

APCOMIN INDUSTRIAL ZINC PHOSPHATE PRIMER

Alkyd



PRODUCT DESCRIPTION

Single pack, air drying, oleoresinous composition with zinc phosphate pigments

FEATURES AND RECOMMENDED USE

- Designed as an anticorrosive primer for industrial application
- Suitable for use in mildly corrosive environments
- Easy application by brush
- Can be top coated by alkyd based top coats

TECHNICAL DATA

Colour	Red oxide and Grey
Gloss	Matt
Volume Solids	Approx. 32%
Recommended DFT / Coat	20 - 25 microns
Theoretical Coverage Capacity	16.0 sq.mtr/ ltr @ 20 microns DFT 12.8 sq.mtr/ ltr @ 25 microns DFT
Drying time at 30°C	Surface Dry : 1 hours Hard Dry : 12 hours
Over coating interval at 30°C	Min. : 12 hours Max. : Unlimited, 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

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 coating. Oil and grease should be removed as per SSPC-SP1 solvent cleaning.
- 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 Apcomin 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

- If settling is observed in the drum, loosen the settled material with the help of hand stirrer followed by power driven stirrer for quick homogenous mixing
- Thinner should be added after mixing. Addition of excessive thinner will lead to reduced sag resistance.

Application

Air Spray	
Recommended thinner	T 284
Volume of thinner	5 - 10 %
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 284
Airless Spray	
Recommended thinner	T 284
Volume of thinner	0 - 5%
Nozzle orifice	0.38 - 0.46 mm (15 – 18 Thou)
Nozzle pressure	10 – 13 MPa (= approx. 100 – 130 atm; 1400 - 1800 p.s.i.)
Cleaning Thinner	T 284
Brush / Roller	Suitable for stripe coating and small areas.
Recommended thinner	T 284
Volume of thinner	0 - 5%

Cleaning

- Do not allow the product to remain in hoses, gun or spray equipment. Clean all equipments immediately after use with thinner T -284. 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

- The maximum performance is achieved after complete drying.
- At higher relative humidity, drying may get retarded

PACK SIZE	20 ltrs
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: Not less than 30°C VOC: 300 ± 20 gm/ ltr (depending on shades)as per USA-EPA Method 24 Product Weight: Approx 1.24 ± 0.04 kg/ ltr (Red Oxide) Approx 1.21 ± 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.



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