

APCODUR HB ZINC PHOSPHATE PRIMER

Epoxy

PRODUCT DESCRIPTION

Two component, high build epoxy primer with zinc phosphate pigment

FEATURES AND RECOMMENDED USE

- Designed as an epoxy primer or build coat in protective coating systems
- Excellent resistance to saline, marine and chemical environments
- Free from lead and chromate containing pigment
- Good adhesion on steel and aged epoxy coatings

TECHNICAL DATA

Colour	Red Oxide & Grey
Gloss	Matt
Volume Solids	Approx. 52%
Recommended DFT / Coat	35 - 50 microns
Theoretical Covering Capacity	14.9 sq.mtr/ ltr @ 35 microns DFT 10.4 sq.mtr/ ltr @ 50 microns DFT
Drying Time at 30°C	Surface dry : 1 hour Hard dry : 12 hour Full cure : 7 days
Overcoating interval at 30°C	Min. : 12 hours Max. : 1 month, provided surface is dry and clean from all contamination

The data given is for guideline only. The physical values are subject to normal manufacturing tolerances, colour and testing variances
The volume solids indicated are as per ASTM D 2697 air drying method.
The actual drying time/ overcoat interval may be shorter or longer, depending on film thickness, ventilation, humidity, temperature etc.
The information provided above is at 30°C and 65% relative humidity.

DIRECTION FOR USE

Surface Preparation

General

- Surfaces must be dry, clean and free from contaminants
- Ensure removal of dirt, dust, oil and all other contaminants that could interfere with adhesion of the primer. Oil and grease should be removed as per SSPC-SP1 solvent cleaning with aromatic solvents.
- Surface should be checked and treated in accordance with ISO 8504 prior to priming

Blast Cleaning

- Steel, abrasive blast clean to min. Sa 2 1/2 (ISO 8501-1: 200) or SSPC –SP6. In case oxidation has occurred between blasting and application of Apcodur HB Zinc Phosphate Primer, the surface should be reblasted.
- A blasting profile of (Rz) 30 - 50 microns is recommended.

Application Conditions

- Substrate temperature should be at least 3°C above dew point but not above 50°C.
- Relative humidity should be below 85%
- Good ventilation is required in confined areas to ensure proper curing

Mixing

- Apcodur HB Zinc Phosphate Primer is supplied in two packs. Stir the base and hardener separately. If settling is observed in the base or hardener, loosen the settled material with the help of hand stirrer followed by power driven stirrer (at lower RPM) for quick homogenous mixing.
- Mix hardener gradually into the base under continuous stirring as per the mixing ratio. Once the unit has been mixed, it should be consumed within the working pot life. In case of part mixing (which should be avoided), close the lids of containers tightly to avoid contact with atmospheric moisture.
- Thinner should be added after mixing the components and post the induction time. Addition of excessive thinner will lead to reduced sag resistance.

Mixing Ratio (by volume)	Base : Hardener 3 : 1
Induction Time	30 minutes
Pot Life at 30°C	5 hour

Application

Air Spray	
Recommended thinner	T 141
Volume of thinner	5 - 20%
Nozzle orifice	1.5 - 3.0 mm
Nozzle Pressure	0.3 – 0.4 MPa (= approx. 3 – 4 atm; 43 – 57 p.s.i.)
Cleaning Thinner	T 141
Airless Spray	
Recommended thinner	T 141
Volume of thinner	0 - 15%
Nozzle orifice	0.33 - 0.41 mm (13 – 16 Thou)
Nozzle Pressure	16 – 20 MPa (= approx. 160 – 200 atm; 2300 - 2800 p.s.i.)
Cleaning Thinner	T 141
Brush / Roller	
Suitable for stripe coating and small areas.	
Recommended thinner	T 141
Volume of thinner	0 - 15%

Cleaning

- Do not allow the product to remain in hoses, gun or spray equipment. Clean all equipments immediately after use with Thinner T 141. It is recommended to periodically flush out spray equipment during the course of the working day. The frequency of cleaning will depend on amount sprayed, temperature and time gap.
- All surplus material and empty containers should be disposed off in accordance with appropriate regional legislation.

Product Characteristics

- Higher film build up in single coat can be attained only by airless spray. Conventional air spray or application using pressure pot may require multiple coats to achieve desired film build. Restrict brush and roller application only for stipe coat and for smaller areas.
- The maximum performance is achieved after complete curing.
- As common with all epoxies Apcodur HB Zinc Phosphate Primer will chalk and discolor on exterior exposure. However, these phenomena are not detrimental to anti-corrosive performance. The actual rate of chalking will depend upon climatic conditions and will normally be limited to a thin surface layer.

PACK SIZE	20 ltr (Base : 15 ltr & Hardener : 5 ltr)
STORAGE	Shelf Life: Atleast 12 months @ 30°C for original unopened pack, subject to inspection thereafter. Store in a cool, dry place and in accordance with local regulations
REGULATORY INFORMATION	Flash Point: Base : Not less than 24°C, Hardener: Not less than 24°C VOC : Approx. : 445 ± 20 gm/ ltr as per USA-EPA Method 24 Product Weight : Approx. 1.43 ± 0.04 kg/ ltr (Red Oxide) Approx. 1.39 ± 0.04 kg/ ltr (Grey)

SAFETY INFORMATION

- As a general safety measure, inhalation of solvent vapours or paint mist and contact of liquid paint with skin & eyes, should be avoided. Forced ventilation should be provided when applying paint in confined spaces or stagnant air. Even when ventilation is provided, respiratory, skin and eye protection are always recommended when spraying paint.
- Please refer our Material Safety Data Sheet prior to using the product.

Disclaimer: To the best of our knowledge the information provided herein are true and accurate at the date of issuance. Since we have no control over the quality or condition of the substrate or the various factors affecting the use and application of the product, we do not accept any responsibility or liability arising out of use of the product.

The company reserves the right to modify data contained herein without prior notice. Any change in data would normally be followed by issue of a new data-sheet. The user should check with the nearest sales office of the company and confirm the validity of the information, prior to using the product.

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Head Office: Asian Paints PPG Private Limited, Plot No-5, Gaiwadi Industrial Estate, Near Religare Building, S.V. Road, Goregaon (W), Mumbai 400 062. **Tel No:** 022 61089800, **Email:** customercare.apppg@asianpaintsppg.com, **Website:** www.asianpaintsppg.com