

# ViterBond ST200 Epoxy ST Primer

<b>Product Description</b>	<b>A two pack epoxy, high solids, surface tolerant aluminium primer.</b>				
<b>Features &amp; Use</b>	<ul style="list-style-type: none"> <li>• Use as a rust inhibiting primer on hand prepared steel, or as a high build patch repair primer under most generic coating types</li> <li>• Approved to UK Network Rail specification as the primer of a 3 coat system applied to manually prepared steelwork</li> <li>• Excellent anticorrosive protection</li> <li>• Excellent 'wetting' properties for application to a manually prepared steel surface</li> <li>• Good chemical and solvent resistance</li> <li>• Use to upgrade a conventional system to high performance epoxy/polyurethane system</li> <li>• Use as a single coat system under insulation (see Product Notes)</li> <li>• Can overlap onto aged, sound chlorinated rubber, vinyl or alkyd products</li> </ul>				
<b>Approvals/ Certification</b>	UK Network Rail M24 (Item 7.1.5)				
<b>Finish</b>	Sheen				
<b>Volume Solids</b>	80 ± 2%				
<b>VOC Content</b>	182 ± 20 g/litre				
<b>Film Thickness Range And Coverage</b>		<b>Dry Film Thickness</b>	<b>Wet Film Thickness</b>	<b>Theoretical Coverage</b>	
	<b>Minimum</b>	125 µm	157 µm	6.4 m <sup>2</sup> /litre	
	<b>Maximum</b>	200 µm	250 µm	4.0 m <sup>2</sup> /litre	
Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated					
<b>Drying Times</b>	Applied to <b>125 microns</b> DFT		<b>+10°C</b>	<b>+23°C</b>	<b>+35°C</b>
	<b>Dust Free</b>		10 hr	4 hr	2 hr
	<b>Hard Dry</b>		24 hr	16 hr	8 hr
	<b>Overcoating*</b>	Minimum	See Product Notes		
		Maximum	Indefinite if clean and sound, with itself or ViterBond WG500		
* See Product Notes Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation					
<b>Colours</b>	Dark Aluminium				
<b>Mix Ratio/ Product Code</b>	Base	<b>3332 001</b>	1 part by volume		
	Hardener	<b>4056 006</b>	1 part by volume		
<b>Pot Life</b>	2 hours at 23°C				
<b>SG</b>	1.28 – 1.32 kg/lit mixed				
<b>Storage Conditions</b>	Store in dry, cool conditions and protect from frost				
<b>Shelf Life</b>	Minimum 12 months if stored as above in unopened containers				
<b>Flash Point</b>	23-60°C				

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<p><b>Surface Preparation</b></p>	<ul style="list-style-type: none"> <li>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</li> <li>Blast clean to Sa2½ (ISO 8501-1:2007), surface profile 50-75 microns</li> <li>Where blast cleaning is impractical the surface should be prepared to St2 (ISO 8501-1:2007) taking care to avoid 'polishing' the surface</li> <li>Can be used as a brush or spray applied primer when water abrasive blast cleaning. Allow to dry and lightly wire brush if powdery deposits form</li> </ul>										
<p><b>Mixing</b></p>	<p>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.</p>										
<p><b>Thinner</b></p>	<p>1031 Thinner <span style="float: right;"><b>Equipment Cleaner</b> 950 Thinner</span></p>										
<p><b>Application Conditions</b></p>	<p>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 3°C 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 15°C.</p>										
<p><b>Application Methods</b></p>	<table border="1" style="width: 100%; text-align: center;"> <thead> <tr> <th style="width: 30%;">Method</th> <th style="width: 15%;">Airless Spray</th> <th style="width: 15%;">Conventional Spray</th> <th style="width: 15%;">Brush</th> <th style="width: 15%;">Roller</th> </tr> </thead> <tbody> <tr> <td></td> <td>Yes</td> <td>No</td> <td>Yes</td> <td>No</td> </tr> </tbody> </table> <ul style="list-style-type: none"> <li>Airless Spray: Output fluid pressure at tip 2000-3000 psi, Tip Size: 19-27 thou (0.48-0.68mm).</li> <li>Apply by brush over manually prepared bare steel surfaces</li> <li>If applying by brush over blast cleaned steel, take care not to brush the coating off the peaks, or apply two brush coats for safety</li> <li>Refer to Spencer '<b>Epoxy Application and Curing Notes</b>'</li> </ul>	Method	Airless Spray	Conventional Spray	Brush	Roller		Yes	No	Yes	No
Method	Airless Spray	Conventional Spray	Brush	Roller							
	Yes	No	Yes	No							
<p><b>Product Notes</b></p>	<p><b>Overcoating</b></p> <ul style="list-style-type: none"> <li><b>With conventional, chlorinated rubber or vinyl:</b> ideally overcoat between 24-48 hours at 23°C. Maximum is 7 days or abrading is required</li> <li><b>With epoxy or two pack polyurethane:</b> min 24 hours, max 3 months, at 23°C</li> <li><b>With alkyds:</b> starting with ViterLac AM112 MIO is recommended for good intercoat adhesion. Min 24 hours, max 7 days, or abrading will be required</li> <li><b>With itself or ViterBond WG500:</b> whilst this product will not fully effectively cure below 10°C, overcoating by spray, with itself or ViterBond WG500, after 16 hours at 5°C minimum is acceptable</li> <li>Extend min/max drying and overcoating times at lower temperatures and for dft's above 125 microns</li> </ul> <p><b>Other</b></p> <ul style="list-style-type: none"> <li>Under insulation the product is suitable for dry operating temperatures up to 150°C with occasional surges to 200°C</li> <li>Do not apply or cure below 5°C. See ViterBond WG200 for low temperature applications</li> <li>Colour changes can occur in exposed conditions and will occur at elevated temperatures</li> <li>Moisture in the can may cause pressure build up</li> </ul>										
<p><b>Health &amp; Safety</b></p>	<p>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.</p>										

This information is given in good faith for the guidance of users but without warranty or liability. Any queries should be referred to our Technical Department. The above information, based on laboratory tests and practical experience has been proved valid at the date marked on the product data sheet. When necessary verify the validity of the product data sheet. The quality of the product is ensured by our operational system, based on the requirements of the standards ISO 9001. As a manufacturer we cannot be responsible for any damages caused by using the product against our instructions or for inappropriate purposes. This product is for professional use only.