



SINGLE PACK EPOXY ZNC RICH PRIMER

PRODUCT CHARACTERISTICS

Description

One-component epoxy Zinc Rich coating that is specially formulated to provide an attractive and durable Anticorrosive Finish.

Recommended use

Single Pack Epoxy Zinc Rich Primer is suitable for onshore corrosion protection of new-build steel constructions.

Service temperature:

- Room Temperature @ 30°C

Features

- A durable finish coat for epoxy based coating systems, Tough, hard wearing finish with overall durability properties.
- High resistance to impact and abrasion.
- Excellent adhesion to aged epoxy coatings.
- High Anticorrosive properties.

PRODUCT SAFETY

Flash Point 27+/-2°C

Handling

Handle with care. Before and during use, observe safety labels on packaging and paint. Always consult Safety Data Sheet for this product along with the Product Data Sheet.

PRODUCT DATA

Product Name	- Epoxy Primer
Product components	- Base
Standard shade* / code	- Grey or As per Customer Requirements
Gloss	- Semi-Gloss, Matt or As per Customer Requirements
Volume Solids	- 45 ± 2% or As per Customer Requirements
Specific gravity	- Min 1.3 kg/L or As per Customer Requirements
Reference dry film thickness	- 50 -60 micron or As per Customer Requirements

SURFACE PREPARATION

Cleanliness

- Remove oil, grease and other contaminants by suitable detergent cleaning.
- Remove salts, detergents and other contaminants by high pressure fresh water cleaning.
- Use 3 in 1 Solution.



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New Build:

- Use degreasing, Phosphating Process for Surface Preparation.
- All damage of shop primer and contamination from storage and fabrication should be thoroughly mechanically/chemically cleaned prior to final painting.
- Remove dust, blast media and loose materials.

Consult separate Surface Preparation Guidelines for more details.

APPLICATION

Mixing ratio : Mixing ratio
Base : Curing agent
(4 : 1 by volume) Stir well before use.

Thinner : Thinner

Cleaner : Tool Cleaner

Pot life

Product Temperature 30°C

Application method

Tool	Application parameters	Thinning max vol.
Airless spray	Nozzle pressure: 225 bar [3300 psi] Nozzle orifice: 0.019-0.021"	5%

If brush or roller application is used, more coats will be necessary to achieve the specified dry film thickness. Spray data are indicative and subject to adjustment.

The hardener component of this product must be mixed thoroughly with the base component and allowed to pre-react (inhibit) for a period of 15 minutes before proceeding to application. Without pre-reaction, this product may result in a greasy/tacky surface, incomplete cure and/or discoloration.

Film thickness

Specification range

Wet film thickness	-	150 Microns
Dry film thickness	-	50 - 60 Micro
Theoretical spreading	-	8 m ² /L

Product may be specified in another film thickness than indicated depending on purpose and area of use. This will alter spreading rate, drying and curing time and over coating interval.



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Application conditions

- Optimal paint temperature for proper mixing, pumping and spraying is: 25-30 °C
- To avoid condensation, apply on a clean and dry surface with a temperature that is at least 3°C [5°F] above the dew point.

DRYING AND OVER COATING

Product compatibility

Previous coat : None or according to specification.
Subsequent coat : None or according to specification.

Drying time

Surface Dry	-	Minutes 60
Touch Dry	-	Hours 6
Hard Dry	-	Hours 24

Drying conditions

- To obtain the drying time stated, it is important to maintain sufficient ventilation during application, drying and curing.

Other Remarks

- Epoxy coats have an inherent tendency of chalking in outdoor exposure. This does not affect the performance of the coating.
- Specification supersedes any recommendations given in the Product Data Sheets.

STORAGE

Shelf life

Ambient temperature **35°C [95°F]**

Base	-	12 months
Curing agent	-	6 months

Shelf life from date of production, when stored in original, unopened containers. Thereafter, the product quality must be re-inspected. Always check the best before date or expiry date on the label.

Storage conditions

- Product must be stored according to local legislation, at maximum 40°C [104°F], without direct sunlight and protected from rain and snow.