

TrimaKote 2776

WB Two Pack Epoxy Primer

Description	A water based, two pack epoxy anticorrosive primer for metals.
Finish	Sheen.
Features	<ul style="list-style-type: none"> • Designed as a primer for general use on metal components and steelwork. • Excellent chemical resistance and anticorrosive properties.
Complies With	2004/42/EC (2012) sub-category A(j) - VOC level below 140 g/l.
Product Code	2776- .
Volume Solids	41% ± 2% (mixed material).
VOC's	Below 50 g/l.
Colour Range	Steel White, Grey, Black.

Film Thickness & Coverage		<u>Dry</u>	<u>Wet</u>	<u>Theo. Coverage</u>
	Rec. Min:	50 µm	122 µm	8.2 m ² /l
Rec. Max:		100 µm	244 µm	4.1 m ² /l

Actual coverage varies considerably with factors including surface porosity, roughness, application methods and conditions.

Drying & Overcoating Times at Min. DFT		<u>10°C</u>	<u>20°C</u>	<u>30°C</u>
	Surface Dry:	6 h	3 h	1½ h
	Hard Dry:	16 h	8 h	4 h
	Overcoat Min:	16 h	8 h	4 h
	Overcoat Max:	Indefinite if clean and sound*		

Drying and overcoating times can be greatly affected by method and conditions of application such as thickness applied, temperature, ventilation etc. Data above are given as a guide.

* Overcoating is recommended as soon as practicable and ideally within 6 months.

TECHNICAL DATA SHEET**TrimaKote 2776****WB Two Pack Epoxy Primer**

Surface Preparation	<ul style="list-style-type: none">All steel surfaces to be coated should be dry and cleaned as necessary to remove all rust, mill scale, grease and other contamination. Where necessary, remove weld spatter and grind smooth all sharp metal edges and weld seams.Abrasive blast clean to standard Sa2½ (ISO 8501-1:2007), with a surface profile of 50-75 microns.For small areas where abrasive blast cleaning is not possible, the surface should be prepared by hand or mechanical means to standard St2 (ISO 8501-1:2007), with care required to avoid 'polishing' the metal surface. Coating lifetime will be significantly reduced if not blast cleaning.
Mixing	Mix each component separately, and then thoroughly mix together in the mix ratio stated, using a power mixer. Stir occasionally during use to maintain an homogenous mix.
Pot Life at 20°C	2 hours (do not use after this time, even though material may still look fluid).
Mix Ratio	Base 1.25 volumes Activator 1 volume.
Application Conditions	Throughout the application and the drying/curing time of coatings: (a) good ventilation is required; (b) do not apply when damp weather conditions are likely; (c) the substrate temperature should be at least 3°C above the Dew Point; and (d) the RH (Relative Humidity) should be below 85%. It is advisable not to apply the product when the ambient temperature falls below 10°C. The paint temperature at the time of application should ideally be 15° - 20°C.
Application Details	<ul style="list-style-type: none">Designed for application by airless or conventional spray. Brush is suitable for small areas only as film build may not be achieved.Do not apply below 10°C.
Thinner/Cleaner	Clean water (for cleaning of equipment, warm water is recommended).
SG	1.25 ± 0.15 kg/l mixed.
Flash Point	Above 60°C.
Shelf Life	Minimum of 2 years from date of manufacture when correctly stored in unopened containers.
Storage	The product should be stored in cool, dry, frost-free conditions, in sealed containers. Most paint materials will apply optimally when at 15° - 20°C.
Health & Safety	Refer to the product's Safety Data Sheet and safety advice on the product label before use.
Date of Issue	Apr 2023.

Information provided in this leaflet is given in good faith but without warranty or assumed liability, as the conditions of application and use are beyond our control. Data are accurate to the best of our knowledge at the time of issue but may be revised in the light of new knowledge and the user should check that data are current before use. The user must satisfy themselves about the product's suitability for their own purpose and refer to the Safety Data Sheet for this product before use. For industrial use only unless specifically stated otherwise.