

# Alesta® EP

## Anticorrosive Primer EP Primer

### EP80027356121 FUNCTIONAL ANTIGASSING ± RAL 7024

Alesta® Functional Antigassing is an anticorrosion powder primer designed for ferrous and non-ferrous substrates. Formulated to be overcoated with some recommended Alesta® topcoats (Alesta® IP, AP, SD), Alesta® Functional Antigassing makes up a whole system that isolates the substrate from its environment and improves corrosion protection.



#### Characteristics

- Gloss Smooth
- Solid
- Tribo/Corona
- Antigassing

#### Usage Area

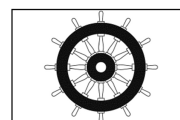
- Protection and decoration of interior parts
- Gas or liquid tanks, pipelines, structural steelwork, trucks, trailers & car parts



#### Approvals

Marine  
UL

CE 2690 (Fr)  
MH45216 (Fr)



- This powder coating complies with the European Directives "Restriction of the use of certain hazardous substances" 2011/65/EU and 2015/863/EU (RoHS)
- Classification A2 (non flammable) of reaction to fire in accordance with NF EN 13501-1+A1 : 2013

The following data has been obtained under laboratory conditions as described below. Actual product properties such as gloss, colour and finish may vary depending on application conditions.



#### Test Conditions

- Curing Conditions (object temperature) 7 min @ 180°C
- Substrate 0,8 mm Iron phosphated & passivated steel panels
- Film thickness 60 ± 10 µm  
EN ISO 2360

#### Physical Data

- Density 1,49 g/cm³  
calculated



## Product Performance / Film Properties

Gloss @ 60° 80 ± 5

EN ISO 2813

Impact Resistance 1 kg / 50 cm

EN ISO 6272

Adhesion GTO

EN ISO 2409



## Curing Conditions (object temperature)

Can be cured using a variety of methods, e.g. IR, convection, combi ovens. In direct gas ovens, combustion by-products may cause significant colour changes (for specific advice, please contact us).

For optimum intercoat adhesion, partial cure of the primer is recommended prior to application of the topcoat. This should be followed by full cure of the combined coating system according to the topcoat curing window.

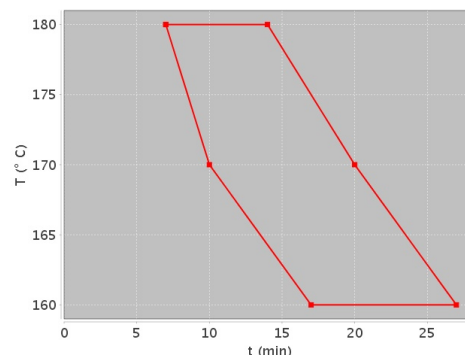
Product is formulated for optimum intercoat adhesion under industrial curing conditions. However for non-conventional curing program, above 210°C, long time in the oven, or direct fired gas oven, it is advisable to test to confirm suitability.

7-14 min @ 180°C

10-20 min @ 170°C

17-27 min @ 160°C

For a degassing substrate, primer must be full-cured at a temperature above the curing temperature of the topcoat in order to prevent extra degassing when topcoat is cured.



## Storage Stability

36 months/35°C

Shelf life applies to materials stored in sealed plastic bags under dry and cool conditions.



## Substrate Preparation

- Both chemical and mechanical surface pretreatments are compatible with Alesta® Functional Antigassing.
- Surface preparation should be chosen according to type of substrate and required performance. The suitability of the surface preparation should be tested by the coater beforehand using appropriate test methods.
- A degassing stage prior to the primer application, at a temperature 20°C higher than the curing schedule of the topcoat, might be required depending on the porosity of the part to be treated.



## Application

- Do not mix this product with other powder coatings.
- Substrate should be correctly cleaned before use.
- Can be applied with manual or automatic guns.
- Spray settings will depend upon the geometry of the object being coated as well as the required film thickness. It is the responsibility of the applicator to make the appropriate adjustments. Optimum coating performance will be obtained with a film thickness of 50-80 µm.
- Alesta® Functional Antigassing is easily overcoatable with specified Alesta® topcoats without sanding or any other preparation\* (within 12 hours).  
\* cleaning is necessary if primer surface becomes contaminated (dust, oil etc.)  
All other conditions must be checked before use with an adhesion test.
- Recycling of the powder: possible up to 30 %.



## Comments

- Certain chemicals or domestic cleaning products can cause damage to the appearance of the coating. Please test a small inconspicuous area first to confirm suitability.
- Please contact us for specific questions.
- Coated parts should be packed after they are fully cooled using suitable materials that are free of plasticizers. Packaged parts should be stored under cover to avoid the formation of condensation (for example under plastic wrapping film) which could result in permanent marks on the surface of the coating.



## Safety

Consult the Safety Data Sheet prior to use

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.

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