



## TWO COMPONENT PRIMER

# EPOXY 61 S GRUND WV B

- certifications of ÖBB/DB/SBB
- minimal share of solvents < 3 %
- economical to apply – 0.15 kg/m<sup>2</sup> at 50 µm TSD

Waterborne 2-component epoxy resin combination-primer especially for use in the rail vehicle sector (certifications of ÖBB/DB/SBB) and for applications in the industry. This primer has excellent corrosion protection properties.

## TECHNICAL DATA

<b>Colour shade:</b>	NCS 2502 B, RAL and NCS
<b>Gloss degree:</b>	silky mat
<b>Processing:</b>	Spray gun and airless spraying (airmix), rolling, brushing
<b>Substrate:</b>	steel and black sheet e. g. S 355 J 2 G 3: sand blasting ISO 8501-1 grade SA 2 ½, sand (120/150) aluminium e. g. EN-AW-6005: abrasive with ferrit-free material or sand (80) chrome steel e. g. 1.4318: abrasive with ferrit-free material or sand (80)

# EPOXY 61 S GRUND WVVB

<b>Shelf life:</b>	at least 18 months
<b>Solids content:</b>	63 +/- 3 % in mixture
<b>Volume-solids content:</b>	calculated 45 +/- 3 % in mixture
<b>Spec. gravity:</b>	1.42 +/- 0.05 g/ml/20 °C in mixture
<b>Theor. spread rate:</b>	calculated 243 g/m <sup>2</sup> /80 µm DFT

## FURTHER PROCESSING

### Coating variants:

EPOXY 61 S Deck wvb  
2 K-Epoxy Spachtel  
2 K-PE-Spachtelkitt  
PE-Faserspachtel P51  
Softfeinspachtel Colormatic  
Aqua Füller 41  
KH-ES-Lack wvb  
KH-ES-Lack ÖBB wvb  
ES-Lack RMB wvb  
REM PUR 510 DF-FEGL

## APPLICATION

### Processing:

Spraying with air-spraying, airless and airmix

### Application instructions:

Optimal processing temperature: 18–28 °C  
Ideal humidity at processing: 40–60 % R.H.  
Maximum humidity at drying process: 80 % R.H.  
No processing below 15 °C!

### Delivery viscosity:

thixotrop

### Mixing ratio:

6 parts by weight      Epoxy 61 S Grund wvb  
1 part by weight      EP-Hardener 61 wvb  
The hardener component should be stirred mechanically.

### Pot life:

max. 3 hours at 20 °C in mixed status

### Thinner:

DI-water or rather drinking water quality

Immediately after processing tools have to be cleaned with water, if necessary rinse with thinner 200. The tools must be suitable for waterborne products, consider manufacturer data. Cleaning dilution has to be duly recycled, don't waste into canalisation!

## ADJUST WITH WATER TO RECOMMENDED PROCESSING VISCOSITY.

PROCESSING	NOZZLE TYPE	VISCOSITY	THINNER % BY WEIGHT	PRESSURE
Spraying gun + Diaphragm pump	1,8 mm 2,0 mm	–	ca. 5 %	4 – 5 bar
Airmix	0,28 – 0,33 mm	delivered viscosity	0 %	> 150 bar

Viscosity data depending on equipment.

## DRYING TIME

DRYING	DEGREE	TIME
Forced drying	reworkable (TG6): or:	2 hrs/40 °C/80 µm DFT 1 hr/60 °C/80 µm DFT
Drying at room temperature	dust free (TG1): reworkable (TG6):	60 min/20 °C/80 µm DFT 16 hrs/20 °C/80 µm DFT

This data is based on experience, for its completeness we assume no liability. As we take no influence on the processing, it lies within the obligation of the customer to test, whether it is suitable for the intended purpose, before using the product. Any change in the processing procedure, the environmental conditions or the failure to comply with instructions may unfavourably influence the result.