

## 2K-EP Varioprimer S 864

Rust-passivating adhesive primer, spray quality, two-component,  
universally recoatable, for interior and exterior use



### Field of application

As an adhesive primer in special spray quality for exterior and interior use, e.g., on zinc, galvanized steel, aluminum, copper pipes (heating pipes), coating plastics (BFS Leaflet No. 22), powder coatings, Coil Coating, Glasal, cement-bonded chipboards, melamine resin boards, wall tiles, load-bearing stove and two-component coatings, as well as on steel parts that are subject to high mechanical and chemical loads.

### Properties

- Two-component
- On an epoxy resin base
- Special spray quality
- Matt
- Rust passivating
- Extremely adhesion promoting
- Quick-drying
- Easy to apply
- For interior and exterior use
- High mechanical and chemical resistance
- Universally coatable with alkyd, acrylic, epoxy resin, PUR, polymerization paints

### Material description

Colors	Scala No.	Description
	—	0095 white
	75.03.12	7035 light gray
	90.03.30	7126 anthracite
	27.12.24	8101 red brown

Basecode color shades can be mixed with the Brillux Color System.

**Gloss grade** Matt

## Material description

<b>Base material</b>	Epoxy resin, solvent-based
<b>VOC</b>	EU limit value for this product (Cat. A/j): 500 g/l (2010). This product contains max. 500 g/l VOC. The specified VOC value refers to the ready-to-use mixture of base paint and hardener.
<b>Flashpoint</b>	+23 °C
<b>Density</b>	Approx. 1.31 g/cm <sup>3</sup>
<b>Packaging</b>	4 l combined container incl. hardener

## Use

<b>Mixing ratio</b>	3.5 parts by volume 2K-EP Varioprimer S 864 – component A – to 1 part by volume hardener – component B. This corresponds to approx. 5:1 parts by weight.
<b>Mixing</b>	Thoroughly mix the base paint and hardener in the specified mixing ratio. Then pour the mixture into another clean container and stir again thoroughly. Avoid inclusion of air during mixing. Do not mix freshly mixed material with residual material. Use the material immediately after the pre-reaction time, taking the pot life into consideration.
<b>Pre-reaction time</b>	After mixing, allow to pre-react for about 10 minutes.
<b>Thinning</b>	Ready to spray. Do not dilute before applying.
<b>Tinting</b>	All color shades can be mixed with one another.
<b>Compatibility</b>	Can only be mixed with similar materials and those stipulated in this data sheet.
<b>Application</b>	2K-EP Varioprimer S 864 can be applied using brush, roller, and spray application. This undiluted primer is preferably applied by spraying. For brush and roller application, we recommend using 2K-EP Varioprimer 865. More information on spray applications is provided in the "Spray data" table.
<b>Pot life (at +20°C)</b>	Approx. 8 hours. Higher temperatures reduce pot life. After end of pot life, to not thin material again, do not use any-more.
<b>Consumption</b>	Approx 120 ml/m <sup>2</sup> of the ready-to-use mixture per coating. Determine exact consumption by means of a test application on the object to be coated.
<b>Application temperature</b>	Do not apply at air and object temperatures below +8 °C and high humidity. An air and object temperature of +10 °C to +25 °C is ideal. Take the dew point temperature into consideration.
<b>Tool cleaning</b>	Clean tools immediately after use with Epoxy Thinner 854

## Use

### Spray data

Spray system	Nozzle	Spray angle	Supply air/air quantity	Material pressure/ material quantity	Thinning	Cross-spraying
High pressure	1.8 mm	–	–	3.5–4 bar	Undiluted	1½
Low pressure <sup>1)</sup>	Yellow front end <sup>2)</sup>	–	50–100%	Ring setting 6-8	Approx. 3%	1–1½
AirCoat <sup>3)</sup>	0.008-0.011 inch	20°-50°	approx. 3.5 bar (air)	180 bar	Undiluted	1–1½
Airless <sup>4)</sup>	0.008-0.014 inch	20°-50°	–	160–200 bar	Undiluted	1–1½

The data is based on substrate and ambient temperatures of +20 °C

<sup>1)</sup> Information relating to XVLP technology with Wagner FinishControl FC 3500 or FC 5000.

<sup>2)</sup> StandardSpray spray attachment (yellow) for all standard enamel paints and woodstains. Also keep the nozzle clean during application. Remove surface-dried paint material with a soft paint brush. Follow the equipment manufacturer's instructions.

<sup>3)</sup> Information relating to the use of AirCoat nozzles 09/40 (air cap green), e.g. for large-surface applications and nozzle 11/40 with otherwise unchanged settings.

<sup>4)</sup> Information relating to the use of FineFinish nozzles 408, 410 and 412 (TradeTip 3 – purple).

### Drying (+20 °C, 65 % relative humidity)

Recoat after approx. 6 hours. After 48 hours, a thorough sanding is required before recoating. Allow for longer drying time if the temperature is lower and/or the humidity is higher.

### Storage

Store in a cool and dry place. Reseal opened containers tightly.

### Declaration

**Product code** RE2.5  
Comply with the specifications in the current Safety Data Sheet.

**Substrate preparation**

The substrate must be solid, dry, clean, with good adhesiveness, load-bearing, and free from separating agents. Check existing coatings for their suitability, load-bearing capacity, and adhesive properties. Prepare zinc, galvanized surfaces by cleaning them with Universal Cleaner 1032 or with ammonia alkaline washing fluid (in accordance with BFS Leaflet No. 5, Paragraph 3.3). Clean aluminum and bare metal with Universal Cleaner 1032 and non-woven abrasive, then rinse thoroughly with warm water. Clean anodized aluminum in a wet sanding procedure with, e.g., Universal Cleaner 1032 and wet sand paper – 240 grain or finer – and thoroughly rinse several times with warm water. When treating aluminum, follow the instructions in BFS Leaflet No. 6. Prepare plastics in accordance with BFS Leaflet No. 22. For substrates where there is a possibility of dissolving or peeling, for example oil and enamel paints, we recommend applying a test coat. Remove defective and unsuitable coatings completely, and dispose of them in accordance with the applicable regulations. Thoroughly sand intact old coatings. Hazardous particles and vapors may be released while reworking or removing old paint coats, e.g. as a result of sanding, paint removal by heat gun, etc. Perform such work only in well ventilated areas and ensure the use of appropriate protective equipment (including respiratory protective equipment) as required. Pretreat the substrate in accordance with the requirements. Also see VOB Part C, DIN 18363, Section 3.

**Prime coat**

Depending on the type of structural component, requirement and choice, use 2K-EP Varioprimer S 864. Always apply two prime coats on exterior zinc or zinc-coated surfaces if alkyd resin enamel paints are to be used for the subsequent top coat. Cement-bonded particle boards should be coated in a sufficient quantity and full covering on all sides, including the cut surfaces.

**Intermediate and top coats**

Depending on the structural component, requirement and selection, continue buildup with alkyd, acrylic, epoxy resin, PUR or polymerized resin paints.

**Notes****Further recoating**

In order to achieve good adhesion with the subsequent coating without sanding, the following coat should be applied within 48 hours.

**Interior application**

Ensure proper ventilation during application and drying in interior areas.

**Primer on Coil Coating**

The suitability of Coil Coatings is to be evaluated on site on a case-by-case basis by means of a test coat.

**Primer on wooden surfaces**

For priming on wooden surfaces, we recommend using Impredur Primer 835.

**Implementation in brilliant and intense color shades**

Brilliant, pure intense color shades, e.g., in the yellow, orange, red, magenta and yellow green areas have a lower hiding power as a result of the pigments used. For critical color shades, we recommend applying a full-covering base coat to these areas in the corresponding base color shade (Basecode). In addition to the standard coating buildup, additional coats may be required.

**Further information**

Follow the instructions in the data sheets of the products used.

This Data Sheet is based on extensive development work and years of practical experience. The translation corresponds to the current German version, in compliance with the German laws, regulations, standards and guidelines. Its content does not constitute a contractual legal relationship. The user/buyer is not released from the responsibility of checking our products to ensure they are suitable for the intended application. In addition, our general terms of business apply.

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