Jotafix Epoxy Primer

Product description

This is a two component amine cured epoxy mastic coating. It is a surface tolerant primer designed for application with brush and roller. Specially designed for areas where optimum surface preparation is not possible or required. Provides protection in environments with high corrosivity. Can be used as primer, mid coat, finish coat or as single coat system in marine atmospheric environments. Suitable for properly prepared carbon steel, galvanised steel, stainless steel and a range of aged coating surfaces. It can be applied at sub zero surface temperatures.

Typical use

General:
Primarily designed for smaller maintenance and repair jobs.

Marine:
Outside hulls, exterior and interior areas.

Approvals and certificates

Grain, Newcastle Occupational Health

When used as part of an approved scheme, this material has the following certification:
- Low Flame Spread in accordance with EU Directive for Marine Equipment. Approved in accordance with parts 5 and 2 of Annex 1 of IMO 2010 FTP Code, or Parts 5 and 2 of Annex 1 of IMO FTPC when in compliance with IMO 2010 FTP Code Ch. 8

Additional certificates and approvals may be available on request.

Colours

grey, red

Product data

Property	Test/Standard	Description
Solids by volume	ISO 3233	68 ± 2 %
Gloss level (GU 60 °)	ISO 2813	semi gloss (35-70)
Flash point	ISO 3679 Method 1	31 °C
Density	calculated	1.5 kg/l
VOC-US/Hong Kong	US EPA method 24 (tested) (CARB(SCM)2007, SCAQMD rule 1113, Hong Kong)	275 g/l
VOC-EU	IED (2010/75/EU) (theoretical)	255 g/l
VOC-China	GB/T 23985-2009 (tested)	254 g/l
VOC-Korea	Korea Clean Air Conservation Act (tested) (Max. thinning ratio included)	312 g/l

This Technical Data Sheet supersedes those previously issued.
The Technical Data Sheet (TDS) is recommended to be read in conjunction with the Safety Data Sheet (SDS) and the Application Guide (AG) for this product. For your nearest local Jotun office, please visit our website at www.jotun.com

The provided data is typical for factory produced products, subject to slight variation depending on colour.

Gloss description: According to Jotun Performance Coatings' definition.

Film thickness per coat

Typical recommended specification range

Dry film thickness	50	-	100	µm
Wet film thickness	75	-	150	µm
Theoretical spreading rate	13.6	-	6.8	m²/l

Surface preparation

Surface preparation summary table

Substrate	Surface preparation	
	Minimum	**Recommended**
Carbon steel	St 2 (ISO 8501-1)	Sa 2 (ISO 8501-1)
Stainless steel	The surface shall be hand or machine abraded with non-metallic abrasives or bonded fibre machine or hand abrasive pads to impart a scratch pattern to the surface.	Abrasive blast cleaning to achieve a surface profile using non-metallic abrasive media which is suitable to achieve a sharp and angular surface profile.
Galvanised steel	The surface shall be clean, dry and appear with a rough and dull profile.	Sweep blast-cleaning using non-metallic abrasive leaving a clean, rough and even pattern.
Shop primed steel	Clean, dry and undamaged shop primer (ISO 12944-4 5.4)	Sa 2 (ISO 8501-1)
Coated surfaces	Clean, dry and undamaged compatible coating	Clean, dry and undamaged compatible coating

Application

Application methods

The product can be applied by

Spray:	Use airless spray.
Brush:	Use a round brush. Care must be taken to achieve the spreading rate.
Roller:	Use of a foam roller will provide the best finish results.

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Product mixing ratio (by volume)

Jotafix Epoxy Primer Comp A	5 part(s)
Jotafix Epoxy Primer Comp B	1 part(s)

Thinner/Cleaning solvent

Thinner: Jotun Thinner No. 17

Guiding data for airless spray

Nozzle tip (inch/1000):	17 - 23
Pressure at nozzle (minimum):	150 bar / 2100 psi

Drying and Curing time

Substrate temperature	-5 °C	0 °C	5 °C	10 °C	23 °C	40 °C
Surface (touch) dry	25 h	15 h	8 h	5 h	2.5 h	45 min
Walk-on-dry	48 h	40 h	20 h	12 h	6 h	2 h
Dry to over coat, minimum	40 h	30 h	15 h	8 h	4 h	1.5 h

For maximum overcoating intervals, refer to the Application Guide (AG) for this product.

Drying and curing times are determined under controlled temperatures and relative humidity below 85 %, and at average of the DFT range for the product.

Surface (touch) dry: The state of drying when slight pressure with a finger does not leave an imprint or reveal tackiness.

Walk-on-dry: Minimum time before the coating can tolerate normal foot traffic without permanent marks, imprints or other physical damage.

Dry to over coat, minimum: The recommended shortest time before the next coat can be applied.

Induction time and Pot life

Paint temperature	23 °C
Pot life	2 h

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Packaging (typical)

	Volume (litres)	Size of containers (litres)
Jotafix Epoxy Primer Comp A	15	20
Jotafix Epoxy Primer Comp B	3	3

The volume stated is for factory made colours. Note that local variants in pack size and filled volumes can vary due to local regulations.

Storage

The product must be stored in accordance with national regulations. Keep the containers in a dry, cool, well ventilated space and away from sources of heat and ignition. Containers must be kept tightly closed. Handle with care.

Shelf life at 23 °C

Jotafix Epoxy Primer Comp A	24 month(s)
Jotafix Epoxy Primer Comp B	24 month(s)

In some markets commercial shelf life can be dictated shorter by local legislation. The above is minimum shelf life, thereafter the paint quality is subject to re-inspection.

Caution

This product is for professional use only. The applicators and operators shall be trained, experienced and have the capability and equipment to mix/stir and apply the coatings correctly and according to Jotun's technical documentation. Applicators and operators shall use appropriate personal protection equipment when using this product. This guideline is given based on the current knowledge of the product. Any suggested deviation to suit the site conditions shall be forwarded to the responsible Jotun representative for approval before commencing the work.

Health and safety

Please observe the precautionary notices displayed on the container. Use under well ventilated conditions. Do not inhale spray mist. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water and medical attention sought immediately.

Colour variation

When applicable, products primarily meant for use as primers or antifoulings may have slight colour variations from batch to batch. Such products and epoxy based products used as a finish coat may chalk when exposed to sunlight and weathering.

Colour and gloss retention on topcoats/finish coats may vary depending on type of colour, exposure environment such as temperature, UV intensity etc., application quality and generic type of paint. Contact your local Jotun office for further information.

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Disclaimer

The information in this document is given to the best of Jotun's knowledge, based on laboratory testing and practical experience. Jotun's products are considered as semi-finished goods and as such, products are often used under conditions beyond Jotun's control. Jotun cannot guarantee anything but the quality of the product itself. Minor product variations may be implemented in order to comply with local requirements. Jotun reserves the right to change the given data without further notice.

Users should always consult Jotun for specific guidance on the general suitability of this product for their needs and specific application practices.

If there is any inconsistency between different language issues of this document, the English (United Kingdom) version will prevail.

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