

APCODUR EPOXY POLYAMIDE PRIMER

Epoxy



PRODUCT DESCRIPTION

Two component, polyamide cured epoxy primer for concrete surface

FEATURES AND RECOMMENDED USE

- Designed for use as a primer for concrete surface
- Excellent water & corrosion resistance
- Good flow and wetting properties
- Good adhesion properties for subsequent coats
- Approved by Central Electro Chemical Research Institute, Karaikudi (CECRI) for concrete structures

TECHNICAL DATA

Colour	Red Oxide
Gloss	Matt
Volume Solids	Approx. 55%
Recommended DFT / Coat	50 - 60 microns
Theoretical Coverage Capacity	11.0 sq.mtr/ ltr @ 50 microns DFT 9.2 sq.mtr/ ltr @ 60 microns DFT
Drying time at 30°C	Surface Dry : 2 hours Hard Dry : 16 hours Full cure : 7 days
Over coating interval at 30°C	Min. : 16 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.

DIRECTIONS FOR USE

Surface Preparation

For New concrete surface

- Ensure that the concrete surface is cured for minimum 3 months
- In case of large areas and for severe exposure conditions, the surface has to be prepared by light blasting. In less critical areas where blasting is not practical, wire brushing has to be adopted to remove lattices, followed by treating with dilute (10%) hydrochloric acid
- Remove acid and contaminants by liberal wash with water. Ensure that acid solution does not retain on the surface & joints
- Allow the surface to dry thoroughly before applying primer

For Old concrete surface

- Remove the surface contaminants like grease, oil etc., by solvent wiping or by 10% caustic solution

- Preferably the surface has to be prepared by light blasting. In case, blasting is not practical, etch the surface to get a good profile by treating white dilute (10%) hydrochloric acid
- Remove acid and contaminants by liberal wash with water. Ensure that acid solution does not retain and penetrate through the joints and concrete surface
- Allow the surface to dry thoroughly before applying primer

Note: Surface should be thoroughly dried before application of primer. This will have a major influence on the performance of the coating

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 Epoxy Polyamide 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	4 hour

Application

Air Spray	
Recommended thinner	T 141
Volume of thinner	10 - 25%
Nozzle orifice	1.5 – 3.00 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	
Recommended thinner	T 141
Volume of thinner	0 - 10%

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 stripe coat and for smaller areas
- The maximum performance is achieved after complete curing

Note: As common with all epoxies Apcodur Epoxy Polyamide 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. 390 ± 30 gm/ ltr as per USA-EPA Method 24 Product Weight: Approx. 1.59 ± 0.04 kg/ ltr (depending on shades)

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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