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**TECHNICAL DATA SHEET**

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**BA018  
EPOTAN HB PRIMER**

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**DESCRIPTION****Product Description**

Two component, high volume solids, semi-gloss epoxy polyamide primer which contains zinc phosphate anticorrosive pigment. BA018 Epotan HB Primer can be used as an anticorrosive primer or as a monolayer for protection of metal surfaces under corrosive atmospheres. BA018 series yield semi-gloss films with good surface quality when applied as a monolayer.

**Intended Use**

- Can be used on indoor steel structures as a high volume solid, semi-gloss monolayer with good surface quality.
- BA018 series will chalk and discolour with direct outdoor exposure.
- Can be applied on carbon steel, aluminium, stainless steel and galvanized steel parts and accessories for OEM subindustries and for ACE machinery where UV exposure is limited.

**Characteristic Properties**

- Forms a continuous, defect free anticorrosive paint films over metal surfaces.
- When topcoated with 2K acrylic polyurethane paints form a highly durable paint system.
- Used as a part of duplex paint system over hot-dip galvanized (HDG), stainless steel and aluminium surfaces when pre-treated according to the methods described at application guidelines.

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**PRODUCT PROPERTIES****Color**

Grey, Black

**Gloss Level**

Semi Gloss (50-60 GU @60°, ISO 2813)

**Mixing Ratio**

Material is supplied in two containers as a unit.

Base (Component A) = BA018 : 6 by weight (3 by volume)

Hardener (Component B) = BB01Z005 : 1 by weight (1 by volume)

Thinner = TB00050 / TB0065 : 0-10 % by volume (depends on app. condition)

**Solids (by volume)**

64-68% (ISO 3233-1)

**Theoretical Coverage**Approximately 13.2 m<sup>2</sup>/L (50 microns dry film)  
Approximately 8.6 m<sup>2</sup>/kg (50 microns dry film)**Application Method**

Pneumatic Spray (conventional air spray or air assisted airless spray)

**Application Viscosity, 20°C**30-40 sec/ DC 4 conventional  
20-25 sec/DC 4 Air assisted airless spray**Pot life, 20°C**

8 hours after the mixture is prepared (at high paint temperature pot life decreases).

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**STORAGE and SAFETY INFORMATION****Storage**

Store in a well ventilated and dry conditions at temperatures between 5 - 40°C. The packaging should not be exposed to direct sunlight. The shelf lives of the products (base and hardener) are at least 12 months in unbroken original package, under mentioned storage conditions.

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See label for precautions. The user of this product is required to comply with the national statutory regulations for health, safety during transportation and at work and waste disposal. See the MSDS for detailed information.

**APPLICATION INFORMATION****Surface Preparation****Carbon steel surfaces;**

- Visible deposits of oil, grease, or other contaminants shall be removed as required by SSPC-SP 1.
- Abrasive blast cleaning to the requirements of ISO 8501-1: 2007 Sa2<sup>1/2</sup> or SSPC SP-10 / Nace No:2 is recommended as minimum.
- Surface profile ranging between 30 µm and 75 µm according to ASTM D 4417 Method B or C is recommended.
- All irregularities, burrs, slivers, slag and spatter on welds, sharp edges and corners shall conform to minimum grade P2 (ISO 8501-3).

**Carbon steel surfaces where sand-blasting cannot be performed;**

- Chemical conversion coating is recommended.
- Depending on the type of conversion coating, treated surface after the rinsing stage should not contain any visible oil, grease, dirt or other soluble contaminants.
- Pre-treated surfaces should be checked prior to painting against flash rust. Paint application should not be performed when the pre-treated surface is damp.

**Metal surfaces other than carbon steel (Hot-Dip galvanized, Aluminium and Stainless steel );**

- All bumps, runs, drips, and dross particles on the galvanized surface should be removed by grinding prior to blasting.
- Light brush-off blasting (sweep blasting) using non-metallic abrasive leaving a clean, rough and even pattern is recommended according to ASTM D 6386.
- Galvanized surfaces where sweep blasting cannot be performed should be surface treated as required by ASTM D 6386.
- Force drying hot dip galvanized surfaces for at least 2 hours at 160°C for efficient outgassing is recommended.
- Hot-dip galvanized surfaces must be clean and free of oil and grease before they are painted.

**Application Conditions**

Ambient temperature shall be above 5°C and relative humidity shall be below 85%. Surface temperature shall be a minimum of 3°C above the dew point. Adequate ventilation shall be provided in confined spaces to ensure proper drying.

Recommended application temperature (65% RH): 5°C - 40°C

**Product Preparation**

Material is supplied in two containers as a unit.

Base (Component A) = BA018

Hardener (Component B) = BB01Z005

Stir each component with power agitator well before. Then mix in a right proportion Base (Comp. A) with Hardener (Comp B), stir thoroughly with power agitator.

6 parts of Comp. A (BA018) to 1 part Comp. B (BB01Z005) (by weight)

3 parts of Comp. A (BA018) to 1 part Comp. B (BB01Z005) (by volume)

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**Application Method, 20°C**

Equipment Type	Conventional Air Spray	Air assisted Airless Spray
Thinner	TB00050 (slow) / TB0065 (fast)	
Dilution	up to 10% by weight	up to 5% by weight
Nozzle pressure	2-4 bar	Not less than 15Mpa
Nozzle size	1.8-2.0 mm	0.019-0.025"

**Drying Time, %65 RH**  
(50 microns dry film)

Surface temperature	5°C	10°C	20°C	40°C
Touch Dry	8 hours	4 hours	2 hours	<1 hour
Flash off (ambient)	1 hour	1 hour	30 mins.	20 mins.
Hard dry	30 mins, 80°C: metal temperature			

**Packaging**

Base (Component A) =	24 kg
Hardener (Component B) =	4 kg

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The effectiveness of our systems is based on many years' practical experience and laboratory research. We guarantee that the quality of the work performed in accordance with our systems meets the Kansai Altan standards, provided that our instructions are followed carefully and the work is performed in accordance with the requirements as to good craftsmanship. We decline any responsibility, if the final result is affected by factors beyond our control. The customer has to determine the suitability of the delivered products for the intended application by using the means which normally are at his/her disposal.

Issue Date: 19/04/2022  
Reference: TDS / BA018/ 02

(It is the user's responsibility to check that this sheet is up to date)