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ViterBlast EV110 Epoxy Blast Primer

Product Description	**A two pack epoxy zinc phosphate holding primer** for the temporary protection of blast cleaned steelwork.
Features & Use	• Fast drying to ensure minimal stoppage for continual blasting operations • Lloyds Register welding approvals • Enables welding and fabrication when applied at the recommended dry film thickness • Can be overcoated with most generic groups (excluding zinc rich) • Where temporary protection is required prior to fabrication • Suitable for marine plate and structural steel • Application by automatic spray, airless spray and conventional spray
Approvals/ Certification	Please consult Spencer Coatings
Finish	Matt
Volume Solids	32 ± 2%
VOC Content	591 ± 20 g/litre

Film Thickness Range And Coverage

	Dry Film Thickness	Wet Film Thickness	Theoretical Coverage
Typical	20 µm	62 µm	16.0 m^2/litre

Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated

Drying Times

Applied to **20 microns** DFT		+10°C	+23°C	+35°C
Dust Free		8 min	3 min	2 min
Hard Dry		12 min	5 min	4 min
Overcoating	Minimum	16 hr	8 hr	4 hr
	Maximum	Depends on conditions – see Product Notes		

Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation

Colours	Red Oxide
Mix Ratio/ Product Code	Base **3339 001** 3 parts by volume Hardener **4050 051** 1 part by volume
Pot Life	12 hours at 23°C
SG	1.25-1.30 kg/lt mixed
Storage Conditions	Store in dry, cool conditions and protect from frost
Shelf Life	Minimum 12 months if stored as above in unopened containers
Flash Point	Below 23°C

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Surface Preparation	• All surfaces to be coated should be dry and cleaned as necessary to remove all oil, grease, salts, weld flux or other contamination. Where necessary, remove weld spatter and grind smooth all sharp edges and weld seams • Blast clean to Sa2½ (ISO 8501-1:2007), surface profile 50-75 microns
Mixing	Mix only in the proportions stated, mixing each component individually then together using a mechanical agitator. Agitate periodically during use to ensure product remains homogeneous.
Thinner	903 Thinner **Equipment Cleaner** 950 Thinner
Application Conditions	Only apply in conditions of good ventilation which must be maintained during drying and curing. Do not apply when rain, mist, sleet or snow are imminent. During application and drying time of the paint coating, the surface should be dry, the Relative Humidity should not exceed 85% and the steel temperature should remain at least 3ºC above the dew point. Only apply this product when the above conditions can be maintained throughout the critical application and drying/curing process. Paint temperature should ideally be at a minimum of 15ºC.
Application Methods	**Method** / **Airless Spray** / **Conventional Spray** / **Brush** / **Roller** Yes / Yes / Yes / Yes • Airless Spray: Output fluid pressure at tip 1500-2500 psi, Tip Size: 15-23 thou (0.38-0.58mm) • Can be applied by automatic airless spray – mix 3 parts EV110 to 1 part 903 Thinners • Brush and roller should only be used for touch-up of small areas as the product dries very quickly • Refer to Spencer '**Epoxy Application and Curing Notes'**
Product Notes	• This is a **low flash material** - ventilate to keep solvent vapour levels below minimum explosive limit and observe low flash regulations • Avoid excessive film thicknesses - solvents will flash-off too quickly to allow accurate measurement of wet film thickness to be taken • Product is very fast drying – ensure that a full continuous wet coat is applied. Care must be taken to prevent dry spray. May be thinned up to 5% to aid application if required • **Overcoating**: can be overcoated after extended periods if the surface of the coating is intact and clean, please consult Spencer Coatings for advice. Note that this is a thin-film coating intended to provide limited, short-term protection during fabrication
Health & Safety	Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Spencer Coatings.