Industrial coating
2K Epoxy primer surfacer, water-based, yellow
high requirements for sandability and corrosion protection
e. g. for trains

Basis Epoxy resin (solid epoxy resin and hydrophobic amine))

	L 00046.1		[2]	[1]	[6]
Component A	*-- part 1 --*				
	Demineralized water		30.50	30.50	32.00
	Additol VXW 6208	(1)	3.30	3.30	3.30
	Additol VXW 6393	(1)	0.15	0.15	0.15
	Texanol	(2)	0.60	0.60	0.60
	-- part 2 --				
	AKTIFIT AM	(3)	---	29.80	---
	AKTISIL AM	(3)	29.80	---	44.80
	Kronos 2190	(4)	8.00	8.00	8.00
	Bayferrox 3920	(5)	2.50	2.50	2.50
	Bayferrox 130	(5)	0.03	0.03	0.03
	Microtalc IT Extra	(6)	15.00	15.00	---
	-- part 3 --				
	Additol VXW 6388	(1)	0.60	0.60	0.60
	Methoxy propanol		1.00	1.00	1.00
	-- part 4 --				
	Beckocure EH 2261w/41WA	(1)	24.20	24.20	24.20
	TACorr MSW)[1]		2.00	2.00	2.00
	flashproTAC C4E	(7)	0.40	0.40	0.40
	Total parts by weight		118.08	118.08	119.58
Component B	Beckopox EP 387w/52WA	(1)	41.30	41.30	41.30
	Demineralisiertes Wasser		4.60	4.60	4.60
	Total parts by weight		45.90	45.90	45.90

)[1] TACorr MSW is no longer available (7)
Recommended: TACorr G50 W

Recommendation

[2] good sandability, very good corrosion protection with excellent substrate adhesion

[1] most effective sandability for high-speed machine grinding, good corrosion protection

[6] high storage stability and best sedimentation protection, early sandability, preferably for manual grinding process, good corrosion protection

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	L 00046.1	[2]	[1]	[6]

Preparation

Component A
- mix raw materials from part 1
- stir in raw materials of part 2 in the indicated order and disperse by dissolver with toothed disc to a particle size of 20 µm
- successively add the raw materials from parts 3-5 for completion

Component B
- mix raw materials

Application

- mix component A and B shortly before application
- undiluted with doctor blade, single layer
- substrate: cold-rolled steel Q-Panel Type R-48
- drying: 7 days @ standard climate 23/50; for sandability: as indicated
- dry film thickness: ≈ 80 µm

Suppliers

(1) Allnex
(2) Eastman Chemical Company
(3) HOFFMANN MINERAL
(4) Kronos International
(5) Lanxess
(6) Elementis
(7) Stratmans High TAC

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				50 pbw barium sulfate ppt 15 pbw talc			
				Control	[2]	[1]	[6]
Technical data	Mixing ratio A : B				all: 2,2 : 1		
	Degree of cross-linking				all: 53		
	Solids content m/m		%	63.7	54.8	54.8	54.3
	Solids content v/v		%	43.9	39.8	39.8	39.5
	PVC		%	42.0	42.0	42.0	42.4
Properties	Sedimentation stability component A 28 days @ 40 °C			poor	good	moderate	very good
	Dyn. viscosity A+B 23 °C	0.1 s^{-1}	Pa·s	23.9	10.1	9.0	10.7
		1000 s^{-1}	Pa·s	0.21	0.13	0.11	0.12
	Pendulum hardness Koenig		s	38	45	48	48
	Cross-cut test 2 mm, after tape tear-off			0	0	0	1
	<u>Salt spray test, DIN EN ISO 9227 NSS, 300 h</u> rating according to DIN EN ISO 4628 part 2-5 and 8						
	Cross-cut test 2 mm, after 24 h, after tape tear-off			2	0-1	1-2	3
	scribe :Sikkens						
	Degree of blistering			2-3 (S5)	0 (S0)	0 (S0)	0 (S0)
	Degree of rusting			Ri 3 (S5)	Ri 0	Ri 0	Ri 0
	Degree of cracking				all: 0 (S0)		
	Degree of flaking				all: 0 (S0)		
	stripped						
	Delamination / corrosion		mm	6	< 2	< 2	< 2

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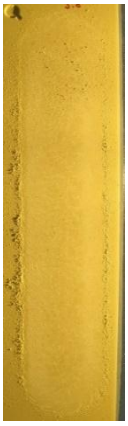
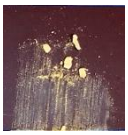
		50 pbw barium sulfate ppt 15 pbw talc			
		Control	[2]	[1]	[6]
Machine sandability 30 mm disc, P240, dry, 2000 rpm, 15 strokes a 15 cm, load 14 g/cm²					
drying: 16 h @ 23 °C + 2 h @ 60 °C convection					
Total loss	mg	80	93	138	51
Manual sandability P240 dry, load 125 g/cm²					
Trocknung: 2 h @ 40 °C Umluft (early sandability)					
		insufficient	moderate	good	very good
drying: 16 h @ 23 °C + 2 h @ 60 °C convection					
		good	good-very good		very

More information on this topic:

Neuburg Siliceous Earth in Water-based Sandable 2C Epoxy Primer Surfacer for Trains

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