DEP 100-20

2K EP primer, matt

Technical information Version
(1.0) 02/26

Beschreibung

Areas of application

Chromate-free 2K zinc phosphate epoxy resin primer for steel, galvanised steel, aluminium, GRP and mineral substrates. Also suitable as a primer coat for chemical protection and underwater coats, as well as an intermediate coat for EP zinc dust primer coats.

Core data

Properties

Delivery viscosity	Thixotrope	
Binder	Epoxy resin	
Density	Approx. 1.5 kg/l	
Solid state	68-72% by weight	
Mixing ratio	5 : 1 by weight (DEP 950-15) 3 : 1 by volume (DEP 950-15)	
Temperature resistance	Constant exposure:	150 °C
	Short-term exposure:	180 °C
Pot life	7-9 h at 20°C	
Gloss level	10 - 20 % / 60° (matt) - DIN 67 530	
Storage life	Store in tightly closed original container for 3 years at 5 - 25°C.	
VOC	33.82 %	
Processing temperature	From +10° C and up to 80% relative humidity	

Substrate / Processing

Substrates

Iron, steel
Clean, sand where necessary (remove rust, scale, rolling skin) and degrease with silicone remover
Zinc
Ammoniacal wetting agent zinc cleaner
Aluminium
Clean, sand and degrease with silicone remover

Application

Painting / Rolling

Pressure (bar)	Nozzle	Spray coats	Dilution
–	–	–	5 - 10 %

Air / gravity-feed gun

Pressure (bar)	Nozzle	Spray coats	Dilution
–	1.5 - 1.8 mm	2 - 3	20 - 25 %

HVLP

Pressure (bar)	Nozzle	Spray coats	Dilution
2.5 - 3 bar	1.5 - 1.8 mm	2 - 4	20 - 25 %

Airless

Pressure (bar)	Nozzle	Spray coats	Dilution
120 - 150 bar	0.28 - 0.33 mm	1 - 2	10 - 15 %

Drying at 20 °C

Dust-dry (TG1)	After approx. 45 - 55 minutes
Touch-dry (TG4)	After approx. 4 - 5 hours
Ready for installation (TG6)	After approx. 10 - 12 hours
Ready for overpainting	After approx. 1 hours

Drying at 60 °C

Ready for installation (TG6)	After approx. 45 minutes

Recoatable after 1 h (20°C) at the earliest and after 3 days at the latest.
If drying takes longer than 3 days, intermediate sanding is required.

Structure

Recommended structure
Iron, steel:
Primer --> DEP 100-20 (coat thickness: 50-70 µm)
Top coat -->Various Dold 1K and 2K top coats

Zinc:
Primer --> DEP 100-20 (coat thickness: 50-70 µm)
Top coat -->Various Dold 1K and 2K top coats

Aluminium:
Primer --> DEP 100-20 (coat thickness: 25-30 µm)
Top coat -->Various Dold 1K and 2K top coats

Coverage

3.8 – 4.2 m^2/kg
(with a dry coat thickness of 50 µm)

Tool cleaning

Clean tools immediately after use with nitro thinner.

Information

Hazard warnings

For further information see the corresponding EU safety data sheet.

Important

Dilution
F 6290 Universalverdünner (universal thinner)
F 8096 Nitro-Universalverdünner (universal cellulose thinner)
Up to 25% depending on type of application

Further properties

- High level of corrosion protection
- Can be electrostatically processed
- Excellent chemical and mechanical resistance
- Can be used to insulate thermoplastic substrates
- Adhesion (DIN 53 151)
  Steel: Cross-cut test 0 (very good)
  Zinc: Cross-cut test 0 (very good)
  Aluminium: Cross-cut test 0 (very good)

Quality and environment

swiss quality

Dold AG was founded on August 01, 1921 by Hans Dold in Wallisellen. Until Dold is still located at the same site and is one of the leading paint and varnish manufacturers in paint manufacturers in Switzerland. In Wallisellen, Dold AG develops and manufactures its innovative range of paints and varnishes for the construction painter as well as for industrial customers.

Swiss paint and varnish factory certified according to ISO 9001 / 14001 / 45001. Dold AG is one of the few one of the few paint and varnish factories which not only has its quality management, management, but also its environmental management system, as well as the occupational safety and health protection processes have been certified. These certifications are a clear commitment for Dold AG towards all its commitment to all its stakeholders.

Environmentally friendly products are a concern for DOLD. The foundation KMU Clima confirms Dold AG's contribution to voluntary climate protection. For this concern all direct emissions of CO2 in form of electricity, heating and mobility are compensated by DOLD to a reforestation project in Uruguay. This is a long-term contribution to climate protection and for the sake of the environment.