HilonGuard 2510
Epoxy Primer/Tie Coat

Product Description

A quick drying two pack epoxy primer / tie coat.

Recommended Uses

For use as a holding primer for the protection of prepared steel prior to the application of a wide range of products.
Can also be used as a tie coat to enhance the adhesion between zinc silicate primers and anticorrosive primers.
Can also be used as repair paint, used for damaged areas caused by welding/cutting on shop primer.

Product Information

Color	EP5101 Red
Part B (Curing Agent)	EPC510
Volume Solids	48% ± 2%
Typical Film Thickness	30–50 microns dry (63–104 microns wet)
Theoretical Coverage	16.00 – 9.60 m^2/litre at 30 – 50 microns D.F.T.
Mix ratio	Part A (Base) : Part B (Curing Agent) =4:1 (By Volume)
Flash Point	27℃
VOC	294g/lt (EPA method 24)

Surface Preparations

All surfaces to be coated must be clean, dry and free from contamination. High pressure fresh water wash or fresh water wash, as appropriate, and remove all oil or grease, soluble contaminants and other foreign matter in accordance with SSPC–SP1 solvent cleaning.

Bare steel	Abrasive blast clean to Sa2 (ISO 8501–1:2007). Power tool cleaning to min. St2(ISO 8501–1:2007) may be acceptable, subject to exposure conditions.
Zinc Primers	The primer surface should be clean, dry and free from all contamination. Areas of breakdown, damage etc. should be prepared to the specified standard (eg. Sa2 (ISO 8501–1:2007)).
Others	Please consult Hilong representative.

Application

Application Condition	The temperature of the substrate should be at least 3℃ above the dew point of the air. Good ventilation is required in confined areas to ensure proper drying.
Mixing	Combine 4 parts of Base with 1 part of Curing Agent and mix thoroughly with a power agitator.
Induction Period	None
Pot Life (23℃)	8 hours (Reduced at higher temperature)
Thinner	THR100
Airless Spray	Recommended. Tip Range 0.53–0.84 mm (21–33 thou) Total output fluid pressure at spray tip not less than 170 kg/cm^2 (2420 p.s.i.)
Air Spray	Not applicable
Brush	Application by brush is recommended for small areas only. Multiple coats may be required to

	achieve specified film thickness
Roller	Application by roller is recommended for small areas only. Multiple coats may be required to achieve specified film thickness

Drying information

Temperature	5℃	15℃	25℃	35℃
Touch Dry	60 mins	40 mins	30 mins	20 mins
Hard Dry	15 hrs	11 hrs	7 hrs	1 hr

Overcoating data

Temperature	5℃		15℃		25℃		35℃	
	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.
HilonGuard 2100	24 hrs	Ext#	12 hrs	Ext#	6 hrs	Ext#	6 hrs	Ext#
HilonGuard 2200	24 hrs	Ext#	12 hrs	Ext#	6 hrs	Ext#	6 hrs	Ext#
HilonGuard 2500	24 hrs	Ext#	12 hrs	Ext#	6 hrs	Ext#	6 hrs	Ext#
HilonHolds 5110	24 hrs	Ext#	12 hrs	Ext#	6 hrs	Ext#	6 hrs	Ext#
HilonHolds 5120	24 hrs	Ext#	12 hrs	Ext#	6 hrs	Ext#	6 hrs	Ext#

Refer to the Guide – Definition and Abbreviations

Unit Size

20 litres unit: 16 litres part A (Base) in a 20 litres container, 4 litres part B (Curing Agent) in a 5 litres container

Storage

Must be stored in accordance with national regulations. Store in dry, shaded conditions away from sources of heat and ignition.

Health And Safety

Prior to use, obtain, consult and follow the Material Safety Data Sheet for this product concerning health and safety information, and apply and use the coating according to the national state of health and safety as well as environmental protection standards and regulations.

Important note

The information in this data sheet is not intended to be exhaustive, for your reference only. The information contained in this data sheet is liable to modification from time to time in the light of experience and our policy of continuous development. Please contact us and request the latest version prior to using the product.