

Technical Data Sheet



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Data sheet Nr. EA9000

AVKOTE 2250 Primer

| | | |
|-----------------------------|---|--|
| Product description | Two component primer and intermediate primer | |
| Binding Agent | Epoxy resin | |
| Areas of Application | Primer and intermediate primer. Adhesion primer for a variety of substrates including a wide range of metal surfaces. | |
| Form of Supply | Colours | White |
| | Gloss Level | Silk Matt |
| Hardener | Avkote Hardener 2243 | |
| Packing | Coating | 1, 3 and 5 Litre disposable containers |
| | Hardener | 1 Litre disposable containers |

Technical Data


| | Coating | | Hardener | | Mixture | |
|---------------------------------|---|-------------------|----------------------------------|-------------------|---------|-------------------|
| Specific Gravity (23 °C) | 1.33 | g/cm ³ | 0.93 | g/cm ³ | 1.29 | g/cm ³ |
| Solids content | 65 | ± 2 Weight-% | 37 | ± 2 Weight-% | Appr 62 | Weight-% |
| Organic Solvent Content. | 35 | ± 2 Weight-% | 63 | ± 2 Weight-% | Appr 40 | Weight-% |
| VOC Content (CH / EU) | 47.1 | % | 471 | g/lt | 58.1 | % |
| | | | | | 581 | g/lt |
| | | | | | 48.2 | % |
| | | | | | 482 | g/lt |
| Shelf life at 20 °C | 12 Months | | 6 Months in well shut containers | | | |
| Theoretical Coverage | 106 g/m ² 9.4 m ² /kg for 35 µm dry layer thickness | | | | | |

| Safety Data | Coating | Hardener |
|-----------------------------------|---------------------|---------------------|
| Flash point | 14 °C | 4 °C |
| Transport ADR/RID | Class: 3 VP: III | Class: 3 VP: III |
| Poison classification (EU) | | |
| VVS disposal code (EU/CH) | 08, 08 01, 08 01 11 | 08, 08 01, 08 01 11 |




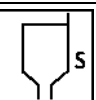
Application Recommendations









| Substrate | No. of Coats | Product | Dry Film thickness | Data sheet |
|--|---|---------------------------|--------------------|------------|
| Steel, Aluminium, etc. Exterior applications | 1 x Primer | Avkote 2250 Primer | 40 – 60 µm | EA9000 |
| | 1 x Top Coat Or or | Avkote BSP | 40 – 60 µm | 5398 |
| | | Avkote Universal | 40 – 60 µm | 5391 |
| | | Avkote ME | 30 – 50 µm | 5393/ME |
| Steel, Aluminium, etc. (chemically resistant) | 1 x Primer | Avkote 2250 Primer | 40 – 60 µm | EA9000 |
| | 1 x Top Coat | Avkote ME | 30 – 50 µm | 5393/ME |
| Rusted areas | 1 x Primer | Avkote 8048 Silver Primer | 80 – 100 µm | 8048 |
| | 1 x Primer | Avkote 2250 Primer | 40 – 60 µm | EA9000 |
| | 1 x Top Coat | Avkote ME | 30 – 50 µm | 5393/ME |
| Note | The use of this product is so multi sided, that all applications cannot be listed in this data sheet. | | | |
| | For further application proposals ask our technical department. | | | |

Preparation

| | | |
|--|--------------------|--|
|  | Substrate | Every substrate must be thoroughly cleaned, grease and oil-free, and dry before paint application commences. |
| | Steel | Sandblast or sand, clean |
| | Aluminium | Sand or use Scotchbrite (coarse), clean or chemically treat such as chromate, clean |
| | Aluminium Profiles | Sand well or use fine sandblast, clean. Or chemically treat such as chromate, clean. |
| | Zinc | Sand well or use fine sandblast, clean |
| | Old Coatings | Sand, clean |
| | Cement Substrate | Roughen the surface, clean |

Processing

| | | |
|---|------------------------------|--|
|  | Preventative measures | We recommend the wearing of protective clothing even if not stipulated by law. The national and regional health and safety regulations for work hygiene and equipment are to be observed. Pay attention to our safety data sheet Nos. EA9000 and EA90002243. |
|  | Stir | Before use ensure contents are stirred together well with hardener if applicable. |
|  | Mixing Ratio | 9 : 1 by volume with Avkote 2243 hardener |
| | Pot life at 20 °C | 8 hr |
|  | Thinners | Mix Thinners 3000 with Avkote 2250 Primer as shown in the table below to obtain application viscosity. |

| | | | | | | |
|--|-------------------------------|---|-----------------|---------------|-----------------|--------------------|
|  | brush | Unthinned, add 5-10% Thinners 3000 if necessary | | | | |
|  | Roll | Unthinned, add 5-10% Thinners 3000 if necessary | | | | |
| | | Viscosity DIN-4 | Thinners | Nozzle | Pressure | Spray coats |
|  | Gravity Feed Spray-gun | 18 - 22 secs | 20 - 25 % | 1.4 - 1.8 mm | 3 - 4 bar | 2 |
|  | Suction-spray-gun | 18 - 22 secs | 20 - 25 % | 1.4 - 1.8 mm | 3 - 4 bar | 2 |
|  | Airless-(Airmix)-Spray | 20 - 25 secs | 20 % | 0.6-0.9 | 3 – 4 bar | 1-2 |
|  | HVLP paint gun | 18 - 22 secs | 20 - 25 % | 1.4 - 1.8 mm | 3 - 4 bar | 2 |
|  | Evaporation time | Prior to drying at temperatures over 40 °C allow an evaporation time of 15 minutes. | | | | |
|  | Drying time | For 40 µm dry coating at 65 % of relative humidity | | | | |
| | At 20 °C | Tack-Dry | after: | 30 | Minutes | |
| | | Touch – Dry | after: | 30 | Minutes | |
| | | Dried (Can be sanded) | after: | 10 | Hours | |
| | | Suitable for re-coating | after: | 12 | Hours | |
| | | Completely Dry | after: | 10 | days | |
| | At 60 °C | Dry | after: | 2 | Hours | |

Important references

| | | | | | |
|--|---|----|--|--|--|
| Specific restrictions | Relative humidity max. 80 % | | | | |
| Minimum application- and drying temperature | 10 | °C | Do not apply at temperatures below the dew point | | |
| Coating removal | Sandblast or use Metro Fit Standard paint stripper | | | | |
| Equipment cleaning | Clean immediately after use with Gun Wash Thinners. | | | | |

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