

SIGMACAP ZINC PRIMER EP

3 pages

April 2011

DESCRIPTION	two component polyamide curing zinc epoxy primer for atmospheric exposure
PRINCIPAL CHARACTERISTICS	<ul style="list-style-type: none"> - excellent corrosion prevention properties - offers improved impact resistance and flexibility in comparison with other zinc epoxy primers - quick drying, can be overcoated after a short period - can serve as a holding primer for various maintenance systems when a short overcoating interval is required - the superimposed system must be unsaponifiable
COLOURS AND GLOSS	grey – flat
BASIC DATA AT 23°C	(for mixed product)
Mass density	approx. 1.7 – 1.8 g/cm ³
Solids content	approx. 51% by volume
Recommended dry film thickness	35 - 50µm depending on blasting profile
Theoretical spreading rate	20 - 30 µm per coat
Touch dry after	14.6 m ² /ltr for 35 µm, 10.2 m ² /ltr for 50 µm
Overcoating interval	15 minutes*
Full cure after	min. 4 hours* max. several months*
Shelf life (cool and dry place)	7 days*
Flashpoint (DIN 53213)	12 months
RECOMMENDED SUBSTRATE CONDITIONS	base 29 °C - hardener 26 °C
	<ul style="list-style-type: none"> - steel; blast cleaned to ISO-Sa2½ - substrate temperature should be above 5°C and at least 3°C above the dew point during application and curing

*see additional data

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INSTRUCTIONS FOR USE

- Mixing ratio by volume base to hardener 78 : 22
- the temperature of the mixed base and hardener should be above 15 °C, otherwise extra solvent may be required to obtain the correct application viscosity
- too much solvent will result in lower sag resistance and slower cure
- thinner should only be added after proper mixing of the base and hardener

Induction time at 20 °C

none

Pot life

- 48 hrs @ 20°C, 24 hrs at 30°C

AIRLESS SPRAY

Recommended thinner

91-92 (flashpoint 20 °C)

Volume of thinner

0 - 20%, depending on dft to be applied

Nozzle orifice

approx. 0.43 - 0.48mm (0.017 - 0.019inch)

Nozzle pressure

150 bar (approx. 2100 p.s.i.)

AIR SPRAY

Recommended thinner

91-92 (flashpoint 20 °C)

Volume of thinner

0 - 20%,

Nozzle orifice

1.8 - 2.2 mm

Nozzle pressure

3 - 6 bar (approx. 43 - 85 p.s.i.)

BRUSH AND ROLLER

Recommended thinner

91-92 (flashpoint 20 °C)

Volume of thinner

0 - 5%

CLEANING SOLVENT

90-53 (flashpoint 30 °C)

SAFETY PRECAUTIONS



see safety sheets 1430 and 1431 and MSDS 7683 for information on LEL and TLV values

ADDITIONAL DATA

Film thickness and spreading rate

Dry film thickness in microns (µm)	35	50
Theoretical spreading rate (m ² /l)	14.6	10.2

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Overcoating table with
 Sigmacap Products
 Sigmacap Coating EP
 Sigmacap Mio EP
 Sigmacap Coaltar EP

Substrate temperature	15 °C	20 °C	30 °C
Minimum interval	5 hours	4 hours	3 hours
Maximum interval	several months when free from zinc salts and contamination		

- zinc primers can form zinc salts on the surface so should not be exposed to long periods prior to overcoating
- an interval of several months can be allowed under clean interior exposure conditions
- in clean exterior conditions an interval of 14 days can be tolerated, but in industrial or marine conditions this should be reduced to a practical minimum
- before overcoating any visible surface contamination must be removed sweep blasting or mechanical cleaning
- when a longer overcoating interval is required, it is recommended to overcoat the primer within two days with 7420 Sigmarite Sealer

Curing table

Substrate Temperature	Touch dry	Full Cure
15 °C	30 minutes	10 days
20 °C	15 minutes	7 days
30 °C	10 minutes	5 days
40 °C	5 minutes	3 days

- at temperatures below 5 °C the primer can be applied but the curing rate will be slow
- for such applications alternative Zinc primer is advised i.e. 7558 Sigmazinc 158 for systems exposed to atmospheric conditions

REFERENCES

explanation to product data sheets on information sheet 1411

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 Sigma Paints Saudi Arabia Ltd