

## ViterShield 178 HS Epoxy Primer/Finish

Product Description	A two pack epoxy, high solids, zinc phosphate primer or primer/finish for steelwork. High performance, low VOC coating to help meet SED requirements.				
Features & Use	<ul style="list-style-type: none"><li>Provides a high build single coat/two coat high performance system for steelwork</li><li>Exceptional sag resistance</li><li>Excellent cure speed and high build properties</li><li>Good resistance to undercutting from damaged areas</li><li>Overcoatable with most epoxy, acrylic or polyurethane coatings</li><li>Use as a base coat for most thin film intumescent coatings</li></ul>				
Approvals/ Certification	Please consult Axalta Coating Systems				
Finish	Matt				
Volume Solids	70 ± 2% (varies with colour)				
VOC Content	277 ± 20 g/litre (varies with colour)				
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage	
	Minimum	75 µm	107 µm	9.3 m²/litre	
	Maximum	280 µm	400 µm	2.5 m²/litre	
	Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated				
Drying Times	Applied to 100 microns DFT		+10°C	+23°C	+35°C
	Dust Free		2 hr	1 hr	30 min
	Hard Dry		6 hr	3 hr	1½ hr
	Overcoating	Minimum*	6 hr	3 hr	1½ hr
		Maximum	Indefinite if clean and sound		
	* See Product Notes Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation				
Colours	Red Oxide, Grey, White and shades to order				
Mix Ratio/ Product Code	Base	6178	5 parts by volume		
	Hardener	6400 003	1 part by volume		
Pot Life	3 hours at 23°C				
SG	1.48 – 1.52 kg/ltr mixed, varies with colour				
Storage Conditions	Store in dry, cool conditions and protect from frost				
Shelf Life	Minimum 12 months if stored as above in unopened containers				
Flash Point	23-60°C				

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<b>Surface Preparation</b>	<ul style="list-style-type: none"> <li>Blast clean to Sa2½ (ISO 8501-1:2007), surface profile 50-75 microns</li> <li>All surfaces to be coated should be dry and cleaned as necessary to remove all oil, grease, salts, weld flux or other contamination. Where necessary, remove weld spatter and grind smooth all sharp edges and weld seams</li> </ul>				
<b>Mixing</b>	Mix only in the proportions stated, mixing each component individually then together using a mechanical agitator. Agitate periodically during use to ensure product remains homogeneous.				
<b>Thinner</b>	<div>1031 Thinner</div> <div><b>Equipment Cleaner</b> 950 Thinner</div>				
<b>Application Conditions</b>	<p>Only apply in conditions of good ventilation which must be maintained during drying and curing. Do not apply when rain, mist, sleet or snow are imminent. During application and drying time of the paint coating, the surface should be dry, the Relative Humidity should not exceed 85% and the steel temperature should remain at least 3°C above the dew point. Only apply this product when the above conditions can be maintained throughout the critical application and drying/curing process. Paint temperature should ideally be at a minimum of 15°C.</p>				
<b>Application Methods</b>	<b>Method</b>	<b>Airless Spray</b>	<b>Conventional Spray</b>	<b>Brush</b>	<b>Roller</b>
		Yes	Yes	Yes	Yes
	<ul style="list-style-type: none"> <li>Airless Spray: Output fluid pressure at tip 2200 psi, Tip Size: 13 thou (0.33mm) for dft's 75-125um; 15-17 thou (0.38-0.43mm) for 125-280um.</li> <li>Thinning of the coating will reduce the build qualities</li> <li>Application by brush/roller will result in a reduced film thickness and is recommended only for small areas of touch up/remedial work</li> <li>Refer to Axalta Coating Systems '<b>Epoxy Application and Curing Notes</b>'</li> </ul>				
<b>Product Notes</b>	<ul style="list-style-type: none"> <li>May be overcoated with itself or other products from the ViterShield, ViterSeal or ViterThane range</li> <li>If overcoating with ViterThane PLV or PLS, allow a minimum of 12 hours at 23°C when the primer has been applied to 100 microns dft. Allow longer drying and overcoating times at higher dft's and lower temperatures</li> <li>The compatibility of overcoating should be confirmed prior to application</li> <li>Certain configurations of steelwork may mean that the primer will have to be applied in more than one coat to achieve the higher film thicknesses</li> <li>Whilst this product will display a matt finish at a dry film thickness of 75 microns, application to a dry film thickness above 125 microns will provide a low sheen finish, the degree of which may vary</li> <li>Do not apply or cure below 5°C, temperatures above 10°C recommended</li> <li>Like all epoxy coatings, this product will chalk on prolonged exterior exposure, the degree of which is subject to atmospheric conditions</li> </ul>				
<b>Health &amp; Safety</b>	<p>Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Axalta Coating Systems.</p>				

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