

ViterShield 177 Epoxy Primer/Finish

Product Description	An economic two pack epoxy zinc phosphate primer or primer/finish for steelwork.				
Features & Use	<ul style="list-style-type: none"> • Provides a high build single coat/two coat high performance system for steelwork • Excellent cure speed and high build properties • Good resistance to undercutting from damaged areas • Overcoatable with most epoxy, acrylic or polyurethane coatings • Use as a base coat for most thin film intumescent coatings • Not recommended for coastal exposure without overcoating 				
Approvals/ Certification	Please consult Axalta Coating Systems				
Finish	Matt				
Volume Solids	64 ± 2% depending on colour				
VOC Content	360 ± 20 g/litre (varies considerably with colour)				
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage	
	Minimum	75 µm	117 µm	8.5 m ² /litre	
	Maximum	175 µm	273 µm	3.7 m ² /litre	
Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated					
Drying Times	Applied to 75 microns DFT	+10°C	+23°C	+35°C	
	Dust Free		2 hr	1½ hr	
	Hard Dry		8 hr	4 hr	
	Overcoating	Minimum*	10 hr	6 hr	4 hr
		Maximum	Indefinite if clean and sound		
* See Product Notes Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation					
Colours	Red Oxide (6177 004), Light Grey (6177 002) approx. RAL7040, Caspian Grey (6177 005) approx. BS00A09, White (6177 001), Buff (6177 003)				
Mix Ratio/ Product Code	Base	6177	4 parts by volume		
	Hardener	6400 009	1 part by volume		
Pot Life	8 hours at 23°C				
SG	1.50 kg/lit mixed, varies with colour				
Storage Conditions	Store in dry, cool conditions and protect from frost				
Shelf Life	Minimum 12 months if stored as above in unopened containers				
Flash Point	23-60°C				

ViterShield 177 Epoxy Primer/Finish

Surface Preparation	<ul style="list-style-type: none"> • Blast clean to Sa2½ (ISO 8501-1:2007), surface profile 50-75 microns. • All surfaces to be coated should be dry and cleaned as necessary to remove all oil, grease, salts, weld flux or other contamination. Where necessary, remove weld spatter and grind smooth all sharp edges and weld seams. 														
Mixing	<p>Mix only in the proportions stated, mixing each component individually then together using a mechanical agitator. Agitate periodically during use to ensure product remains homogeneous.</p>														
Thinner	1031 Thinner		Equipment Cleaner 950 Thinner												
Application Conditions	<p>Only apply in conditions of good ventilation which must be maintained during drying and curing. Do not apply when rain, mist, sleet or snow are imminent. During application and drying time of the paint coating, the surface should be dry, the Relative Humidity should not exceed 85% and the steel temperature should remain at least 3°C above the dew point. Only apply this product when the above conditions can be maintained throughout the critical application and drying/curing process. Paint temperature should ideally be at a minimum of 15°C.</p>														
Application Methods	<table border="1"> <thead> <tr> <th data-bbox="451 864 692 938">Method</th> <th data-bbox="692 864 938 938">Airless Spray</th> <th data-bbox="938 864 1184 938">Conventional Spray</th> <th data-bbox="1184 864 1337 938">Brush</th> <th data-bbox="1337 864 1490 938">Roller</th> </tr> </thead> <tbody> <tr> <td data-bbox="451 938 692 994"></td> <td data-bbox="692 938 938 994">Yes</td> <td data-bbox="938 938 1184 994">Yes</td> <td data-bbox="1184 938 1337 994">Yes</td> <td data-bbox="1337 938 1490 994">Yes</td> </tr> </tbody> </table>					Method	Airless Spray	Conventional Spray	Brush	Roller		Yes	Yes	Yes	Yes
	Method	Airless Spray	Conventional Spray	Brush	Roller										
	Yes	Yes	Yes	Yes											
<ul style="list-style-type: none"> • Airless Spray: Output fluid pressure at tip 2000 psi, Tip Size: 15-21 thou (0.38-0.53mm) • Thinning of the coating will reduce the build qualities • Application by brush/roller will result in a reduced film thickness and is recommended only for small areas of touch up/remedial work • Refer to Axalta Coating Systems 'Epoxy Application and Curing Notes' 															
Product Notes	<ul style="list-style-type: none"> • May be overcoated with itself or other products from the ViterShield, ViterSeal or ViterThane range • If overcoating with ViterThane PLV or PLS, allow a minimum of 12 hours at 23°C when the primer has been applied to 100 microns dft. Allow longer drying and overcoating times at higher dft's and lower temperatures • The compatibility of overcoating should be confirmed prior to application • Certain configurations of steelwork may mean that the primer will have to be applied in more than one coat to achieve the higher film thicknesses • Whilst this product will display a matt finish at a dry film thickness of 75 microns, application to a dry film thickness above 125 microns will provide a low sheen finish, the degree of which may vary • Do not apply or cure below 5°C, temperatures above 10°C recommended • Like all epoxy coatings, this product will chalk on prolonged exterior exposure, the degree of which is subject to atmospheric conditions 														
Health & Safety	<p>Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Axalta Coating Systems.</p>														

The information provided herein corresponds to our knowledge on the subject at the date of its publication. This information may be subject to revision as new knowledge and experience becomes available. The data provided fall within the normal range of product properties and relate only to the specific material designated; these data may not be valid for such material used in combination with any other materials or additives or in any process, unless expressly indicated otherwise. The data provided should not be used to establish specification limits or used alone as the basis of design; they are not intended to substitute for any testing you may need to conduct to determine for yourself the suitability of a specific material for your particular purposes. Since Axalta cannot anticipate all variations in actual end-use conditions Axalta makes no warranties and assumes no liability in connection with any of this information. Nothing in this publication is to be considered as a license to operate under or a recommendation to infringe any patent rights. This product is for professional use only.