

### Product description:

1-component primer based on epoxy resin ester, with zinc phosphate, solvent-based. Easy-to-use anti-corrosion primer with a portion of active pigments.

Can also be used on galvanized surfaces or other non-ferrous metals. For this seek advice on a case by case basis.

### Applications:

Suitable for steel constructions of any kind, e.g. in the chemical and machine building industries.

### Hardener:

Not applicable

### Article numbers, colour:

E.g. KG96-0039, red brown  
Other colour shades on request.

### Technical specifications (relating to the mixture):

Flash point:	above +23 °C
Viscosity:	intrinsically viscous
Density:	approx. 1.55 g/ml
Mixture ratio:	---
Pot life:	---
Dry film thickness (DFT):	60-80 µm
Solid density:	approx. 60 %
Tinctural power (theoretical):	approx. 6.5 m <sup>2</sup> /kg at 60 µm DFT
VOC value:	approx. 346 g/l
Organic solvent content:	approx. 22 % by weight
Temperature stability:	max. +200 °C, dry heat

The Technical Data indicated are subject to variations depending on colour shade and production process.

### Drying times:

Dust-dry:	after approx. 50 minutes
Fast to handling:	after approx. 5 hours
Ready for rework:	after approx. 12 hours (spray coating)

The values indicated apply to the dry film thickness at (standard atmosphere) +20 °C and 55 % relative humidity.

### Working temperature / humidity of air:

+5 °C to +35 °C

The substrate temperature must be at least 3 °C above the dew point of the ambient air.

The relative humidity of air should not exceed 85 %.

### Thinner:

VESTOCOR thinner VK14-, also for tool cleaning.

### Subsequent coats:

Depending on requirements VESTOCOR products based on: VESTOLUX, VESTOPLAST, VESTOPUR

### Substrate preparation:

In any case, adhesion-reducing residues such as oil, grease, dust, mill scale, etc. are to be removed.

**Steel:** abrasive blasting to preparation grade Sa 2.5 of the norm DIN EN ISO 12944-4 is recommended.

**Zinc coated steel:** slight abrasive blasting (sweeping) is recommended to remove all contaminants, even zinc corrosion products.

### Applying:

**Brush/roller:** processing in delivery state. Use short-haired lamb-skin rollers for roller application.

### High-pressure spray coating:

Processing is with a spray viscosity of 22-30 sec./4 mm.  
Air pressure: 4.0-5.0 bar  
Nozzle: 1.0-1.5 mm

**Airless spray painting:** Generally in delivery state, if required add 5 weight per cent VESTOCOR thinner as a maximum.

Minimum pressure: approx. 120 bar  
Nozzle: approx. 0.21-0.48 mm

### Repair of transport and installation damages:

Recommended surface preparation: abrasive blast flaws to preparation grade Sa 2,5 of the DIN EN ISO 12944-4. Repair with VESTOLUX 1K-EPE-Grund KG96-. If - for technical or environmental reasons - only a power rust removing to PSt3 acc. to DIN EN ISO 12944-4 is possible, repair can also be done with VESTOPOX 1K-EPE primer KG96.

### Storage and identification according to hazardous substance/workplace safety regulations:

For the identification according to valid hazardous substance regulations see the associated Material Safety Data Sheets and labels.

### Storage life:

**Main component:** approx. 12 months in case of proper storage of non-opened drums at +5 °C to +25 °C.

### Safety and protection precautions:

When processing note the safety and health at work rules from the trade association, BGR 500, chapter 2.29, as well as the relevant EC Material and Safety Data Sheets. In liquid state, the products are classified to be hazardous to waters, and therefore they must not come into waters.

Information and recommendations in this document are based on today's state of our knowledge and are intended to inform purchasers. They do not exempt purchasers to check the products for their suitability and application. We guarantee a perfect quality within the scope of our general terms and conditions of business. All previous Technical Data Sheets cease to be valid.