CHING-EP-zinc flake-Primer
EMD 155

Intended use

Fast-drying 2C-zinc flake primer with cathodic and barrier protection. Suitable for heavy corrosion protection on steel in combination with suitable 2C-EP-PUR-subsequent coatings. Due to its good adhesion properties, this product can also be used for manually derusted steel or as a stain primer for damage to hot-dip-galvanized steel.

Application

Radiators, transformers, bridge construction, structural steelwork, hall construction, lattice structures and substations with high loads and where blasting is not possible.

General information

	Color shades	Grey, lightgrey, reddish grey, other colors on request			
	Gloss	mat			
	Mixing ratio	**Hardener**	**per weigth** [Paint : Hardener]	**per volume** [Paint : Hardener]	
		Hardener M 028W	100 : 11	100 : 18	
	Pot life	approx. 3 - 4 h	NC 23°C/50%		
	Stirring / Dilution	Stir the product mechanically before each use. Ready to use after adding hardener. Dilute with CHING-EP-Thinner EM 04 FL or EM 01 if necessary.			
	Spraying	**Viscosity** [DIN 4]	**Thinner** [%]	**Nozzle** [mm]	**Pressure** [bar]
	Cup gun	40 - 70 s	5 - 10	1,5 - 2,5	3 - 5
	Airless (Airmix)	Delivery form	≤ 3	0,31 - 0,51	120 - 200
	Brush application	Delivery form (best penetration by brush application)			
	Roller application	Delivery form (multiple application is recommended due to structure formation and minimum layer thicknesses)			
	Flow application	suitable, adjust flood viscosity depending on flood viscosity and object geometry e.g. 18 - 30 DIN-4-sec. with Thinner EM 04 FL			

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Substrate preparation	Steel must be free of grease, oil, salt, dust, and other adhesion-reducing substances. For requirements of corrosion protection class C5 and higher, and for offshore applications, blasting to Sa 2½ according to ISO 8501-1 with sharp-edged blasting media is recommended. Roughness grade according to ISO 8503-1 at least fine (G); surface roughness depth Rz 10-30 µm. In renovation applications, when used as a stain primer: St 2-3 or P St 3 according to DIN EN ISO 12944-4.
Viscosity delivery form	40 - 70 DIN-6-seconds

Drying time[1]	**Temperature**	**Dust-dry**	**Grip resistant**	**Mech. resilient**	**Recoatable**[2]
at 120 µm	NC 23/50	40 min	4 h	12 h	2 - 3 h[3] 6 - 7 h[4]

1 Based on delivery viscosity! Humidity has a decisive influence on drying!
2 with itself (not normally required for top and final coats, except possibly for minimum coat thicknesses)
3 with suitable subsequent coating e.g. 2C-EP-intermediate coating EMD 30
4 with suitable subsequent coating e.g. 2C-PUR-top coat ADD 43/47

Other values

Density [g/cm³]	**Solids** [Weight. %]	**Solid volume** [%]	[cm³/kg]	**Effiency**[1] [m²/kg]
1,6 ± 0,1	70 ± 3	58 ± 3	354 ± 20	3,0
WFF	**DFT**[2] [µm]	**Consume** [g/m²]	**VOC-content** [g/l] (± 20)	**Temperature resistance**[3]
1,8	60 - 120	340 ± 20	450	120°C

These values are imputed values that may vary depending on the color shade and application.
Drying times are correspondingly longer for thicker layers.
The drying times are shortened by forced drying.

1 ± 0,5 for 120 µm dry layer thickness (depending on shade)
2 With layer thicknesses > - µm bubbles may form!
3 Dry heat

Notes

- **Storage**
  24 months (in unopened original container. Store cool but frost protected!)
- **Processing conditions**
  - The air and object temperature should be at +10°C to +40°C (optimally at 15-35 °C) and the relative humidity at max. 80 %. The surface temperature of the parts to be coated must be at least 3 °C above the dew point of the surrounding air during application.
  - Sufficient supply and exhaust air must be provided.
  - Experience has shown that the coating system is suitable for vapur phase drying and for operating temperatures of transformers, whereby the specified layer thickness must not exceed by more than double!
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