



TDS

Issue Date: November 2021

Code: BUZZ2KArmour

Page 1 of 2

2K Epoxy Armour

Product Description	Two pack epoxy, rust stabilising primer formulated using a tar free resin system, with Corrosion Stabilising Pigment System and self-leaving glass flake.				
Features & Use	<ul style="list-style-type: none"> Moisture tolerant - can be manually applied to damp surfaces Very High Build, solventless product with excellent abrasion resistance Heavily resistant to most fuels and chemicals Applications include Corroded chassis, fuel tanks, rebuilding intricate parts finishes, swivel hub repair, 				
Finish	Gloss (when new - chalks on exterior exposure)				
Volume Solids	97% ± 2%				
VOC Content	Black: 41 ± 20 g/litre Buff: 34 ± 20 g/litre				
Film Thickness Range And Coverage	Typical	Dry Film Thickness	Wet Film Thickness	Theoretical Coverage	
		205 µm	213 µm	4.8 m ² /litre	
Practical coverage depends on the application method, surface roughness, profile, and the shape					
Drying Times	Applied to 213 microns WFT		+10°C	+18°C	+30°C
	Dust Free		8 hr	6 hr	4 hr
		Hard Dry		24 hr	16 hr
	Overcoating	Minimum	20 hr	15 hr	10 hr
		Maximum	3 days*	2 days*	2 days
*Full cure is a nominal 7 days at 18°C. Drying and recoating times are related to the substrate temperature					
Colours	Hardener Black, Base Buff				
Mix Ratio	Hardener 1 part by volume Base 1 part by volume				
Pot Life	60 min at 18°C				
SG	1.53 kg/lit mixed				
Storage Conditions	Store in dry, cool conditions and protect from frost				
Shelf Life	12 months if stored as above in unopened containers				
Flash Point	Above 60°C				

Surface Preparation	<ul style="list-style-type: none"> If required due to dirt/grease contamination, salt or chemical contamination, clean all surfaces with a water-soluble degreaser such as Fxdegreaser, wash down with clean fresh water and allow to dry before commencing main preparation Recommended substrate: Steel / Corroded steel Manual Preparation: Prepare using rust scrapers, chipping hammers, needle guns, wire brushes etc. to St2 standard of ISO 8501-1:2007 or equivalent. Where necessary, remove weld spatter and grind smooth all sharp edges and weld seams Wash down with clean fresh water and allow to dry before coating. Stripe coat prior to main coating exercise. Mechanical preparation: Blast clean to minimum Sa1 standard of EN ISO8501-1:2007 or equivalent with a surface profile of 50 to 75 microns. Wash down with clean fresh water and allow to dry New Steel: All mill scale must be removed prior to application Before coating all surfaces should be firm, clean dry and free from oil, grease, powdery flash rusting and other contamination 														
Mixing	Mix each component separately prior to use. thoroughly mix together for 2-3 minutes at medium speed, do not induce large amounts of heat from fast mixing. Always use a mechanical agitator. Ensure product is used only in 1:1 by volume ratio.														
Thinner / Cleaner	Buzzweld 1K multi thinner, or ideally Buzzweld 2K thinner.														
Application Conditions	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 90% and the steel temperature should remain at least 3°C above the dew point. Paint temperature should ideally be at a minimum of 15°C.														
Application Methods	<table border="1"> <thead> <tr> <th data-bbox="416 1081 687 1160">Method</th> <th data-bbox="691 1081 935 1160">Airless Spray</th> <th data-bbox="938 1081 1182 1160">Conventional Spray</th> <th data-bbox="1185 1081 1334 1160">Brush</th> <th data-bbox="1337 1081 1487 1160">Roller</th> </tr> </thead> <tbody> <tr> <td data-bbox="416 1162 687 1211"></td> <td data-bbox="691 1162 935 1211">Yes</td> <td data-bbox="938 1162 1182 1211">No</td> <td data-bbox="1185 1162 1334 1211">Yes</td> <td data-bbox="1337 1162 1487 1211">Yes</td> </tr> </tbody> </table>	Method	Airless Spray	Conventional Spray	Brush	Roller		Yes	No	Yes	Yes				
	Method	Airless Spray	Conventional Spray	Brush	Roller										
	Yes	No	Yes	Yes											
<ul style="list-style-type: none"> Airless spray: output fluid pressure 3500-4000 psi, tip size 17-21 thou (0.43-0.53mm). Brush/roller: apply un-thinned, lay on, do not over brush. When rolling do not overload the roller and change the roller more often prior to roller failing. 															
Product Notes	<ul style="list-style-type: none"> Application Temperature: Range 2°C-30°C (Curing will be retarded below 10°C -product will cure down to 2°C but cure will be slow Stripe Coating: Stripe coat all edges, nuts and bolts, welds etc. Overcoating: Overcoat with Blackit, WAR, FxLiner, DTM, GIO. If overcoating time exceeds and contamination has occurred, clean using a detergent solution/fresh water and allow to dry before continuing If maximum overcoat times are exceeded abrade the surface and wash down with fresh water to remove contamination and allow to dry before continuing 														
Health & Safety	Containers are provided with safety labels which should be observed. Further Product Safety Data Sheets. A Safety Data Sheet for this product is available on request for information about hazardous influences and protection are detailed in individual														

Buzzweld

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 purposes. Since Buzzweld cannot anticipate all variations in actual end-use conditions Buzzweld 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.