

## TECHNICAL DATA SHEET

### PURE EPOXY PRIMER

#### **PRODUCT DESCRIPTION:**

Pure Epoxy Primer is a 2-component, ready to mix, polyamide cured, epoxy industrial zinc phosphate primer, free from chromate and lead containing pigments.

It is recommended to be used as an anticorrosive primer in coating systems for steel structures and fuel tanks in chemical plants, power stations, ship building yards and sea port equipment.

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#### **INFORMATION ABOUT THE PRODUCT:**

COLOUR:	Gray, red-brown, beige and Off-white/mat.
SOLID CONTENT :	50 ± 2% b.v.
SPECIFIC GRAVITY:	1.33 ± 0.05 kg/L at 20°C.
RECOMMENDED D.F.T.:	50 - 100 µm
MIXING RATIO:	A:B = 4:1 b.v.
DRYING TIME: (23 °C & 50% RH)	Dust free: 2 hr. Dry hard: 3-4 hrs.
THEORETICAL COVERAGE:	9.5-10 m <sup>2</sup> /L for 50 µm D.F.T. The actual coverage may be less, depending on application technique, job conditions and the nature of surface to be coated.
THINNING:	If it is necessary with Smaltosolvent NR-640 to adjust working viscosity. Add thinner after mixing the two components.
POT LIFE:	6 hrs at 23 °C, depends on ambient temperature.
TOP COATING: (23 °C & 50% RH)	Min after 8 hrs. Max no limit.

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#### **APPLICATION:**

By air spraying, airless, roller or brush.

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#### **SURFACE PREPARATION:**

- All steel works, including welding, flamecutting and gridding must be finished before the surface preparation.
- All weld spatters must be removed.
- Remove oil, grease and other contamination with suitable detergent, fresh water and scrubbing.
- Alkali deposits on new welding seams as well as soap traces must be removed by fresh water and scrubbing.
- Grind blast to min Sa 2, ISO 8501-1 or for severe exposures to Sa 2 ½ with a profile of approximately 30 µm, is mandatory for optimum results.

## **PURE EPOXY PRIMER**

- The most safe working conditions are:
  - Steel temperature at least 3°C above dew point.
  - Relative humidity preferably less than 75%
  - Application temperature 10 - 35°C.
- Before top coating, primed surfaces should be cleaned from oil, grease dirt and other contaminants.
- Derusting of damages caused during transportation, handling and erection to min St 3.
- Top coating with any coating system, preferably with epoxy or polyurethane paint.

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**SHELF LIFE:**

At least, one year in closed original container at max 35°C.

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