

Product description

A zinc rich epoxy primer containing 92% ASTM D520 Type II Zinc Dust

Recommended use

For application to blast cleaned or MBX bristle blast cleaned steel to SA 2.5

Film thickness and spreading rate

	Minimum	Maximum	Typical
Film thickness, dry (μm)	25	75	50
Film thickness, wet (μm)	45	140	95
Theoretical spreading rate (m^2/l)	21,2	7,1	10,6

Physical properties

Colour	Grey
Solids (vol %)*	53 \pm 2
Flash point	25°C \pm 2 (Setaflash)
VOC	400 gms/ltr UK-PG6/23(97). Appendix 3
Gloss	Flat
Water resistance	Excellent
Abrasion resistance	Very good
Solvent resistance	Very good
Flexibility	Good

*Measured according to ISO 3233:1998 (E)

Surface preparation

All surfaces should be clean, dry and free from contamination. The surface should be assessed and treated in accordance with ISO 8504.

Bare steel

Cleanliness: Blast cleaning to min. Sa 2 ½ (ISO 8501-1:2007) or for maintenance UHPWJ to WJ2 (NACE No.5/SSPC-SP 12). Roughness: using abrasives suitable to achieve minimum grade Fine (ISO 8503-2).

Shopprimed steel

Clean, dry and undamaged approved shopprimer.

Other surfaces

The coating may be used on other substrates.

Condition during application

The temperature of the substrate should be minimum 5°C and at least 3°C above the dew point of the air, temperature and relative humidity measured in the vicinity of the substrate. Good ventilation is required in confined areas to ensure correct drying.

Application methods

Spray	conventional or airless spray
Brush	Recommended for stripe coating and small areas, care must be taken to achieve the specified dry film thickness.

Application data

Mixing ratio (volume)	3:1
Mixing	3 part Comp. A (base) to be mixed thoroughly with 1 part B (curing agent) ½ hour prior to use.
Pot life (23°C)	24 hours (Reduced at higher temp.).
Thinner/Cleaner	Thinner No. 17
Pressure at nozzle	15 MPa min (150 kp/cm ² , 2100 psi.)-Airless spray
Nozzle tip	0.38 - 0.53 mm (0.015 - 0.021"). 1.8 - 2.1 Conventional spray
Spray angle	40 - 80°
Filter	Check to ensure that filters are clean.

Drying time

Drying times are generally related to air circulation, temperature, film thickness and number of coats, and will be affected correspondingly. The figures given in the table are typical with:

- * Good ventilation (Outdoor exposure or free circulation of air)
- * Typical film thickness
- * One coat on top of inert substrate

Substrate temperature	5°C	10°C	23°C	40°C
Surface dry	50 min	20 min	10 min	4 min
Through dry	3 h	2 h	1,5 h	40 min
Cured	10 d	7 d	5 d	2 d
Dry to recoat, minimum ¹	3 h	2 h	1,5 h	40 min
Dry to recoat, maximum ^{1,2}				

1. Recommended data given for recoating with coatings normally specified on top of zinc epoxy coatings.
1. The surface should be dry and free from any contamination prior to application of the subsequent coat.

The given data must be considered as guidelines only. The actual drying time/times before recoating may be shorter or longer, depending on film thickness, ventilation, humidity, underlying paint system, requirement for early handling and mechanical strength etc. A complete system can be described on a system sheet, where all parameters and special conditions could be included.

Typical paint system

Zinc Rich Epoxy Primer **1 x 25 - 75 µm (Dry Film Thickness)**

Subsequent coating(s) by choice e.g.: Epoxy, Acrylic or Vinyl. Synthetic.

Other systems may be specified, depending on area of use

Storage

The product must be stored in accordance with national regulations. Storage conditions are to keep the containers in a dry, cool, well ventilated space and away from source of heat and ignition. Containers must be kept tightly closed.

Handling

Handle with care. Stir well before use. Continuous stirring during application will prevent the heavy zinc pigment from settling.

Packing size

Health and safety

Please observe the precautionary notices displayed on the container. Use under well ventilated conditions. Do not breathe or inhale mist. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water and medical attention sought immediately.

For detailed information on the health and safety hazards and precautions for use of this product, we refer to the Material Safety Data Sheet.

DISCLAIMER

The information in this data sheet is given to the best of our knowledge based on laboratory testing and practical experience. However, as the product can be used under conditions beyond our control, we can only guarantee the quality of the product itself. We also reserve the right to change the given data without notice. Minor product variations may be implemented in order to comply with local requirements.

If there is any inconsistency in the text the English (UK) version will prevail.