



58 EPOXY PRIMER



PRODUCT INFORMATION BULLETIN

DESCRIPTION **Enviroline® 58** is an epoxy polyamide rust inhibitive primer designed for use as an undercoat for interior or exterior steel surfaces requiring an extended recoat window. **Enviroline 58** is an excellent holding primer with superior aged recoatability.

TYPICAL USE Steel structures, off-shore rigs, interior and exterior of tanks, rail cars, machinery, equipment or any ferrous substrate that requires a rust inhibitive holding primer. Excellent adhesion to fiberglass, galvanized steel, glazed brick, concrete, masonry and ceramic tile.

BENEFITS

- Excellent adhesion
- Excellent holding primer
- Spray, roller or brush applied
- Rust inhibiting
- Excellent aged recoatability
- Excellent corrosion resistance

TECHNICAL DATA

Weight (lbs/gal): 10.8	Pot Life (@77° F): 12 hours
Volume Solids: 58%	VOC (mixed lbs/gal): < 2.80
Color: Tan	VOC (mixed g/l): < 340
Flash Point: >80° F	Recommended Thickness: 2-3 mils DFT

Temperature Resistance:
 Non-Immersion, Dry Heat: 250° F (121° C) – may discolor above 140° F (60° C)
 Continuous immersion temperature resistance is dependent on particular reagent exposure. Consult your Enviroline representative.

COVERAGE **Theoretical Coverage*:** 930 sq. ft per gallon @ 1 mil dry
 @ **2.5 mils:** 372 sq. ft. per gallon
**When ordering product, make allowances for any loss due to overspray, surface irregularities, etc. (approx. 15 – 20%).*

MINIMUM DRY TIME 77° F and 50% relative humidity, ASTM D 1640:
To Handle: 2.5 hours
To Recoat: 3.5 hours

Maximum Recoat Time: 90 days

CURE SCHEDULE **Full Cure:** 7 days

SURFACE PREPARATION All surfaces must be clean and dry, free of dust, dirt, oil or other foreign matter. Best results are obtained when steel surfaces are abrasive blasted to SSPC SP-10/Nace No. 2 or Swedish Standard Sa2½, Near White Metal finish with a minimum 1-2 mil angular profile. See Enviroline Technical Services Department for additional information.

APPLICATION EQUIPMENT May be brush (natural bristle) or roller (short nap) applied but spray application is preferred. For airless spray, use a 0.019-0.025" tip. Adjust pressure as needed. Use clean short nap synthetic roller. New rollers should be thoroughly wet with Enviroline 76T Thinner and spun rigorously to remove loose fibers. Consult Enviroline for more information.

MIX RATIO 3:1 by volume.

APPLICATION CONDITIONS Apply at 5° F (3° C) above dew point. Use the following chart for preferred temperature and humidity conditions.

	Coating	Substrate	Ambient	Humidity
Preferred	60-90° F	60-90° F	60-90° F	N/A
Minimum	50° F	50° F	50° F	5° above dew point

HANDLING	Store at moderate temperatures (65-85° F) prior to application for ease of handling and mixing.
THINNING	Thin only if necessary with Enviroline 76T Thinner. Use up to one half pint per gallon.
PRE-HEATING	Not needed for Enviroline® 58 .
MIXING	Mechanically pre-mix each component one minute; then mix combined compound with mechanical mixer at low speed for 15 minutes. Enviroline custom designed mixing blade is recommended. Consult your Enviroline representative for more information.
CLEAN UP	Clean immediately with methyl ethyl ketone (MEK) or methyl isobutyl ketone (MIBK).
PACKAGING	One unit forms approximately 4 gallons consisting of two components: Resin: 5 Gallon Pail Hardener: 2 Gallon Pail
SHELF LIFE	2 years when stored at 75° F (24° C) unopened.
SHIPPING	F.O.B. Pompano Beach, Florida for domestic shipments, Ex-Works Pompano Beach for international shipments.
SAFETY	This product is for industrial use only and should be installed by qualified coating and lining specialists. Consult Material Safety Data Sheets for important health and safety information prior to use.

10/04*

**Enviroline continuously strives to improve its data sheets for the benefit of all users. The owner/applicator is responsible for obtaining the most recent Product Information Bulletin prior to the purchase or application of material.*