EPOXY PRIMER EP 211

Technical sheet no. 6

Editing **September 2022**

TYPE OF PRODUCT :

CORROSION INHIBITOR EPOXY PRIMER

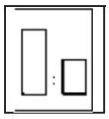
PROPERTIES :

Information

Products

EPOXY PRIMER EP 211 is an anti-corrosion polyamino-amide epoxy primer based on zinc phosphate, fast drying.
EPOXY PRIMER EP 211 is suitable as a high corrosion protection primer for most metals and adhesion promoter for composites and old primers.
EPOXY PRIMER EP 211 has good resistance:
In marine environments and at dry temperatures.
Greases and chemicals (contact us).
EPOXY PRIMER EP 211 :
Applies in a 40 to 80 μm film (can be applied in thick layers, contact us).
Dries quickly.
Sands easily (if needed).
Can be applied at low temperature (between 10°C and 15°C).
Accepts being covered with epoxy coatings without sanding if the covering times are respected.
Accepts overcoating without sanding with a wide variety of intermediate systems or finishes.
Suitable as an anti-corrosion primer before epoxy coating for the protection of ships indoors and outdoors :
Cast iron skittles
Tanks
Metallic structures

COMPONENTS:



Hardeners

Thinners

EPOXY PRIMER EP 211 HARDENER / HARDENER

THINNER EP N°17

DILUTIONS:
BRUSHES AND ROLLS from 3% to 10%
PNEUMATIC GUN from 5% to 20%
AIRLESS from 3% to 5%

SPECIFICATIONS :

Standards and

Qualifications

MAP YACHTING *Paint Systems* SPEC

For the latest missing updates, please check with us at sales@map-yachting.com

The information contained in this edition is based on our current knowledge and experience. Given the many factors that can affect the transformation and application of our products, this information does not in any way release any user from his obligations to carry out his own checks and tests. Nor do they constitute a guarantee of certain characteristics of the products or of their adaptation to a specific need. Any description, photo, data etc. Is mentioned for information only. The most recent version cancels and replaces all previous versions. The most recent document is available on our website www.map-yachting.com, or directly from your distributor. The recipient of our products is required to ensure that all industrial property rights and all laws and regulations in force are respected.

MAP YACHTING *Paint Systems*
Zone Athelia IV-296 Avenue de la Tramontane-13705 LA CIOTAT CEDEX – France

EPOXY PRIMER EP 211

Surface Preparation

All surfaces to be covered must be free of dirt, pollution due to grease, water vapour (refer to the dew point table) dust or mould.
EPOXY PRIMER EP 211 should be applied over a compatible system or over clean blasted steel to Steel Structures Painting Council SP10 or Swedish Standard Sa 2.5. Surfaces must be free of sanding dust. The minimum configuration of the steel surface after sandblasting should be 14μm in depth and slightly rough in nature. For aluminum and galvanized steel, sweep with fine abrasive or pickling with METONET followed by abundant rinsing with clear water. For any other type of surface preparation, consult our technical department.

For any other type of coating, and for surface preparation of aluminium, zinc, galvanized or any previously painted support, consult our technical department.

EPOXY PRIMER EP 211 is compatible with IM409, 215 HB, 215HB+, BIOTANK, BIOTANK IMPREGNANT, FUELTANK, CHEMITANK291, BWT575 systems.
EPOXY PRIMER EP 211 is compatible with epoxy fillers MIXFILL 10&27, GREENFILL80, MIXFILL100.
EPOXY PRIMER EP 211 is compatible with intermediates SF500, AEROFILLER525.01, EPU221, PU225, PU228.
EPOXY PRIMER EP 211 is compatible with finishes: GL55, PU77, PU88, PU99, TOPCOAT PU320-PU380.

Manual

Mixing ratio

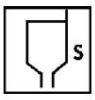
Volume (ml): **100 :** Base / **16** Hardener

Weight (gr): **100 (gr) Base 10 (gr) Hardener**

Allow products to acclimate to ambient site temperature before use. The base should be mixed thoroughly for at least 5 minutes using a clean disperser mounted on an explosion-proof stirrer. Then add the part of hardener by pouring it slowly and continuing to mix until a liquid with a smooth and homogeneous unctuous appearance is obtained. Since the two components are of different viscosity, the edges of the mixing container should be carefully scraped with a spatula. Mixing containers should have flat bottoms and perfectly smooth edges.

Duration
dying

10 to 15 minutes at 20°C



Viscosity
initial
of application
(at 23ºC)

17s to 20s AFNOR Cup n°4

Remark

The viscosity should be checked using AFNOR cup no. 4 and readjusted if necessary. A viscosity check is recommended every 1/2 hour. Do not forget to mix well after each readjustment by diluting. Viscosity measurements are provided for guidance only and should not be used as quality control parameters.

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Shelf life of the mixture at 20°C	8 hours
Remark	
Dry film thickness	70 to 80 μm on abrasive blasted steel (NS SA 2.5) 40 to 50 μm on aluminium, galvanized steel and zinc (previously treated with METONET). 50 to 60 μm on composites, old bases (Polyester Gelcoats, lacquers, etc.) if these are perfectly adherent.

Applications & Recommendations

Conditions

Hardeners :	**EP 211 HARDENER**	**EP 211 HARDENER**	**EP 211 HARDENER**
Place:	10 – 15°C	15 – 25°C	25 – 35°C
Hygrometry :	30 – 80%	40– 70%	30 – 80%

Note

The quality of application of all coatings will be influenced by the spray equipment chosen and by the temperature, humidity and airflow of the paint application area. When first applying the product, it is recommended that test panels be prepared to identify the best equipment settings to use to optimize the performance and appearance of the coating. EPOXY PRIMER EP 211 cannot be applied in conditions outside the limits indicated. Care should be taken to ensure a satisfactory result.

Please contact your MAP YACHTING Paint Systems technician to determine proper application techniques and media when environmental conditions are outside of the recommended range.

Remark

It is advisable to check the chemical stability and the perfect adhesion of composite supports, old bases (Ex: Polyester gelcoats, lacquers, etc.) before applying EPOXY PRIMER EP 211.

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Materiel

Pressure pot
Gun : IWATA WS200SP / WS200FT / W200G2P
Nozzle + Needle: 1.4mm to 1.8mm
Paint flow: 170 - 280 ml/min
Air cap: G2P / WS-200SP-01 / WS-200FT-01 /WS-200FT-02
Gun pressure: 2.5 – 3.0 Bars
Pressure Product: 1 Bar

Gravity gun
Gun : IWATA WS400 / W400 / W400WB / W400 BELLARIA
Nozzle + Needle: 1.4 mm to 2.2 mm
Paint flow: 140 - 250 ml/min
Air cap: LV2 / BA4-1 / WB1 / WBX
Gun pressure: 1.8 – 2.5 Bars
Airless
Nozzle: 0,011 - 0,013 mm
Pressure : 100 - 200 Bars
Electrostatique
Buse : 1.2 – 1.8 mm
Pression : 3.5 - 5 Bars
Electrostatique
Buse : 1.2 – 1.8 mm
Pression : 3.5 - 5 Bars

Name of lying down

Do not "paint to try to cover" when applying the 1st coat.
The final 2° and 3° coats must be closed, smooth and homogeneous with an overcoating time of 1h to 1h30 at 23°C between coats.

Cleaning the material

Perform the first cleaning with SOLVATOP (noble solvent without water and without recycling) and finish the cleaning with the system application solvent.

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Physical properties

USE LIMIT TEMPERATURE : +100 °C

Time to Drying (at 23°C – 40 to 60% RH)

Temperatures	Dry to the touch	Dry hard
10°C	1 hour 30 mins	6 hours
20°C	1 hour	4 hours
30°C	40 minutes	3 hours

Recovery (at 23°C – 40 to 60% RH)

Temperatures	Minimum	Maximum
10°C	15 hours	12 months
20°C	10 hours	12 months
30°C	5 hours	12 months

YIELD THEORETICALLY

12.5 m²/L for 40 m sec -- 6.5m²/L for 80μm dry (without loss)

Dry extract in Volume you Mixed

50 %

Density of Mix at 20°C

1,48

Compounds organic Volatiles

EU limit value for this product (cat. A/d): 500 g/l (2010)
This product contains a maximum of 500 g/l VOC

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ASPECT (at 60°)	Satin / Matte
Colors	Beige clair
Flash point	23°C <= PE <= 55°C
Storage	Store the product in a dry place and at a temperature between + 10°C and + 25°C according to the specifications of MAP YACHTING Paint Systems. Store in original unopened containers. Storage temperature may vary depending on OEM specification requirements. Refer to container label for specific information on storage time.
Lifetime +10°C to 25°C	The information is given for closed containers in the original packaging, i.e. 24 months according to the commercial specifications of MAP YACHTING Paint Systems for the base and 24 months for the catalysts. Shelf life may vary due to OEM specification requirements. Refer to container label for specific shelf life information.

Safety instructions

Comply with all local safety, disposal and transportation regulations. Carefully check the Safety Data Sheet (SDS) and label of each product before using it.

Safety Data Sheets are available on request.

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Exhaustive and is based on the current state of our knowledge and on the laws in force: anyone using the product for purposes other than those specifically recommended in the data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended use does so at its own risk. It is always the responsibility of the user to take all necessary measures to meet the requirements set by local rules and legislation. Always read the Material Data Sheet and Technical Data Sheet for that product, if available. All advice we give or statements we make about the product (whether in this data sheet or elsewhere) are correct to the best of our knowledge, but we have no control over the quality or condition of the substrate or on the many factors affecting the use and application of the product. Therefore, unless we agree otherwise in writing, we accept no liability whatsoever for the performance of the product or for any loss or damage arising from the use of the product. All products supplied and technical advice given are subject to our terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to change from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to check that this data sheet is up to date before using the product. **Brand names mentioned in this data sheet are registered trademarks or licensed to:**