



APCODUR HB RED OXIDE ZINC PHOSPHATE PRIMER

Two component, high build polyamide cured epoxy primer with red oxide and zinc phosphate pigments

- Designed as an epoxy primer or build coat in protective coating systems
- Excellent resistance to saline, marine and chemical environments
- Free from lead and chromate containing pigment
- Good adhesion on steel and aged epoxy coatings

TECHNICAL DATA

Colour	Red oxide	Drying time at 30° C	Surface dry : 1 hour
Gloss	Matt		Hard dry : 16 hours
Volume Solids	Approx. 52 %	Over coating Interval at 30° C	Full cure : 7 days
Recommended DFT/ Coat	35 - 50 microns		Min. : 16 hours
Theoretical covering capacity	14.9 sq.mtr/ l @ 35 microns DFT 10.4 sq.mtr/ l @ 50 microns DFT	Shelf Life (cool and dry place)	Max.: 1 month, provided surface is dry and clean from all contamination
Flash point	Base : Not less than 24° C Hardener : Not less than 24° C		At least 12 months

DIRECTIONS FOR USE

SURFACE PREPARATION & SUBSTRATE CONDITION:

- Steel; blast cleaned to Sa 2.5 of Swedish specification
- If blast cleaning is impractical, remove loose rust/ scale using power tools to achieve St3 grade of surface preparation, as per Swedish standards. Remove contaminants like grease, oil etc. with aromatic solvents. Ensure the surface is clean and dry before priming
- Surface temperature must be atleast 3° C above dew point but not above 50° C

MIXING

Stir the base and hardener separately. If settling is observed in the base or hardener, 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 as follows:

Mixing Ratio	Base : Hardener	Induction time	30 minutes
(by volume)	3 : 1	Pot life at 30° C	5 hours

APPLICATION

Application Method	Brush	Air Spray	Airless Spray
Recommended thinner	T - 121/ T - 141	T- 121/ T - 141	T - 121/ T - 141
Volume of thinner	0 - 15 %	5 - 20 %	0 - 15%
Nozzle Orifice		1.5 - 3.00 mm	0.33 - 0.41 mm
Nozzle pressure		0.3 - 0.4 MPa (= approx. 3 - 4 atm; 43 - 57 p.s.i.)	16 - 20 MPa (= approx. 160 - 200 atm; 2300 - 2800 p.s.i.)

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.

Disclaimer: To the best of our knowledge the information provided herein are true and accurate at the date of issuance. Since we have no control over the quality or condition of the substrate or the various factors affecting the use and application of the product, we do not accept any responsibility or liability arising out of use of the product.

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