

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	
	Microcalc 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 (7)	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	

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

Our applications engineering advice and the information contained in this formulation are based on experience and are made to the best of our knowledge and belief, they must be regarded however as non-binding advice without guarantee. Working and employment conditions over which we have no control exclude any damage claim arising from the use of our data and recommendations. Furthermore we cannot assume any responsibility for patent infringements, which might result from the use of our information.

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- Preparation**
- mix raw materials from part 1
- Component A
- 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

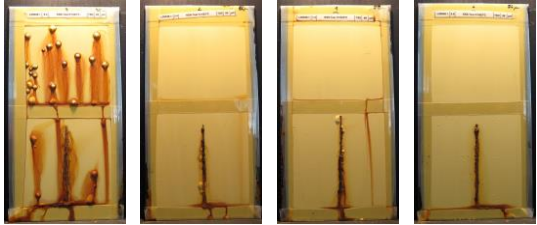

- Application**
- mix component A and B shortly before application
 - undiluted with doctor blade, single layer
 - substrate: cold-rolled steel Q-Panel Type R-48
 - drying: 7 days @ standard climate 23/50; for sandability: as indicated
 - dry film thickness: ≈ 80 µm

- 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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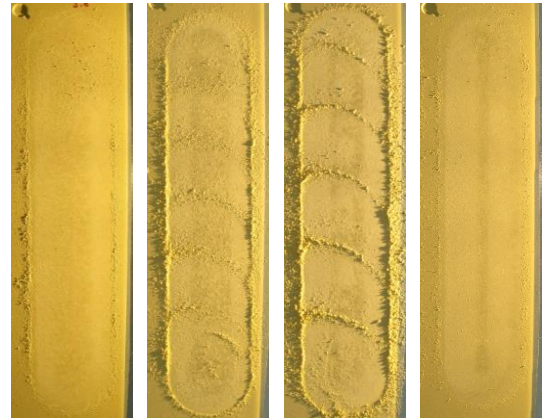
50 pbw barium sulfate ppt
15 pbw talc

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

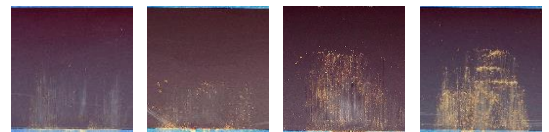


Total loss	mg	80	93	138	51
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Manual sandability

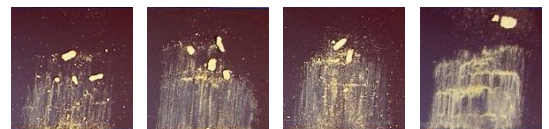
P240 dry, load 125 g/cm²

drying:
2 h @ 40 °C convection
(early sandability)



insufficient moderate good very good

drying:
16 h @ 23 °C
+ 2 h @ 60 °C convection



good good-very good very good

More information on this topic:

[Neuburg Siliceous Earth in Water-based Sandable 2C Epoxy Primer Surfacer for Trains](#)