



# EPIGRIP H795

## PRODUCT TECHNICAL DATA

Revised 09/2014 Issue 15

### PRODUCT INFORMATION

#### PRODUCT DESCRIPTION

#### EPIGRIP H795 BLAST PRIMER FOR ALUMINIUM

**Material Type:** A 2-pack epoxy anti-corrosive primer

#### RECOMMENDED USE

For the priming of aluminium and other non-ferrous surfaces

#### ENDORSEMENTS

Approved by MOD/DRA to AFS No. 1789

#### RECOMMENDED APPLICATION METHODS

Airless Spray  
Conventional Spray  
Brush

**Recommended Cleanser/Thinner:** No 5

#### PRODUCT CHARACTERISTICS

**Flash Point:** Base : 29°C Additive : 28°C

**% Solids by Volume:** 38 ± 2% (ASTM-D2697-91)

**Pot Life:** 10 hours at 15°C 8 hours at 23°C

**Colour Availability:** Green

#### VOC

575 gms/litre determined practically in accordance with UK Regulations PG6/23  
575 gms/litre calculated from formulation to satisfy EC Solvent Emissions Directive  
452 gms/kilo content by weight from formulation, to satisfy EC SED

#### TYPICAL THICKNESS

Dry film thickness	Wet film thickness	Theoretical coverage
35 microns	92 microns	10.9 m <sup>2</sup> /ltr*

\* This figure makes no allowance for surface profile, uneven application, overspray or losses in containers and equipment. Film thickness will vary depending on actual use and specification.

#### PRACTICAL APPLICATION RATES - MICRONS PER COAT

	Airless Spray	Conventional Spray	Brush
Dry	35*	35	25
Wet	92	92	66

\* Maximum sag tolerance typically 50µm dry by airless spray.

#### AVERAGE DRYING TIMES

	At 15°C	At 23°C
To touch:	30 minutes	20 minutes
To recoat:	4 hours	4 hours
To handle:	24 hours	16 hours

*These figures are given as a guide only. Factors such as air movement and humidity must also be considered.*

#### RECOMMENDED TOPCOATS

Indefinitely overcoatable with epoxy systems provided the surfaces to be coated have been suitably cleaned. Where a high degree of gloss and colour retention is required overcoat with Resistex C137V2, Resistex C237, within 7 days at a minimum dft of 50 microns or in the case of C750V2 overcoat within 4 days. These overcoating times refer to achievement of optimum adhesion at 23°C and will vary with temperature.

For overcoating with alkyd systems, consult Sherwin-Williams for advice

#### PACKAGE

A two component material supplied in separate containers to be mixed prior to use.

**Pack Size:** 4 litre units when mixed

**Mixing Ratio:** 3 parts base to 1 part additive by volume

**Weight:** 1.27 kg/litre

**Shelf Life:** 2 years from date of manufacture or 'Use By' date where specified.



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#### **SURFACE PREPARATION**

##### **Ferrous Surfaces**

Blast clean to Sa2½ BS EN ISO 8501-1:2007. Average surface profile in the range 50-75 microns.

##### **Non Ferrous Surfaces**

For optimum adhesion all surfaces should be blasted using non-metallic abrasive and coated with H795 within 4 hours of blasting.

Under conditions of high humidity a shorter period will be necessary.

##### **All Surfaces**

Ensure surfaces to be coated are clean, dry and free from all surface contamination.

#### **APPLICATION EQUIPMENT**

##### **Airless Spray**

Nozzle Size	0.33mm (13 thou)
Fan Angle	80°
Operating Pressure	155kg/cm <sup>2</sup> (2200 psi)

The airless spray details given above are intended as a guide only. Details such as fluid hose length and diameter, paint temperature and job shape and size all have an effect on the spray tip and operating pressure chosen. However, the operating pressure should be the lowest possible consistent with satisfactory atomisation. As conditions will vary from job to job, it is the applicators' responsibility to ensure that the equipment in use has been set up to give the best results. If in doubt Sherwin-Williams should be consulted.

##### **Conventional Spray**

Nozzle Size	1.27mm (50 thou)
Atomising Pressure	3.5kg/cm <sup>2</sup> (50 psi)
Fluid Pressure	0.7kg/cm <sup>2</sup> (10 psi)

The details of atomising pressure, fluid pressure and nozzle size are given as a guide. It may be found that slight variations of pressure will provide optimum atomisation in some circumstances according to the set up in use. Atomising air pressure depends on the air cap in use and the fluid pressure depends on the length of line and direction of feed i.e. horizontal or vertical.

##### **Brush**

The material is suitable for brush application. Application of more than one coat may be necessary to give equivalent dry film thickness to a single spray applied coat.

#### **APPLICATION CONDITIONS AND OVERCOATING**

This material should preferably be applied at temperatures in excess of 10°C. In conditions of high relative humidity, ie 80-85% good ventilation conditions are essential. Substrate temperature should be at least 3°C above the dew point and always above 0°C.

At application temperatures below 10°C, drying and curing times will be significantly extended, and spraying characteristics may be impaired.

Application at ambient air temperatures below 5°C is not recommended.

In order to achieve optimum water and chemical resistance, temperature needs to be maintained above 10°C during curing.

##### **Overcoating with Water Based Materials**

Application of water based topcoats over inadequately cured H795 may cause poor wetting out of the topcoat. It is recommended that the H795 is allowed to cure for at least 24 hours at 23°C/48 hours at 15°C prior to overcoating with water based materials.

If overcoating is required prior to those intervals, solvent wiping of the H795 with C1 will improve the wetting characteristics.

If it is desired to overcoat outside the times stated on the data sheet, please seek advice of Sherwin-Williams.

#### **ADDITIONAL NOTES**

Drying times, curing times and pot life should be considered as a guide only.

The curing reaction of epoxies commences immediately the two components are mixed, and since the reaction is dependent on temperature, the curing time and pot life will be approximately halved by a 10°C increase in temperature and doubled by a 10°C decrease in temperature.

##### **Epoxy Coatings - Tropical Use**

Epoxy paints at the time of mixing should not exceed a temperature of 35°C. At this temperature the pot life will be approximately halved. Use of these products outside of the pot life may result in inferior adhesion properties even if the materials appear fit for application. Thinning the mixed product will not alleviate this problem.

The maximum air and substrate temperature for application is 50°C providing conditions allow satisfactory application and film formation. If the air and substrate temperatures exceed 50°C and epoxy coatings are applied under these conditions, paint film defects such as dry spray, bubbling and pinholing etc. can occur within the coating.

Numerical values quoted for physical data may vary slightly from batch to batch.

#### **HEALTH AND SAFETY**

Consult Product Health and Safety Data Sheet for information on safe storage, handling and application of this product.

#### **WARRANTY**

Any person or company using the product without first making further enquiries as to the suitability of the product for the intended purpose does so at their own risk, and Sherwin-Williams can accept no liability for the performance of the product, or for any loss or damage arising out of such use.

The information detailed in this Data Sheet is liable to modification from time to time in the light of experience and of normal product development, and before using, customers are advised to check with Sherwin-Williams, quoting the reference number, to ensure that they possess the latest issue.