

Description

Fast drying epoxy shop-primer with corrosion inhibitors based on zinc phosphate. Direct-to-metal application. Provides anticorrosive protection of structures up to 24 months, including in an outdoor industrial atmosphere.

Recommended use

ISOLEP-eps can be used as shop-primer for cleaned steel sheets and other metal structures during manufacturer painting at automated lines on plant.

It is a shop primer designed for high semi-automatic and automatic welding and cutting speed, giving reduced weld porosity.

Can be used as temporary primer, as holding primer or as primer in a complete coating system with the ISOLEP-primer and ISOLEP-mastic VMP coatings, and other epoxy, polyurethane, vinyl, chlorinated-rubber and acrylic materials.

Certificates, Approvals

State registration certificate No. RU.66.01.40.015.E.000200.10.18 dated 31.10.2018.
Expert statement by LKP-Khotkovo-Test, the JSC "Ural Institute of Welding".

Technical data

	Coating	
Color		red-brown
Appearance		matt
	Primer	
Density, g/cm ³		1.2±0.1
Pot life at temperature 20 °C, hours, not less than		8
Viscosity according to viscometer with 4 mm nozzle diameter at temperature (20.0±2) °C, s		12-20
Drying time (GOST 19007) at 20 °C, minutes, not more than		
to 1 degree		5
to 3 degree		10
Dry film thickness, µm		15-30
Wet film thickness, µm		50-95
Theoretical spreading rate of one-layer coating, g/m ²		55-110
Solids		
by volume, % volume		32±2
by mass, % mass		45-50

Surface preparation

- to degrease metal surface to 1 grade according to GOST 9.402;
- to do abrasive-blast cleaning to 2 grade according to GOST 9.402 or Sa 2 ½ ISO 8501-1, surface roughness of 25-60 µm (segments 1-2 on S comparator ISO 8503-1);
- to remove dust.

During the subsequent application of coating system, ISOLEP-eps surface should be dedusted, if necessary, degreased to the first degree (GOST 9.402), in the presence of traces of corrosion and other defects, local cleaning should be carried out to the degree P Sa 2 - Sa 2 ½ ISO 8501-1.

Application

- mix the component A to a homogeneous condition before application;
- add the component B to the primer base in proportion as the label indicates, with constant stirring, mix thoroughly, dilute to working viscosity, if necessary, with SOLV-ES thinner.

The proportion of components A and B by mass 2.9:1, by volume 2:1, respectively.

The pot life (after mixing the components) at (20±0.5) °C is at least 8 hours (periodic stirring is recommended).

ISOLEP-eps is recommended to be applied in plant conditions at temperature from plus 5 to plus 40 °C and relative air humidity not exceeding 85 %.

Temperature of the painting surface shall be above the dew point by at least 3 °C.

Recommended application:

Automated line

Recommended thinner no thinner
Pressure 10 - 15 MPa (100 - 150 bar)
Nozzle diameter 0.011" - 0.015"

Brush/roller

small area, for touch-up purposes
no thinner

Equipment cleaning

SOLV-ES (TU 2319-080-12288779-2009)
SOLV-EP (TU 20.30.22-106-12288779-2018)
solvent naphtha, P4, 646

Hardening time of the ISOLEP-eps at dry film thickness of 30 µm

Surface temperature	10 °C	20 °C	30 °C	40 °C
touch dry	12 min	4 min	2 min	1 min
to turning over, handling	30 min	12 min	6 min	4 min

The mentioned hardening time is approximate for practical painting. The hardening time depends on air and surface temperature and relative air humidity.

Time to over coat with ISOLEP-mastic and ISOLEP-primer

Air temperature, °C	Minimum time	Maximum time
From 20 to 25	8 hours	Unlimited

Storage and handling

ISOLEP-eps is supplied as the component A in 20 and the component B in 10 litre metal containers.

Storage conditions of components- in accordance with GOST 9980.5 (at ambient air temperature from minus 40 to plus 40 °C). In storage the package shall be protected from lasting direct sunlight and atmospheric condensation. It is allowed to store the package with components under direct sunlight, however not more than 3 hours.

The shelf life of the component A is 24 months, of the component B- 12 months starting with the date of manufacture.

Precautions

When working with the enamel-primer one shall observe the existing sectoral standard norms and requirements and safety measures as specified on the package label.

One shall use personal protective equipment (goggles, face masks and respirators) and avoid inhalation of solvents and contact of the composition substances with skin, eye mucosa, respiratory channels; use inside the premises is allowed only in case sufficient ventilation is provided.

ISOLEP-eps is classified as fire-hazardous material.

The information is of general character, without consideration to the object specific nature and it is recommended to be read with the Operating Procedure. Use of materials for other purposes not specified here or in case other influencing factors are present shall be approved by VMP in writing. In case of absence of such approval the manufacturer is not held liable for the improper use of the material and the buyer falls from the right to present claims connected with the coating quality.



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