

Corroless EPF Temperate Grade 2022

Rust Stabilising Primer

Issue Date: July 2021
Code: LEPFTN3/4
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Product Description	A two pack epoxy, rust stabilising primer formulated using a tar free resin system, with Corroless Pigment and self-leafing glass flake.				
Features & Use	<ul style="list-style-type: none"> • High Build, solventless product with excellent abrasion resistance • Moisture tolerant - can be applied to damp surfaces • Applications include structural steel, sheet piling, tank linings, jetties, bridges, ballast tanks as well as concrete and other selected substrates 				
Approvals/ Certification	<ul style="list-style-type: none"> • NATO stock number 0442-8010-25-150-0972 				
Finish	Semi-gloss (when new - chalks on exterior exposure)				
Volume Solids	96% ± 2%				
VOC Content	Black: 41 ± 20 g/litre Buff: 34 ± 20 g/litre				
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage	
	Typical	200 µm	208 µm	4.8 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 208 microns WFT	+10°C	+18°C	+30°C	
	Dust Free	8 hr	6 hr	4 hr	
	Hard Dry	24 hr	16 hr	12 hr	
	Overcoating	Minimum	24 hr	16 hr	12 hr
		Maximum	4 days*	2 days*	2 days
*For solvented products 7 days is acceptable but for Corroless EPF and RF35(2006) and RF35 White the maximums listed apply. Full cure is a nominal 7 days at 18°C. Drying and recoating times are related to the substrate temperature					
Colours	Black (LEPFTN3) and Buff (LEPFTN4) Note: base is red brown and the hardeners are black and off white respectively				
Mix Ratio	Base 1 part by volume Hardener 1 part by volume				
Pot Life	60 min at 18°C				
SG	1.53 kg/lit mixed				
Storage Conditions	Store in dry, cool conditions and protect from frost				
Shelf Life	Minimum 24 months if stored as above in unopened containers				
Flash Point	Above 60°C				

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<p>Surface Preparation</p>	<ul style="list-style-type: none"> If required due to obvious dirt/grease contamination or suspected salt or chemical contamination, clean all surfaces with a water-soluble degreaser, wash down with clean fresh water and allow to dry before commencing main preparation Recommended substrate: Steel (Corroless EPF can also be applied to concrete and other substrates – advice available on request) Manual Preparation: Prepare using rust scrapers, chipping hammers, needle guns, wire brushes etc. to St2 standard of ISO 8501-1:2007 or equivalent. Where necessary, remove weld spatter and grind smooth all sharp edges and weld seams Wash down with clean fresh water and allow to dry before coating Mechanical preparation: Blast clean to minimum Sa1 standard of EN ISO8501-1:2007 or equivalent with a surface profile of 50 to 75 microns. Wash down with clean fresh water and allow to dry New Steel: All mill scale must be removed prior to application Before coating all surfaces should be firm, clean dry and free from oil, grease, powdery flash rusting and other contamination 										
<p>Mixing</p>	<p>Mix each component separately prior to use thoroughly mixing together for 2-3 minutes at medium speed. Always use a mechanical agitator. Ensure product is used only in proportions recommend.</p>										
<p>Thinner / Cleaner</p>	<p>Corroless Thinners No.6 Note: thinning is not allowed when lining potable tanks</p>										
<p>Application Conditions</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 90% and the steel temperature should remain at least 3°C above the dew point. Paint temperature should ideally be at a minimum of 15°C.</p>										
<p>Application Methods</p>	<table border="1" data-bbox="459 1077 1497 1205"> <thead> <tr> <th>Method</th> <th>Airless Spray</th> <th>Conventional Spray</th> <th>Brush</th> <th>Roller</th> </tr> </thead> <tbody> <tr> <td></td> <td>Yes</td> <td>No</td> <td>Yes</td> <td>Yes</td> </tr> </tbody> </table> <ul style="list-style-type: none"> Airless spray: output fluid pressure 3500-4000 psi, tip size 17-21 thou (0.43-0.53mm). For detailed advice contact Corroless Brush/roller: apply un-thinned, lay on, do not over brush. When rolling, use a short nap lamb's wool roller followed by laying off with a brush. For non-potable situations a maximum addition of 5% Corroless Thinners No.6 is allowed 	Method	Airless Spray	Conventional Spray	Brush	Roller		Yes	No	Yes	Yes
Method	Airless Spray	Conventional Spray	Brush	Roller							
	Yes	No	Yes	Yes							
<p>Product Notes</p>	<ul style="list-style-type: none"> Application Temperature: Range 2°C-30°C (Curing will be retarded below 10°C -product will cure down to 2°C but cure will be slow) Stripe Coating: Stripe coat all edges, nuts and bolts, welds etc. Overcoating: Overcoat with Corroless EPF, Corroless RF31, RF35, RF61, RF65. If overcoating time exceeds and contamination has occurred, clean using a detergent solution/fresh water and allow to dry before continuing If maximum overcoat times are exceeded abrade the surface and wash down with fresh water to remove contamination and allow to dry before continuing 										
<p>Health & Safety</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 Axalta Coating Systems.</p>										

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