



## APCODUR EPOXY ZINC RICH PRIMER

Two component, polyamide cured epoxy zinc rich primer

- Designed as a system primer in various paint systems

- Good corrosion prevention properties

### TECHNICAL DATA

Colour	Grey	Drying time at 30° C	Surface dry : 30 minutes Hard dry : 16 hours Full cure : 7 days
Gloss	Matt	Over coating Interval at 30° C	Min. : 16 hours Max.: Unlimited, provided surface is completely free from corrosion, contamination and zinc salt
Volume Solids	Approx. 38 %		
Recommended DFT/ Coat	35 - 50 microns	Shelf Life (cool and dry place)	At least 6 months
Theoretical covering capacity	10.9 sq.mtr/ l @ 35 microns DFT 7.6 sq.mtr/ l @ 50 microns DFT		
Flash point	Base : Not less than 24° C Hardener : Not less than 24° C		

#### Over coating Procedure

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.

Zinc rich primers, when exposed for extended periods of time without proper top coating, will start showing white rust formation. These "white rust" spots are zinc corrosion products. The extent of white rust formation will depend on the period of exposure of the zinc rich coating and the nature of the surrounding environment. Prior to application of the subsequent coats, it is necessary to ensure removal of the white rust.

#### Note:

Continuous stirring is required during the application to avoid settling of zinc dust.

### DIRECTIONS FOR USE

#### SURFACE PREPARATION & SUBSTRATE CONDITION:

- Steel, blast cleaned to Sa 3/ 2.5 of Swedish specification
- Substrate temperature must be at least 3° C above dew point but not above 50° C

#### MIXING

Stir the base and hardener separately. If settling is observed in the base, loosen the settled material with the help of hand stirrer followed by power driven stirrer for quick homogenous mixing. Mix hardener gradually into the base under continuous stirring.

Mixing Ratio (by volume)	Base : Hardener 3 : 1	Induction time Pot life at 30° C	30 minutes 6 hours
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#### APPLICATION

Application Method	Brush/ Roller (for touch up only)	Air Spray	Airless Spray
Recommended thinner	T - 121/ T - 141	T - 121/ T - 141	T - 121/ T - 141
Volume of thinner	0 - 5%	0 - 10 %	0 - 10 %
Nozzle Orifice		1.5 - 3.00 mm	0.46 - 0.64 mm
Nozzle pressure		0.3 - 0.4 MPa (= approx 3 - 4 atm; 43 - 57 p.s.i.)	15 - 16 MPa (= approx. 150 - 160 atm; 2100 - 2300 p.s.i.)

#### Note:

- Continuous stirring is required during the application to avoid settling of zinc dust
- It is recommended to achieve the required DFT of zinc rich primer in one coat application
- Should not be overcoated with coating containing saponifiable matter

### STORAGE & PACKING

Storage : Store in a cool, dry place. Store in accordance with local regulations.

Packing : 20 litres

### 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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