Industrial coating
Anti-corrosion primer
medium solid, VOC approx. 430 g/l

Basis Epoxy resin (bisphenol A and polyamide resin)

	R 24301.1		[25]	[27]	[42]
Component A	Epikote Resin 1001-X-75	(1)	23.8	23.8	23.8
	Bentone 34 10 % paste)*)**	(2)	4.3	4.3	4.3
	Xylene		6.5	6.5	6.5
	Ethyl glycol		4.7	4.7	4.7
	Methyl isobutyl ketone (MIBK)		6.6	6.6	6.6
	Nusa 57	(3)	0.4	0.4	0.4
	Byk-354	(4)	0.8	0.8	0.8
	Sachtleben RD3	(5)	5.9	5.9	5.9
	Blanc Fixe micro	(5)	7.8	7.8	7.8
	Zinkphosphat ZP 10	(6)	2.5	2.5	2.5
	AKTISIL PF 777	(7)	21.3	---	---
	AKTISIL AM	(7)	---	21.3	21.3
Component B	Versamid 115 X 70	(8)	12.7	12.7	12.7
	Dynasylan AMEO	(9)	---	---	< 1.0
	Total parts by weight		97.3	97.3	98.3

)* 10 % Bentone paste:

Bentone 34	10
Xylene	87
Ethanol	3

)** with AKTISIL PF 777, the Bentone portion can be lowered or left off

Recommendation Formulation [25] with AKTISIL PF 777: preferably for blasted steel, high corrosion protection at scribe, early hardness development, high sag resistance

Formulation [27] with AKTISIL AM: preferably for blasted steel, good leveling

Formulation [42] with AKTISIL AM: preferably for non-blasted steel, excellent adhesion, reduced delamination around a scribe

Mixing The preparation of component A was realized by dissolver with adapted bead mill after predispersion by grinding (15 min, 8 m/s).

Application Spraying by air pressure, single-layered with a dry film thickness of 80 µm

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Technical Data	Solids content (m/m)	%	67	67	67
	PVC	%	34	34	34
	VOC	g/l	430	430	425
Properties	Fineness of grind	µm	5	5	5
	Sedimentation comp. A. 60 d / 23°C		no	no	no
	Dynamic viscosity A+B 0.1 s^{-1}, 23°C	Pa·s	49.8	3.8	6.6
	Dynamic viscosity A+B 1000 s^{-1}, 23°C	Pa·s	0.29	0.32	0.29
	Pendulum hardness after 48 h	s	70	48	35
	after 336 h	s	119	113	88
	Cross-cut test (2 mm after tape tear-off)		0	0	0
	Cold-rolled steel, Sa 2½, blasted medium (G) according to ISO 8503-1				
	Salt spray test DIN EN ISO 9227 NSS, 1000 h				
	Rating according to DIN EN ISO 4628 part 2-5 and 8				
	Degree of blistering		1 (S2)	0	---
	Degree of rusting		0	0	---
	Degree of cracking		0	0	---
	Degree of flaking		0	0	---
	Degree of corrosion around a scribe	mm	0.1	0.4	---
	Degree of delamination around a scribe	mm	12	15	---
	Cross-cut test (2 mm after tape tear-off)		0	0	---
	Humidity test DIN EN ISO 6270-2 CH, 1000 h				
	Rating according to DIN EN ISO 4628 part 2-5 and 8				
	Degree of blistering		0	0	---
	Degree of rusting		0	0	---
	Degree of cracking		0	0	---
	Degree of flaking		0	0	---
	Degree of corrosion around a scribe	mm	< 0.5	< 0.5	---
	Degree of delamination around a scribe	mm	0	0	---
	Cross-cut test (2 mm after tape tear-off)		0	0	---

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R 24301.1		[25]	[27]	[42]
Cold-rolled steel, non-blasted, Q-Panel R 48				
Salt spray test DIN EN ISO 9227 NSS, 1000 h				
Rating according to DIN EN ISO 4628 part 2-5 and 8				
Degree of blistering		---	---	0-1 (S2-3)
Degree of rusting		---	---	0
Degree of cracking		---	---	0
Degree of flaking		---	---	0
Degree of corrosion around a scribe	mm	---	---	1.3
Degree of delamination around a scribe	mm	---	---	8
Cross-cut test (2 mm after tape tear-off)		---	---	0
Humidity test DIN EN ISO 6270-2 CH, 1000 h				
Rating according to DIN EN ISO 4628 part 2-5 and 8				
Degree of blistering		---	---	0
Degree of rusting		---	---	0
Degree of cracking		---	---	0
Degree of flaking		---	---	0
Degree of corrosion around a scribe	mm	---	---	< 0.5
Degree of delamination around a scribe	mm	---	---	0.8
Cross-cut test (2 mm after tape tear-off)		---	---	0

Suppliers

(1) Westlake
(2) Elementis
(3) Nusa Iberica
(4) Byk Chemie
(5) Venator Materials Corporation
(6) Heubach
(7) HOFFMANN MINERAL
(8) BASF
(9) Evonik Industries

More information on this topic:

Neuburg Siliceous Earth for Medium Solid Epoxy Coatings

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