



Product description.

A high solids epoxy primer/coating formulated with Navimar binder technology. Navibond 467 has excellent anticorrosive properties and good impact- and abrasion resistance. Good adhesion to St3 prepared steel substrates and compatible with most aged coatings.

Physical properties.

Colour/Texture	Red brown and Grey/Semi-gloss
Volume Solids	81%
Specific gravity	1.41 gr/ml
VOC	168 gr/liter
Flashpoint	>25°C

	Dry film thickness per coat (μ)	Wet film thickness per coat (μ)	Theoretical spreading rate (m ² /l)
Range	100 – 250	125 – 310	8.1 – 3.2
Recommended	150	185	5.4

Application data.

Mixing ratio
By weight, base to hardener: 10 to 1.
By volume, base to hardener: 7 to 1.

Potlife
10°C: 3 hours, 23°C: 2 hours, 30°C: 1 hour.

Guiding data Airless spray
Pressure at nozzle: 180 – 250 bar. Nozzle size: 0.41 - 0.58 mm.
Spray angle: 40 - 80 degrees.
Volume of thinner: 0 - 5%.

Brush
Suitable but airless spray is recommended. Multicoats are required to achieve the specified dry film thickness.
Volume of thinner: 0 - 10%.

Thinner/Cleaner
Navimar Epoxy Thinner T-10

Conditions
Humidity: below 85% RH.
Temperature of the paint before application: min: 10°C, max: 30°C.
Substrate temperature: min: 10°C, max: 35°C.
The temperature of the substrate should be at least 3°C above the dew point of the air. Air temperatures and relative humidity must be measured in the vicinity of the substrate.

Drying and recoating times.

Substrate temperature	Touch dry	Dry to handle	Full cure	Dry to recoat (1)		
				Minimum	Maximum with 1-pack.	Maximum with 2-pack
10 °C	6 hours	24 hours	8 days	18 hours	15 days	Indefinite
23 °C	3 hours	20 hours	5 days	15 hours	10 days	Indefinite
30 °C	1 hour	16 hours	3 days	12 hours	10 days	Indefinite

(1) The surface should be dry and free from contaminants prior to overcoating. The best intercoat adhesion is achieved when the subsequent coat is applied before the preceding coat is fully cured. After prolonged exposure it may be necessary to roughen the surface to ensure intercoat adhesion. When in doubt, consult your nearest Navimar office.

Surface preparation.

Steel	Oil and grease should be removed by solvent cleaning according to SSPC-SP1. Remove weld spatter and smooth weld seams and sharp edges as applicable. Abrasive blasting: min. Sa2 – ISO 8501:1. Power tool cleaning: min. ISO-St3. Please note that better surface preparation always results in longer lifetime expectations. Apply Navibond 467 immediately after the steel has been blasted and the quality of preparation has been approved.
Repair	Existing systems should be roughened and dry and free from loose paint, salt, grease and other contaminants prior to overcoating. Corroded and/or damaged areas should be power tool cleaned to ISO-St2 or better or blast cleaned to ISO-Sa2.

Recommended paint system.

A typical system for atmospheric exposure is shown below.

Navibond 467 2 x 150 µ dft.

The coating can be left uncoated but may be recoated with NAVIPOX-, NAVIPOL-, NAVICRYL- or NAVILAC Finishes.

Health and safety.

Observe the precautionary notices on the label of the container. A material safety data sheet is available upon request and national or local safety regulations should be followed. This product is intended for use by professional applicators.

As a general rule, avoid skin- and eye contact by wearing overalls, gloves, goggles, mask, etc. Spillage on the skin should immediately be removed by thorough washing with lukewarm water and soap or a suitable industrial cleaner. Eyes should be flushed with fresh water and medical attention sought immediately.

Spraying should be carried out under well-ventilated conditions. Avoid inhalation of solvent vapours and paint mist by wearing an air mask.

This product contains flammable materials and should be kept away from sparks and open flames.

Smoking in the area should not be permitted.

Disclaimer

The information in this data sheet is provided to the best of our knowledge. However, we have no control over either quality or condition of the substrate and other factors affecting the use and application of this product.

Therefore, we cannot accept any liability whatsoever or howsoever arising from the performance of the product or for any loss or damage arising from the use of this product.

We reserve the right to change the product without notice.