

Product description.

Navimare Epoxy Primer is a two-pack primer especially designed for metal substrates. The primer can also be used on hydrojetted steel substrates. This very versatile primer can be used below and above the waterline and can be recoated with various Navimare products.

Technical properties.

Colour/Texture	Green yellow/ Mat
Volume Solids	51%
Specific gravity	1.3 gr/ml
Volatile organic compounds	424 gr/liter
Flashpoint	>25°C

Surface Preparation

GRP – Ensure surface is dry and free from traces of wax, lubricants and other contaminants. Treat if required with Navimare Gelclean.

Non-ferrous metals – Treat surface with Gel clean followed by light blast cleaning with a fine grade, inert abrasive or by using suitable power tools such as disc sanders.

Steel - Oil and grease should be removed by solvent cleaning or by using Gelclean. Remove weld spatter and smooth weld seams and sharp edges as applicable. Abrasive blasting: min. Sa 2,5 – ISO 8501:1. Apply Navimare Epoxy Primer 7116 immediately after the steel has been blasted. Alternatively, the steel could be prepared by Ultra High Pressure Waterjetting to DW 2-3 (STG standard 2222)

Wood – Ensure surface is dry. Sand and remove the remaining dust with dry rags or rags slightly dampened with water (not solvent).

Usage instructions

Substrate should be dry and free from contaminations.

Relative Humidity should be less than 90 %RH.

Mix pack A and pack B well, preferably by means of a mechanical stirrer. Do not mix more paint than can be used in 1 hour.

Thin if necessary with 0- 5% of the specified thinner. Mix well.

When applied by brush or roller, apply in smooth and gentle strokes. Apply crosswise to ensure an even distribution of the paint.

When applied by airless or airspray observe spraying recommendations mentioned on the next page. Avoid excessive application as it will result in sagging and a poor appearance.

Whether applying by brush, roller or spray, wear protective clothing, goggles and gloves. Refrain from smoking at all times. For further information refer to label instruction or safety data sheet please.

Application data.

Mixing ratio by weight	Base to hardener: 82 to 18
Mixing ratio by volume	Base to hardener: 75 to 25
Potlife	6 hours at 23° C
Dry film thickness per coat	50 micron
Wet film thickness per coat	100 micron
Thinner	Navimare Thinner 76.03
Surface Temperature	Minimum 10°C Maximum 40°C

Spray equipment data.

	Conventional spray	Airless spray
Nozzle orifice	1.2 – 2.0 mm	0.38 – 0.53 mm
Air pressure	3 – 5 bar	180 – 300 bar
Volume of thinner	0 – 15%	0 – 3 %
Practical Spreading rate (m ² /l)	5.5	7.0

Drying and recoating times.

Substrate temperature	Dry to recoat	Fully cured	Maximum recoating (1)
10 °C	8 hours	8 days	Indefinite
23 °C	4 hours	5 days	Indefinite
30 °C	2 hours	3 days	Indefinite

(1) The surface should be dry and free from salts and other 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 times it may be necessary to roughen the surface in order to ensure intercoat adhesion. When in doubt, consult your nearest Navimare office.

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. 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.

Date of issue: July, 26.