

Product Description

A two components fast dry pure epoxy zinc phosphate shop primer as temporary protective anti corrosive primer for severe corrosive environment.

Features

- Easy to use – spray, brush, roller
- General purpose & fast dry Epoxy Zinc phosphate blasting Primer.
- Compatible with other type of subsequent coating except inorganic paint.
- Excellent application workability, mechanical and physical properties for heavy duty application
- Better weldability without any hazardous effect and good heat resistance properties.
- Good anti corrosion properties, expected service life of 4 - 6 months for outdoor exposure at 20-30 μ .

Typical Uses

Suitable for use as temporary protective coating and shop primer for blast cleaned steel plates and structures. Especially suitable for steel plates subjected to prolonged weathering. Fast dry and good weldability make it a suitable shop primer for auto or manual blasting line.

Physical Data

| | | |
|---------------------------|---|------------------------------------|
| Color | : | Red Brown, Grey |
| Flash Points | : | Base : 3.0 °C Hardener : 7.0 °C |
| Volume Solid | : | 25+/- 2% |
| VOC(as supplied) | : | 725g/L |
| Shelf Life @25°C / indoor | : | 12 months |

Typical Thickness : 20 ~ 40 μ dried film.

| Drying Time(at Dry Film Thickness 25 μ) | Temperature | 10°C | 20°C | 30°C |
|--|-------------|--|---------|---------|
| | Surface Dry | | 6 mins | 3 mins |
| Hard Dry | | 135 mins | 90 mins | 45 mins |
| Painting interval: | Minimum | 19 hrs | 16 hrs | 8.0 hrs |
| | Max. (self) | 120 D | 120 D | 90D |
| Pot Life | | 48 hrs | 24hrs | 18hrs |
| Theoretical coverage (at DFT 20- 25 μ) | | 0.08~0.10 L/m ² ; 12.5 ~ 10.0m ² /L | | |
| Service temperature | | -60 to 150°C (dry) | | |

Application Data

Mixing ratio : Base : hardener = 80 : 20 (by weight)
3 : 1 (by volume)
Application Method : airless spray, roller, brush

Mixing Procedure : Add part B into part A and power mix for at least two minutes or until homogeneous.

Drying schedule : Drying by solvent evaporation and chemical cross linking. Higher film thickness, insufficient ventilation, or lower temperature will require longer drying time. Excessive humidity or condensation on the surface can interfere with the drying cause discoloration and may result in a surface haze. Any haze or contamination must be removed by water washing before recoating.

This product requires the substrate temperature to be above the dew point (+ 3~5 °C). Condensation due to substrate temperatures below dew point can cause flash rust on metal and adhesion will be affected.
Color Different : The paint use as primer or anti fouling may have slight color variance between batches. Similarly, the paint under sun light exposure may fade and chalk.

Application Procedure

Mix properly the paint before use.

- Flush equipment with epoxy thinner before use.
- Mix the paint (part A and Part B accordingly to mixing ratio) thoroughly until homogeneous.
- Thin with epoxy thinner only if necessary for workability.
- When applying by conventional spray, use adequate air pressure and volume for proper atomisation.
- Apply a wet coat in even parallel passes, overlap 50% to avoid holidays and pin hole.
- Excessive thickness can prolong drying and sagging.
- Clean up all equipment with thinner immediately after use.
- Keep containers tightly close and store in proper storage area.

Condition of Application

Use brush or roller with 1/8" nap . Apply at sufficient thickness and avoid repeating rolling to have good levelling.

| | | |
|-----------------------|---|------------------------------------|
| Temperature | : | Min 5 °C ; Max 50 °C |
| Humidity | : | Maximum 85 % R.H. |
| For Airless spray :- | | |
| Tip Size | : | Graco 719 or equivalent |
| Paint Output pressure | : | 8.8 – 11.8 MPa (g) |
| Viscosity | : | 9.0 ~ 10.0 second (Ford Cup no 4) |
| Thinning | : | 10 – 25 % by volume |
| Suitable Thinner | : | Hana Thinner E QD |

cleaning. Observe safety precaution when use the solvents. In case of spillage, absorb and dispose the material and used container according to local required regulation or through licence waste collector.

Surface Preparation

General :

Surfaces must be clean and dry, all contaminants like dirt, dust , oil must be remove by appropriate method to ensure good adhesion.

Abrasive blast clean

Abrasive blast clean to Sa 2.5 (ISO-8501) or SSPC-SP6. In case of hydro blasting or hydro jetting to remove existing coating, ginger rust should be remove and blow dry before application. Surface profile must be a minimum of 50 microns.

Safety Precaution and Clean-up

Safety : Read and follow the material safety data sheet (MSDS) before use. Employ normal safety precaution. Put on necessary personal protection equipment when handle and use this product.

Ventilation : when working in a confine workplace, thorough air ventilation must be used during and after application until the coating is cured. The ventilation system should be effective to prevent solvent vapour concentration from reaching lower explosion limit for the product and to ensure exposure limit to the personnel to be below permissible exposure limit.

Caution : All electrical equipment and installations should be properly grounded. In area where explosion hazard exist, workmen should be used non-ferrous tools, conductive shoes and non-sparkling tools

Clean-up : Use Hana Paint epoxy thinner (Hana Thinner E) or hydrocarbon solvent for

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Limited Warranty

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