

# Technical Data Sheet



Edition dated: 13.10.06

Replaces Edition dated: 21.10.05

Data sheet Nr. EA9000

## AVKOTE 2250 Primer (unthinned)

<b>Product description</b>	Two component primer and intermediate primer (Supplied unthinned) Thinner 3000 needs to be added. See page 3
<b>Binding Agent</b>	Epoxy resin
<b>Areas of Application</b>	Primer and intermediate primer. Adhesion primer for a variety of substrates including a wide range of metal surfaces.
<b>Form of Supply</b> Colours	White
Gloss Level	Silk Matt
<b>Hardener</b>	Avkote Hardener 2243
<b>Packing</b> Coating	1, 3 and 5 Litre disposable containers
Hardener	1 Litre disposable containers

### Technical Data

	Coating		Hardener		Mixture	
<b>Specific Gravity (23 °C)</b>	1.33	g/cm <sup>3</sup>	0.93	g/cm <sup>3</sup>	1.29	g/cm <sup>3</sup>
<b>Solids content</b>	65	± 2 Weight-%	37	± 2 Weight-%	Appr 62	Weight-%
<b>Organic Solvent Content.</b>	35	± 2 Weight-%	63	± 2 Weight-%	Appr 40	Weight-%
<b>VOC Content (CH / EU)</b>	47.1	%	471	g/lit	58.1	%
					581	g/lit
<b>Shelf life at 20 °C</b>	12 Months		6 Months in well shut containers			
<b>Theoretical Coverage</b>	106	g/m <sup>2</sup>	9.4	m <sup>2</sup> /kg for	35	µm dry layer thickness

Safety Data	Coating	Hardener
<b>Flash point</b>	14 °C	4 °C
<b>Transport ADR/RID</b>	Class: 3 VP: III	Class: 3 VP: III
<b>Poison classification (EU)</b>		
<b>VVS disposal code (EU/CH)</b>	08, 08 01, 08 01 11	08, 08 01, 08 01 11

**Application Recommendations**

Substrate	No. of Coats	Product	Dry Film thickness	Data sheet
Steel, Aluminium, etc. Exterior applications	1 x Primer	Avkote 2250 Primer	40 – 60 µm	EA9000
	1 x Top Coat or	Avkote BSP	40 – 60 µm	5398
		Avkote LE	30 – 50 µm	5393
Steel, Aluminium, etc. (chemically resistant)	1 x Primer	Avkote 2250 Primer	40 – 60 µm	EA9000
	1 x Top Coat	Avkote LE	30 – 50 µm	5393
Note	The use of this product is so multi sided, that all applications cannot be listed in this data sheet.			
	For further application proposals ask our technical department.			

**Preparation**

	<b>Substrate</b>	Every substrate must be thoroughly cleaned, grease and oil-free, and dry before paint application commences.
	Steel	Sandblast or sand, clean
	Aluminium	Sand or use Scotchbrite (coarse), clean or chemically treat such as chromate, clean
	Aluminium Profiles	Sand well or use fine sandblast, clean. Or chemically treat such as chromate, clean.
	Zinc	Sand well or use fine sandblast, clean
	Old Coatings	Sand, clean
	Cement Substrate	Roughen the surface, clean

**Processing**

	<b>Preventative measures</b>	We recommend the wearing of protective clothing even if not stipulated by law. The national and regional health and safety regulations for work hygiene and equipment are to be observed. Pay attention to our safety data sheet Nos. EA9000 and EA90002243.
	<b>Stir</b>	Before use ensure contents are stirred together well with hardener if applicable.
	<b>Mixing Ratio</b>	9 : 1 by volume with Avkote 2243 hardener
	<b>Pot life at 20 °C</b>	8 hr
	<b>Thinners</b>	<b>Mix Thinners 3000 with Avkote 2250 Primer as shown in the table below to obtain application viscosity.</b>
	<b>brush</b>	Unthinned, add 5-10% Thinners 3000 if necessary
	<b>Roll</b>	Unthinned, add 5-10% Thinners 3000 if necessary

	Viscosity DIN-4	Thinners	Nozzle	Pressure	Spray coats
 Gravity Feed Spray-gun	18 - 22 secs	20 - 25 %	1.4 - 1.8 mm	3 - 4 bar	2
 Suction-spray-gun	18 - 22 secs	20 - 25 %	1.4 - 1.8 mm	3 - 4 bar	2
 Airless-(Airmix)-Spray	20 - 25 secs	20 %	0.6-0.9	3 – 4 bar	1-2
 HVLP paint gun	18 - 22 secs	20 - 25 %	1.4 - 1.8 mm	3 - 4 bar	2
 Evaporation time	Prior to drying at temperatures over 40 °C allow an evaporation time of 15 minutes.				
 Drying time	For 40 µm dry coating at 65 % of relative humidity				
	At 20 °C	Tack-Dry	after:	30	Minutes
		Touch – Dry	after:	30	Minutes
		Dried (Can be sanded)	after:	10	Hours
		Suitable for re-coating	after:	12	Hours
		Completely Dry	after:	10	days
	At 60 °C	Dry	after:	2	Hours

**Important references**

<b>Specific restrictions</b>	Relative humidity max. 80 %		
<b>Minimum application- and drying temperature</b>	10 °C	Do not apply at temperatures below the dew point	
<b>Coating removal</b>	Sandblast or use Metro Fit Standard paint stripper		
<b>Equipment cleaning</b>	Clean immediately after use with Gun Wash Thinners.		

This data sheet is for your reference and information only. The above data are correct to the best of our knowledge. We offer no guarantees for use and exclude any liability. This applies in particular to consequential damage. We are not liable for any advice given by our employees. Our employees give non-binding information only. Site supervision, compliance with handling regulations and adherence to recognized engineering rules are the responsibility of the manufacturer, even if our employee was on site during handling. Modifications due to technical developments may be made. The latest version of this information is applicable. In special cases, please request separate technical specifications.