Issue Date: Dec 2015
Reference: n/a
Page 1 of 2

ViterShield 178 HS Epoxy Primer/Finish

Product Description	**A two pack epoxy, high solids, zinc phosphate primer or primer/finish** for steelwork. High performance, low VOC coating to help meet SED requirements.
Features & Use	• Provides a high build single coat/two coat high performance system for steelwork • Exceptional sag resistance • Excellent cure speed and high build properties • Good resistance to undercutting from damaged areas • Overcoatable with most epoxy, acrylic or polyurethane coatings • Use as a base coat for most thin film intumescent coatings
Approvals/ Certification	Please consult Spencer Coatings
Finish	Matt
Volume Solids	70 ± 2% (varies with colour)
VOC Content	277 ± 20 g/litre (varies with colour)

Film Thickness Range And Coverage

	Dry Film Thickness	Wet Film Thickness	Theoretical Coverage
Minimum	75 µm	107 µm	9.3 m^2/litre
Maximum	280 µm	400 µm	2.5 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 **100 microns** DFT		**+10°C**	**+23°C**	**+35°C**
Dust Free		2 hr	1 hr	30 min
Hard Dry		6 hr	3 hr	1½ hr
Overcoating	Minimum*	6 hr	3 hr	1½ hr
	Maximum	Indefinite if clean and sound		

* 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, Grey, White and shades to order
Mix Ratio/ Product Code	Base **6178** 5 parts by volume Hardener **6400 003** 1 part by volume
Pot Life	3 hours at 23°C
SG	1.48 – 1.52 kg/lt mixed, varies with colour
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	23-60°C

ViterShield 178 HS Epoxy Primer/Finish

Surface Preparation	• Blast clean to Sa2½ (ISO 8501-1:2007), surface profile 50-75 microns • 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
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	1031 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	See table below • Airless Spray: Output fluid pressure at tip 2200 psi, Tip Size: 13 thou (0.33mm) for dft's 75-125um; 15-17 thou (0.38-0.43mm) for 125-280um. • Thinning of the coating will reduce the build qualities • Application by brush/roller will result in a reduced film thickness and is recommended only for small areas of touch up/remedial work • Refer to Spencer '**Epoxy Application and Curing Notes'**
Product Notes	**Overcoating** May be overcoated with itself or other products from the ViterShield, ViterSeal or ViterThane range If overcoating with ViterThane PLV or PLS, allow a minimum of 12 hours at 23ºC when the primer has been applied to 100 microns dft. Allow longer drying and overcoating times at higher dft's and lower temperatures The compatibility of overcoating should be confirmed prior to application **High Film Builds** Certain configurations of steelwork may mean that the primer will have to be applied in more than one coat to achieve the higher film thicknesses **Other** • Whilst this product will display a matt finish at a dry film thickness of 75 microns, application to a dry film thickness above 125 microns will provide a low sheen finish, the degree of which may vary • Do not apply or cure below 5ºC, temperatures above 10ºC recommended • Like all epoxy coatings, this product will chalk on prolonged exterior exposure, the degree of which is subject to atmospheric conditions
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.

Method	Airless Spray	Conventional Spray	Brush	Roller
	Yes	Yes	Yes	Yes