

# EPITAMARIN SOLEKOTE

## HIGH-BUILD MASTIC EPOXY PRIMER FOR APPLICATION ON RUST

▶ <b>Product code No.</b>	843-463 Aluminum 843-458 Grey 843-473 Red Oxide 843-448 Black
▶ <b>Product Description</b>	Two-component, surface tolerant high build and high solids epoxy for application on metal. Can be used as primer and top-coat after blasting or partial surface preparation.
▶ <b>Special features</b>	Excellent anti-corrosive resistance in industrial and marine environment above and below the water line. Resistant to maximum constant dry heat up to 120°C (yellowing without affecting the protective properties of the film may occur in prolonged constant heat).
▶ <b>Suggested uses</b>	Primer and top-coat on steel after mechanical cleaning to ST-2. Can be applied on old synthetic, epoxy and phenol paints. Epitamarin Solecoat red & grey are approved for the carriage of edible products. Epitamarin Solecoat can be applied as a tie coat over Inorganic Zinc Silicate, prior to painting "Tamaglass" .

### Technical data

▶ <b>Color</b>	Aluminum, Red Oxide, Black, Grey 7023, Grey 9001.
▶ <b>Gloss at 60°C</b>	Satin.
▶ <b>Solid content by volume</b>	75%
▶ <b>Recommended dry film thickness</b>	80-150 microns.
▶ <b>Calculated spreading rate* (sq. m/liter)</b>	5-9.4 respectively.
▶ <b>Recommended thinner</b>	4-100
▶ <b>Touch dry**</b>	4 hours.
▶ <b>Hard coat**</b>	24 hours.
▶ <b>Dry to recoat</b>	12 hours min.; 90 days max.
▶ <b>Dry to dip</b>	5 days at least.

**Two pack product**

<b>Mixing ratio by weight &amp; volume</b>	A:B = 1:1
<b>Induction period before application**</b>	15 minutes.
<b>Pot life after mixing**</b>	6 hours.
<b>V.O.C. MIXED</b>	233 g/l
<b>▶ Shelf life**</b>	24 months.

**Surface preparation and specification** Remove contaminants, oil, dirt and salts. Remove loose rust and paint using a steel brush or other effective means to ST-2 per Swedish standard. Blasting to SA2.5 to achieve a profile of 60-70 microns is preferable. Apply one primer coat, 80-150 microns thick, per specification requirements. Can be applied as a primer for synthetic, epoxy and polyurethane paints, such as Super Durable Top-Coat (for synthetic paints, refer to recommended dry to recoat times), POLYCHEMCURE, Multi-Poxy and Tamaglass.

<b>▶ Paint application</b>	Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume (%)
	Brush/roller			4-100	10-15%
	Regular spray	5-6	0.021"-0.023"	4-100	Up to 5%
	Airless spray	5	1.8	4-100	10-15%

**▶ Cleaning thinner** 4-100

**Application remarks**

1. Stir well before application and while painting.
2. For optimal results, use airless equipment of 1:30 compression ratio at least..

**Caution** Any work that includes application and use of this product shall be performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label. Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet. Do not inhale fumes when spraying this product.

**Warning** Never mix this material with others when not specifically recommended by us.

**General comments** Data presented here is based on our best knowledge and experience. We reserve the right to update and/or alter it without prior notice. Achievement of the best desired results is subject to proper application in strict conformance to our instructions and safety measures. Before application, the user should verify that the product is indeed designed for the intended usage and that the surfaces to be painted are properly prepared, and are suitable for the product's application.

\* Practical spreading rate can vary, depending on the surface, the application mode, the painter's skill and weather conditions at the site. Assume approximately 75% of the calculated spreading rate.  
 \*\* At 25°C and 65% relative humidity.