

# APCOMIN INDUSTRIAL ROZC PRIMER

Alkyd



## PRODUCT DESCRIPTION

Single pack, air drying, oleoresinous composition with zinc chrome & red oxide 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  |
| Gloss                         | Matt   |
| Volume Solids                 | Approx. 30%  |
| Recommended DFT / Coat        | 25 - 35 microns  |
| Theoretical Coverage Capacity | 15.0 sq.mtr/ ltr @ 20 microns DFT<br>12.0 sq.mtr/ ltr @ 25 microns DFT                         |
| Drying time at 30°C           | Surface Dry : 1 hours<br>Hard Dry : 12 hours   |
| Over coating interval at 30°C | Min. : 12 hours<br>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 Industrial ROZC 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

|                       |  |
|-----------------------|--|
| <b>Air Spray</b>      |  |
| Recommended thinner   | T - 284  |
| Volume of thinner     | 5 - 10%  |
| Nozzle orifice        | 1.5 - 3.0 mm   |
| Nozzle Pressure       | 0.3 – 0.4 MPa<br>(= approx. 3 – 4 atm; 43 – 57 p.s.i.)       |
| Cleaning Thinner      | T - 284  |
| <b>Airless Spray</b>  |  |
| Recommended thinner   | T - 284  |
| Volume of thinner     | 0 - 5%   |
| Nozzle orifice        | 0.38 - 0.46 mm (15 – 18 Thou)                                |
| Nozzle Pressure       | 10 – 13 MPa<br>(= approx. 100 – 130 atm; 1400 - 1800 p.s.i.) |
| Cleaning Thinner      | T - 284  |
| <b>Brush / Roller</b> |  |
| 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

|                               |  |
|-------------------------------|--|
| <b>PACK SIZE</b>              | 20 ltrs  |
| <b>STORAGE</b>                | <b>Shelf Life:</b> Atleast 12 months @ 30°C for original unopened pack, subject to inspection thereafter.<br>Store in a cool, dry place and in accordance with local regulations |
| <b>REGULATORY INFORMATION</b> | <b>Flash Point:</b> Not less than 30°C<br><b>VOC:</b> 210 ± 30 gm/ ltr (depending on shades) as per USA-EPA Method 24<br><b>Product Weight:</b> Approx 1.40 ± 0.07 kg/ ltr       |

## 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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