

## Description

Quick-drying epoxy shop-primer with corrosion inhibitors based on zinc phosphate. Direct-to-metal application. Provides anticorrosive protection of structures up to 6 months.

## Recommended use

In-process anticorrosive protection of cleaned steel sheets and other metal structures during manufacturer painting at automated lines on plant.

Coated pieces can be exposed to thermal cutting, semi-automatic and automatic high-velocity welding without increasing in weld porosity.

The primer is recommended for application as an independent coating or in complex coating systems with the ISOLEP-primer (TU 2312-067-12288779-2008) and ISOLEP-mastic (TU 20.30.12-065-12288779-2017) primer-enamel of the VMP Holding JSC, and other epoxy, polyurethane, vinyl, chlorinated-rubber and acrylic materials.

## Certificates, Approvals

State registration certificate No. RU.66.01.40.015.E.000200.10.18 dated 31.10.2018.  
Expert statement by the JSC "Ural Institute of Welding".

## Technical data

	Coating	
Color		red-brown
Appearance		matt
	Primer	
Density of the primer, g/cm <sup>3</sup>		1.2±0.1
Pot life at temperature 20 °C, hours, not less than		24
Viscosity according to viscometer with 4 mm nozzle diameter at temperature (20.0±0.5) °C, s		12-20
Drying time to 1 degree (GOST 19007) at temperature 20 °C, minutes, not more than		5
Dry film thickness, µm		15-30
Wet film thickness, µm		50-95
Theoretical spreading rate of one-layer coating, g/m <sup>2</sup>		55-110
Non-volatile matter content		
by volume, % volume		32
by mass, % mass		45-50

## Surface preparation

- to degrease metal surface to 1 grade according to GOST 9.402;
- to do abrasive-blast cleaning to 2 grade according to GOST 9.402 or Sa 2 1/2 according to ISO 8501-1, surface roughness of 25-60 µm;
- to remove dust.

Before applying the next project coating system, the surface shall be free from dust, degreased, if necessary, to the first degree according to GOST 9.402; local cleaning to P Sa 2 – Sa 2 1/2 degree according to ISO 8501-1, if any corrosion or other defects

## Application

- mix the primer base to a homogeneous condition before application;
- add a hardener to the primer base in proportion as the label indicates, with constant stirring, mix thoroughly, dilute to working viscosity, if necessary, with SOLV-ES thinner.

The proportion of the base and hardener by mass 2.9:1, by volume 2:1, respectively.

The pot life of the primer (after mixing the components) at air temperature (20±0.5) °C is at least 24 hours (periodic stirring is recommended).

The primer is recommended to be applied in plant conditions at temperature from plus 5 to plus 40 °C and relative air humidity not exceeding 85 %.

Temperature of the painting surface shall be above the dew point by at least 3 °C.

**Hardening time of the ISOLEP-eps primer at dry film thickness of 30 µm**

Surface temperature	10 °C	20 °C	30 °C	40 °C
to tack disappearance	12 min	4 min	2 min	1 min
to turning over, handling*	30 min	12 min	6 min	4 min

The mentioned hardening time is approximate for practical painting. The hardening time depends on air and surface temperature and relative air humidity.

**Time for overlapping the primer with ISOLEP-mastic and ISOLEP-primer coating materials.**

Air temperature, °C	Minimum time	Maximum time
From 20 to 25	8 hours	Unlimited

Recommended application:

**Automated line**

Recommended thinner no thinner  
Pressure 10 - 15 MPa (100 - 150 bar)  
Nozzle diameter 0.011" - 0.015"

**Brush/roller**

small area, for painting  
no thinner

**Equipment cleaning**

SOLV-ES (TU 2319-080-12288779-2009)  
SOLV-EP (TU 20.30.22-106-12288779-2018)  
oil solvent, P4, 646

**Storage and handling**

The primer is delivered in packages: the base and hardener packed in metal buckets and metal cans respectively depending on the package weight.

Storage conditions – in accordance with GOST 9980.5 (at air temperature from minus 40 to plus 40 °C). The material components shall be stored away from heat sources, the container shall be protected from atmospheric condensation and direct sunlight.

The shelf life of the base is 24 months, hardener – 12 months starting with the manufacture date.

**Precautions**

When working, one shall observe the existing sectoral standard norms and requirements and safety measures as specified on the package label.

One shall use personal protective equipment (goggles, face masks and respirators), avoid inhalation of thinners and contact of the material or its components with skin, eye mucosa, respiratory channels; use inside the premises is allowed only in case sufficient ventilation is provided.

The material and its components (the base and hardener) are fire-hazardous!

*The information is of general character, without consideration to the object specific nature. Use of materials for other purposes not specified here or in case other influencing factors are present shall be approved by the VMP Holding CJSC in writing. In case of absence of such approval the manufacturer is not held liable for the improper use of the material and the buyer falls from the right to present claims connected with the coating quality.*



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