

Two sheet issue

June 2008

<b>DESCRIPTION</b>
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general purpose zinc phosphate two component high build polyamide cured epoxy primer

<b>PRINCIPAL CHARACTERISTICS</b>
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- developed as an epoxy primer for steel and concrete structures in atmospheric exposure conditions
- easy to apply
- relatively long potlife at elevated temperatures
- good corrosion resistance
- resistant to splash and spillage of mild chemicals and solvents
- good wetting properties

<b>COLOUR AND GLOSS</b>
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red-brown - eggshell

<b>BASIC DATA AT 20 °C</b>
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( for mixed product )

**Mass density**

approx. 1.4g/cm<sup>3</sup>

**Solids content**

approx. 63% by volume

**Recommended dry film thickness**

50 - 100 µm\*

**Theoretical spreading rate**

12.6 m<sup>2</sup>/ltr for 50 µm\*

**Touch dry after**

approx. 3 hours

**Overcoating interval**

min. 10 hours\*  
max. 3 months\*

**Full cure after**

4 days

**Shelf life (cool, dry place)**

at least 12 months

**Flashpoint**

base 27 °C - hardener 28 °C

\* see additional data

<b>RECOMMENDED SUBSTRATE CONDITIONS</b>
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- concrete; dry and free from any contamination
- steel; blast cleaned to ISO-Sa2½ or power tool cleaned to SPSS-Pt3
- substrate temperature must be above 5 °C and at least 3 °C above the dew point

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## INSTRUCTIONS FOR USE

- mixing ratio: by volume; base to hardener 80 : 20
- 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 at 20 °C** 8 hours\*

### AIRLESS SPRAY

**Recommended thinner** Sigma thinner 91-92 (flashpoint 20 °C)

**Volume of thinner** 0 - 5%

**Nozzle orifice** approx. 0.48 mm (0.019 inch)

**Nozzle pressure** 150 bar (approx. 2100 p.s.i.)

### AIR SPRAY

**Recommended thinner** Sigma thinner 91-92 (flashpoint 20 °C)

**Volume of thinner** 5 - 10%

**Nozzle orifice** 1.5 - 3.0 mm

**Nozzle pressure** 3 - 4 bar (approx. 43 - 57 p.s.i.)

### BRUSH AND ROLLER

**Recommended thinner** Sigma thinner 91-92 (flashpoint 20 °C)

**Volume of thinner** 0 - 5%

### CLEANING SOLVENT

Sigma thinner 90-53 (flashpoint 30 °C)

## SAFETY PRECAUTIONS



see safety sheets 1430, 1431 and MSDS 7681 for information on LEL and TLV values

this is a solvent based paint and care should be taken to avoid inhalation of spray mist or vapour as well as contact between the wet paint and exposed skin or eyes

## ADDITIONAL DATA

**Film thickness and spreading rate**

<b>Dry film thickness in microns (µm)</b>	50	75	100
<b>Theoretical spreading rate (m<sup>2</sup>/l)</b>	12.6	8.4	6.3

Minimum dft for closed film with airless spray: 40 µm

Maximum dft for brush application: 50 µm

see sheet two

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**Overcoating table for the Sigma epoxy range**

<b>substrate temperature</b>	20 °C	30 °C	40 °C
<b>minimum interval</b>	10 hours	8 hours	6 hours
<b>maximum interval</b>	3 months	2 months	1 month

**Overcoating table for the Sigma Polyurethane range**

<b>substrate temperature</b>	20 °C	30 °C	40 °C
<b>minimum interval</b>	24 hours	16 hours	12 hours
<b>maximum interval</b>	3 months	2 months	1 month

**Curing table**

<b>Substrate temperature</b>	<b>Dry to handle</b>	<b>Full cure</b>
20 °C	10 hours	4 days
30 °C	7 hours	3 days
40 °C	5 hours	2 days

adequate ventilation must be maintained during application and curing (refer sheets 1433 and 1434)

**Pot life (at application viscosity)**

<b>Paint temperature</b>	<b>Pot life</b>
20 °C	8 hours
30 °C	6 hours
40 °C	4 hours

**REFERENCES**

explanation to product data sheets on information sheet 1411

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