

# APCODUR RAPID RECOAT ZR PRIMER

Epoxy rapid recoat, metallic zinc rich epoxy primer



## PRODUCT DESCRIPTION

Two component, rapid recoat air drying metallic zinc rich epoxy primer

## FEATURES AND RECOMMENDED USE

- High performance zinc rich epoxy primer for highly aggressive environments
- Rapid curing and overcoating properties
- Excellent corrosion resistance
- Excellent abrasion resistance
- Complies with SSPC Paint-20 Level 2 in both composition & performance expectation

## TECHNICAL DATA

Colour	Grey
Gloss	Matt
Volume Solids	Approx. 60%
Recommended DFT / Coat	50 - 75 microns
Theoretical Coverage Capacity	12.0 sq.mtr/ ltr @ 50 microns DFT 8.0 sq.mtr/ ltr @ 75 microns DFT
Drying Time at 30°C	Surface Dry : 30 minutes Hard Dry : 16 hours Full Cure : 7 days
Over coating interval at 30°C	Min. : 3 hours Max. : Unlimited, provided surface is completely free from corrosion, contamination and zinc salt

The data given is for guideline only. The physical values are subject to normal manufacturing tolerances 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 3 / Sa 2 1/2 (ISO 8501-1: 2007) or SSPC –SP6. In case oxidation has occurred between blasting and application of Apcodur Rapid Recoat ZR, the surface should be reblasted
- A blasting profile of (Rz) 50-75 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. Continuous stirring is required during the application to avoid settling
- 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

<b>Mixing Ratio (by volume)</b>	Base : Hardener 4 : 1
<b>Induction Time</b>	20 minutes
<b>Pot Life at 30°C</b>	3 hours

## Application

<b>Air Spray</b>	
Recommended thinner	T 141
Volume of thinner	5 - 15 %
Nozzle orifice	1.50 - 3.00 mm
Nozzle pressure	0.3-0.4 MPa (= approx 3-4 atm, 43-57 p.s.i)
Cleaning Thinner	T 141
<b>Airless Spray</b>	
Recommended thinner	T 141
Volume of thinner	0 - 15%
Nozzle orifice	0.46 - 0.64 mm
Nozzle pressure	15 MPa (= approx. 150 atm; 2100 p.s.i)
Cleaning Thinner	T 141
<b>Brush</b>	
Suitable for touch up in the small areas.	
Recommended thinner	T 141
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 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

- Zinc rich coatings are porous and hence pinholes may occur in the subsequent coat due to solvent popping. To minimize pinholes, apply a mist coat as the first pass of the subsequent coat, let the entrapped air escape and then apply full coat.
- Surfaces primed with Zinc rich primers without suitable topcoat when exposed to atmosphere forms zinc corrosion products which is also called as white rust. The extent of white rust formation will depend on the period of exposure of the zinc rich primer and the nature of the surrounding environment. Prior to application of the subsequent coats, it is necessary to ensure removal of the white rust. Use fresh water wash with nylon scrubber to remove white rust.
- It is recommended to achieve the required DFT of zinc rich primer in one coat application
- Should not be over-coated with coating containing saponifiable matter

<b>PACK SIZE</b>	20 ltrs (Base : 16 ltrs & Hardener : 4 ltrs)
<b>STORAGE</b>	<b>Shelf Life:</b> Atleast 6 months @ 30°C for original unopened pack, subject to inspection thereafter. Store in a cool, dry place and in accordance with local regulations
<b>REGULATORY INFORMATION</b>	<b>Flash Point:</b> Base : Not less than 24°C Hardener : Not less than 24°C <b>VOC:</b> Approx. 320 gm/ ltr (depending on shades) as per USA-EPA Method 24 <b>Product Weight:</b> Approx. 2.5 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

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