



PRODUCT DATA SHEET

INDUSTRIAL RANGE

HIGH BUILD EPOXY ZINC PHOSPHATE PRIMER

1. DESCRIPTION

High quality zinc phosphate primer, based on modified PVB Phenol alkyd resin.

2. PRINCIPAL CHARACTERISTICS

- Good anticorrosive properties.
- Fast drying.
- Fast hardening.
- Recoatable with one and two component coatings.
- Not suitable for immersion in water.

3. PACKAGING, COLOURS AND GLOSS

- 1lt, 5lt and 20lt.
- Grey.
- Matt.

4. BASIC DATA AT 23°

- Drying time: \pm 30min surface dry.
 \pm 2hrs hard dry.
- Recoating time: \pm min 10hrs for 40 μ m dft, max unlimited.
- Mass relative density: \pm 1.2 – 1.3 g/cm³.
- Solids by volume: \pm 70%.
- Viscosity: \pm 98 – 105Ku.
- Recommended dft: Min: 40 μ m Max: 65 μ m per coat. (2 coats recommended).
- Theoretical spreading rate: \pm 4m² - 6m²/lt for 65 μ m or 8m² - 10m²/lt for 40 μ m.
- Shelf life: at least 12 months in cool and dry conditions.
- Flash point: 18°C.



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; unpainted, dry and free from any surface contamination.
- 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 of the stirred base should be above 15°C to achieve application viscosity.
- Quick dry thinners can be introduced to lower the viscosity if necessary. Do not exceed 10% to volume.
- Too much solvent will reduce functionality, opacity and sag resistance.
- Always ensure adequate ventilation.

- AIRLESS SPRAY:

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

- BRUSH / ROLLER: (not recommended)

- Recommended thinner: QD Thinners.
- Volume thinner: 0 – 5%, depending on required thickness and application conditions.
- Cleaning solvent: QD Thinners.

7. SAFETY PRECAUTIONS



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This is a solvent 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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