

Technical Data

MUKI EPS



Product description

Muki EPS is a two-pack epoxy based quick drying primer.

Recommended use

1. As a preconstruction primer on blast cleaned steel surfaces in automatic shoppriming plants to protect steel during transport, storage and production.
 2. As an Epoxy primer for application in automatic shoppriming plants as a primer in paint system for corrosion classes, ISO 12944 C2 to C4.
 3. As a Holding primer for temporary protection of blast cleaned steel surfaces.
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Film thickness and spreading rate

	Minimum	Maximum	Typical
Film thickness, dry (μm)	15	50	20
Film thickness, wet (μm)	60	200	80
Theoretical spreading rate (m^2/l)	16,7	5	12,5

Comments

See Typical paint system for recommendations.

Physical properties

Colour	Grey, Red
Solids (vol %)*	25 \pm 2
Flash point	-5°C \pm 2 (Setaflash)
VOC	610 gms/ltr UK-PG6/23(97). Appendix 3
Gloss	Flat
Water resistance	Very good
Abrasion resistance	Very good
Solvent resistance	Very good
Flexibility	Good

*Measured according to ISO 3233:1998 (E)

Surface preparation

All surfaces should be clean, dry and free from contamination. The surface should be assessed and treated in accordance with ISO 8504.

Bare steel

Cleanliness: Blast cleaning to Sa 2½ (ISO 8501-1:1988). Roughness: using abrasives suitable to achieve grade Fine to Medium S/G (30-85 μm , Ry5) (ISO 8503-2)

Other surfaces

The coating may be used on other substrates. Please contact your local Jotun office for more information.

Condition during application

The temperature of the substrate should be minimum at least 3°C above the dew point of the air, temperature and relative humidity measured in the vicinity of the substrate. For application in shopprimer plants the recommended steel temperature is 30-40°C.

Application methods

Spray Use airless spray. Conventional spray recommended for touch-up purposes.
Brush Recommended for touch-up purposes.

Application data

Mixing ratio (volume)	18 parts Comp. A (base) to be mixed thoroughly with 0.5 part Comp. B (curing agent).
Pot life (23°C)	24-36 hours (Reduced at higher temp.)
Thinner	Jotun Thinner No. 17/3 (For use in shopprimer plants use Jotun Thinner No. 3 for fast evaporation and Jotun Thinner No. 17 for slow evaporation).
Guiding data airless spray	
Pressure at nozzle	10-15 MPa (100-150 kp/cm ² , 1500-2100 psi).
Nozzle tip	0.38-0.53 mm (0.015-0.021").
Spray angle	40-95°
Filter	Check to ensure that filters are clean.

Drying time

Drying times are generally related to air circulation, temperature, film thickness and number of coats, and will be affected correspondingly. The figures given in the table are typical with:

- * Good ventilation (Outdoor exposure or free circulation of air)
- * Typical film thickness
- * One coat on top of inert substrate

In shopprimer plants:

Substrate temperature	23°C	40°C
Surface dry	1-3 min	20-40 sec
Through dry	4 min	1-2 min
Cured	7 d	3 d
Dry to recoat, minimum	7 h	3 h
Dry to recoat, maximum ¹		

As Holding Primer

Substrate temperature	5°C	10°C	23°C	40°C
Surface dry	15 min	10 min	1-3 min	0,3-0,6 min
Through dry	20 min	15 min	4 min	1-2 min
Cured	21 d	14 d	7 d	3 d
Dry to recoat, minimum	15 h	10 h	7 h	3 h
Dry to recoat, maximum ¹				

1. The surface should be dry and free from any contamination prior to application of the subsequent coat.

The given data must be considered as guidelines only. The actual drying time/times before recoating may be shorter or longer, depending on film thickness, ventilation, humidity, underlying paint system, requirement for early handling and mechanical strength etc. A complete system can be described on a system sheet, where all parameters and special conditions could be included.

Typical paint system

As preconstruction primer:

Muki EPS 1 x 20-30 µm (Dry Film Thickness - measured on a smooth test panel).

As an epoxy primer in paint system for corrosion classes ISO 12944 C2-C4:

Muki EPS 1 x 25-40 µm (Dry Film Thickness - measured on a smooth test panel).

As holding primer

Muki EPS 1 x 20 µm (Dry Film Thickness).

Normally overcoated with a choice of systems based on acrylics, vinyls, epoxy resins or polyurethans.

Other systems may be specified, depending on area of use

Storage

The product must be stored in accordance with national regulations. Storage conditions are to keep the containers in a dry, cool, well ventilated space and away from source of heat and ignition. Containers must be kept tightly closed.

Handling

Handle with care. Stir well before use.

Packing size

18.5 litre unit: 18.0 litres Comp. A (base) in a 20 litre container and 0.5 litre Comp. B. (curing agent) in a 1 litre container.

Packing may vary from country to country according to local requirements.

Health and safety

Please observe the precautionary notices displayed on the container. Use under well ventilated conditions. Do not breathe or inhale mist. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water and medical attention sought immediately.

For detailed information on the health and safety hazards and precautions for use of this product, we refer to the Material Safety Data Sheet.

DISCLAIMER

The information in this data sheet is given to the best of our knowledge based on laboratory testing and practical experience. However, as the product is often used under conditions beyond our control, we cannot guarantee anything but the quality of the product itself. We reserve the right to change the given data without notice.

Footer - English

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