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Reference: n/a
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ViterShield SPF Epoxy Pr/Fin Semi-gloss

Product Description	**A two pack epoxy, mid-sheen primer/finish** for blast cleaned steelwork. Low temperature curing and high build airless spray capability.
Features & Use	• Low temperature curing (down to 0ºC) and low tendency to bloom • Use as an anticorrosive primer/undercoat or primer/finish for general structural steelwork • Good resistance to undercutting from damaged areas • Overcoatable with most epoxy, acrylic or polyurethane coatings • Use as a base coat for most thin film intumescent coatings
Approvals/ Certification	Please consult Axalta Coating Systems
Finish	Mid sheen
Volume Solids	60 ± 2% (may vary with colour)
VOC Content	421 ± 20 g/litre (varies considerably with colour)

Film Thickness Range And Coverage

	Dry Film Thickness	Wet Film Thickness	Theoretical Coverage
Minimum	75 µm	125 µm	8.0 m^2/litre
Maximum	200 µm	333 µm	3.0 m^2/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		+10ºC	+23ºC	+35ºC
Dust Free		1 hr	30 min	15 min
Hard Dry		4 hr	2 hr	1 hr
Overcoating	Minimum*	8 hr	4 hr	2 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 BS & RAL shades from our in-can tinting system
Mix Ratio/ Product Code	Base **3403 or 3321 (L)** 3 parts by volume Hardener **4050 077** 1 part by volume
Pot Life	8 hours at 23ºC
SG	1.54 – 1.58 kg/lt 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	23-60ºC

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Surface Preparation	• Blast clean to Sa2½ (ISO 8501-1:2007), surface profile 50-75 microns. • 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.
Mixing	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.
Thinner	1031 Thinner **Equipment Cleaner** 950 Thinner
Application Conditions	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 3ºC 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 15ºC.
Application Methods	**Method** / **Airless Spray** / **Conventional Spray** / **Brush** / **Roller** Yes / Yes / Yes / Yes • Airless Spray: Output fluid pressure at tip 2500-3000 psi, Tip Size: 15-21 thou (0.38-0.53mm) • For airless spray application at low temperatures, up to 5% by volume of 1031 thinner may be added to ensure achievement of a closed film • Application by brush/roller will result in a reduced film thickness and is recommended only for small areas of touch up/remedial work • Refer to Axalta Coating Systems '**Epoxy Application and Curing Notes'**
Product Notes	• Minimum overcoating with itself: allow a minimum 4 hours at 23ºC, when SPF has been applied to 75-100 dft • Minimum overcoating with 2p polyurethanes and non-iso (i.e. ViterThane PLV or PLS, or ViterSeal EA80): allow a minimum 6 hours at 23ºC, when SPF has been applied to 75-100 dft • Allow longer drying and overcoating times at higher dft's and lower temperatures • A minimum of 100 microns dft will be required to achieve a consistent solid appearance with white, pastel and other low opacity shades • Do not apply or cure below 0ºC, temperatures above 10ºC are recommended • Some shades may contain lead colourants and these are labelled SPF **(L)** • Like all epoxy coatings, this product will chalk on prolonged exterior exposure, the degree of which is subject to atmospheric conditions
Health & Safety	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.