



APCOMIN HB ZINC PHOSPHATE PRIMER

Single pack, air drying phenolic modified oleoresinous composition with zinc phosphate pigment

- Anti-corrosive primer for use in marine and mildly corrosive environment
- Good adhesion to prepared steel
- Heat resistance upto 175° C (dry heat)
- Easy application by brush

TECHNICAL DATA

Colour	Red oxide & Grey	Drying time at 30° C	Surface dry : 1 hour Hard dry : 16 hours
Gloss	Matt	Over coating interval at 30° C	Min.: 16 hours Max.: Unlimited, provided surface is dry and clean from all contamination
Volume solids	Approx. 46%	Shelf life (cool and dry place at 30° C)	At least 12 months
Recommended DFT / Coat	30 - 40 microns		
Theoretical covering capacity	15.3 sq. mtr/l at 30 microns DFT 11.5 sq. mtr/l at 40 microns DFT		
Flash point	Not below 30° C		

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/ hand tools to achieve St3/ St2 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.
- Substrate temperature must be at least 3° C above dew point but not above 50° C.

MIXING

If settling is observed in the drum, loosen the settled material with the help of hand stirrer followed by power driven stirrer for quick homogenous mixing.

APPLICATION

Application Method	Brush/Roller	Air Spray	Airless Spray
Thinner	T 284	T 284	T 284
Thinner intake	0 - 5% by volume	5 - 15% by volume	0 - 10% by volume
Nozzle orifice		1.5 - 3.0 mm	0.38 - 0.46 mm
Spray pressure		0.3 - 0.4 MPa (= approx. 3 - 4 atm; 43 - 57 p.s.i)	12 - 15 MPa (= approx. 120 - 150 atm; 1700 - 2100 p.s.i)

STORAGE & PACKING

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

Packing : 20 litre packs

SAFETY INFORMATION

As a general safety measure, inhalation of solvent vapours or paint mist and contact of liquid paint with skin and 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 to our Material Safety Data Sheet prior to using the product.

Disclaimer: To the best of our knowledge the information provided herein is 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. The company reserves the right to modify data contained herein without prior notice. Any change in data would normally be followed by issue of a new data-sheet. The user should check with the nearest sales office of the company and confirm the validity of the information, prior to using the product.

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