

DOCO POX PRIMER 1000

Kansai Helios Epoxy 51 universal primer

Technical information Version

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Especially for railway vehicles and industrial applications: 2-component epoxy resin/zinc phosphate primer with polyaminoamide hardener. Impresses with first-class corrosion protection, high abrasion value and dry film thicknesses of 40-150 µm. DB approval in accordance with DBS 918300, sheet 3.

Beschreibung

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| Areas of application | <ul style="list-style-type: none"> - 2-component epoxy resin/zinc phosphate primer coating - Approvals: DB approval according to TL 918300, sheet 3 - With polyaminoamide hardener - Excellent corrosion protection properties - High abrasion value - Dry film thickness 40 - 150 µm |
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Core data

Properties	Delivery viscosity	Thixotrope
	Density	Approx. 1.34 kg/l
	Solid state	Approx. 68 % by weight Approx. 51 % by volume
	Mixing ratio	5 : 1 by weight with DOCO POX Hardener 1000/5100 Stir in the hardener component mechanically
	Gloss level	Matt
	Shades (stock shades)	RAL 3012, RAL 7035, NCS S 0500-N
	Storage life	Store in well-sealed original container for 2 years at 5 - 25°C.
	Processing temperature	Optimum processing temperature 18 - 28 °C Ideal air humidity during application 40 - 60 % r.h. Maximum humidity for drying 80 % r.h.

Substrate / Processing

Application	Material pressure (bar)	Atomizer pressure (bar)	Nozzle (mm)
Compressed air (cup gun)	3	–	≥ 1.6
Compressed air (diaphragm pump)	2.5 – 3.5	–	≥ 1.3
Airmix	1.8 – 3.0	–	≥ 0.33

Dilution	Viscosity (s)	Addition (%)	Thinner
Compressed air (cup gun)	40 – 50 (DIN 4 mm)	–	DOCO POX Thinner 9000
Compressed air (diaphragm pump)	45 – 60 (DIN 4 mm)	–	DOCO POX Thinner 9000
Airmix	16 – 20 (DIN 6 mm)	–	DOCO POX Thinner 9000

Drying	Forced drying	
	Flash-off conditions	Ca. 20 Min / 20 °C
	Drying conditions	Ca. 60 Min / 75 °C
	Drying at 20°C	
	Dust dry	Ca. 40 Min
	Touch-dry	Ca. 150 Min
	With a coating thickness of 60 µm TSD	

Structure	Recommended substrates
	Steel e.g. S 355 J 2 G 3: Blast cleaning, standardised purity grade Sa 2 1/2 ISO 8501-1 or grinding (120/150).
	Aluminium e.g. EN- AW-6005: Chemical pre-treatment, e.g. fluorite process, open-pore anodising, blasting with corundum or grinding (P80).
	Chrome steel e.g. 1.4318: Blasting with corundum or grinding (P80)

Recommended fillers
DOCO PUR Filler 4000 / DOCO POX Primer 1000

Recommended top coats
DOCO POX Iron Mica 5100 / DOCO PUR Topcoat 5000
DOCO PUR Basecoat 6000 / DOCO PUR Basecoat 6100
DOCO PE Putty 9900 / DOCO PE Putty 9920

Coverage	130 g/m ² / 50 µm TSD/DFT
Tool cleaning	Immediately wash out thoroughly with DOCO POX Thinner 9000.

Information

Important	▪ See work instructions for the respective users and projects. ▪ Viscosity specifications may vary slightly depending on the device type. ▪ This information is based on experience. As we have no influence on processing, we can only guarantee the consistent quality of our products. Subject to change without notice.
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Quality and environment



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.

The above information is for general guidance only. The working conditions beyond our control and the large number of different substrates mean that no claims can be made on the basis of this information. In case of doubt, we recommend that you carry out sufficient tests yourself. A guarantee can only be given for the consistently high quality of our products. All previous editions of this data sheet hereby lose their validity.