into component A. Mixing of the 2 components should take place for about 5 minutes, using a low revolution mixer (300 rpm). It is important to stir the mixture thoroughly near the sides and bottom of the container, to succeed uniform dispersion of the hardener.

## 3. Application - Consumption

### a) As a primer

EPOXYCOAT-AC is applied by roller, brush or spray in two layers. The second layer follows after the first has dried, but within 24 hours.

Consumption: 150-200 g/m<sup>2</sup>/layer.

Painting with EPOXYCOAT-W, EPOXYCOAT-VSF, EPOXYCOAT or EPOXYCOAT-S epoxy coatings should follow within the next 24 hours.

### b) As a paint

EPOXYCOAT-AC is applied by roller, brush or spray in 3 - 4 layers. Every next layer follows after drying of the previous one, but within 24 hours.

Consumption: 150-200 g/m<sup>2</sup>/layer.

## Packaging

EPOXYCOAT-AC is supplied in packages (A+B) of 3 kg and 8 kg, with components A and B having the fixed weight proportion.

## Shelf-life - Storage

12 months from date of production if stored in original sealed packaging, in areas protected from humidity and direct sun exposure. Recommended storage temperature between +5°C and +35°C.

## Remarks

- The workability of epoxy materials is affected by their temperature. The ideal temperature of application is between +15°C and +25°C so that the product will be easy to use and cure as prescribed. Room temperature below +15°C will expand the curing time and temperature above +30°C will accelerate the curing time. In winter time a mild preheating of the product is recommended, while in summer time to store the materials in a cool room before the application.
- EPOXYCOAT-AC contains solvents. In cases of application in closed rooms, measures should be taken for good ventilation.
- Bonding between successive layers may be severely affected by the intervention moisture or dirt between them.
- Epoxy layers should be protected from moisture for 4-6 hours after application. Moisture may whiten the surface or/and make it sticky. It may also disturb hardening. Faded or sticky layers in parts of the surface should be removed by grinding or milling and laid again.
- In case that longer time than predicted interferes between the application of successive layers or in case that old floors are going to be laid again, the surface should be thoroughly cleaned and ground before application of the new layer.
- After hardening, EPOXYCOAT-AC is totally safe for health.
- Before application, study the safety advice mentioned on the product's labels.

# EPOXYCOAT-AC



## Volatile organic compounds (VOCs)

According to the Directive 2004/42/CE (Annex II, table A), the maximum allowed VOC content for the product subcategory j, type SB is 500g/l (2010) for the ready to use product.

The ready to use product EPOXYCOAT-AC contains max 450 g/l VOC.



2032

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2032-CPR-10.11

DoP No.: EPOXYCOAT-AC/1834-01

EN 1504-7

Reinforcement corrosion protection product for  
uses other than low performance requirements

Shear adhesion: Pass

Corrosion protection: Pass

Glass transition temperature:  $\geq 68$  °C

Dangerous substances: comply with 5.4

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