



PRODUCT DATA SHEET

INDUSTRIAL RANGE

WATER BASED ETCH PRIMER

1. DESCRIPTION

High quality zinc phosphate primer, based on a modified styrene acrylic resin.

2. PRINCIPAL CHARACTERISTICS

- Anticorrosive properties.
- Fast drying.
- Fast hardening.
- Recoat able with conventional coating systems.
- No suitable for immersion in water.

3. PACKAGING, COLOURS AND GLOSS

- 1lt, 5lt and 20lt.
- Black, grey and red oxide.
- Matt.

4. BASIC DATA AT 23°

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| • Drying time: | ± 30min surface dry.
± 5hrs full cure. |
| • Recoating time: | ± min 3hrs for 40µm dft, max unlimited. |
| • Mass relative density: | ± 0.95 – 0.97 g/cm ³ . |
| • Solids by volume: | ± 47%. |
| • Viscosity: | ± 60 – 70sec. |
| • Recommended dft: | 40µm per coat. (2 coats recommended.) |
| • Theoretical spreading rate: | 10 - 12m ² /lt for 40µm. |
| • Practical spreading rate: | 5 – 7m ² /lt for 40µm. |
| • Shelf life: | at least 12 months in cool and dry conditions. |
| • Flash point: | N/a. |



PROTECTION WHERE YOU NEED IT!

Limitation of liability applies. Refer to annexure for full disclosure.
April 2009 - INDUSTRIAL RANGE - HB EPOXY PIPE COAT - revision 1 of 2009.



5. RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES

- Steel; blast cleaned to at least Sa2½ and free from rust, scale, shop primers and any other contamination.
- Blasting profile: 50µm - 100µm.
- The substrate must be dry before and during application of this primer.
- Substrate temperature should be between 10°C and 30°C and at least 3°C above dew point during application and curing.
- Ambient temperature between 5°C and 40°C with a maximum relative humidity of 85%.

6. INSTRUCTIONS FOR USE

- Stir well before use.
- Product temperature should be above 15°C to achieve application viscosity.
- Clean water can be introduced to lower the viscosity if necessary. Do not exceed 10% to volume.
- To mush thinning will reduce sag resistance.
- Always ensure adequate ventilation.

- AIRLESS SPRAY:
 - Recommended thinner: Clean water.
 - Volume of thinner: 0 – 10%, depending on required thickness and application conditions.
 - Nozzle orifice: ± 0.38 – 0.48mm.
 - Nozzle pressure: 12 – 16MPa (± 120 to 160 bar).

- AIR SPRAY:
 - Recommended thinner: Clean water.
 - Volume of thinner: 0 – 10%, depending on required thickness and application conditions.
 - Nozzle orifice: ± 1.8 – 2 mm.
 - Nozzle pressure: 0.35MPa (± 3½ bar).

- BRUSH / ROLLER: (not recommended)
 - Recommended thinner: Clean water.
 - Volume thinner: 0 – 5%, depending on required thickness and application conditions.
 - Cleaning solvent: Clean water.

7. SAFETY PRECAUTIONS

This is a water-based primer, avoid inhalation of spray mist vapor as well as contact between the wet paint and exposed skin or eyes.



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