

Apcodur Epoxy Zinc Phosphate Primer

Two pack, polyamide cured, air drying high build epoxy primer containing zinc phosphate pigments.

Features

- * Designed for use as a primer for steel as well concrete
- * Excellent resistance to saline, marine and chemical environments
- * Good adhesion properties for subsequent coats
- * Good adhesion on concrete, steel and aged epoxy coatings

Technical Data

Colour	:	Grey
Gloss	:	Matt
Volume solids	:	Approx. 48 %
Recommended DFT/ Coat	:	35 -50 microns
Theoretical covering capacity	:	13.7 m ² / l @ 35 microns DFT
	:	9.6 m ² / l @ 50 microns DFT
Drying time at 30°C	:	Surface dry - 1 hour
	:	Hard dry - 16 hours
	:	Full cure - 7 days
Overcoating interval at 30°C	:	Min. : 16 hours
	:	Max. : 30days, provided surface is dry and clean contamination.
from all		
Shelf life (cool & dry place)	:	at least 12 months
Flash point	:	Base - Not less than 28°C
	:	Hardener - Not less than 28°C

Directions for use

Surface Preparation & Substrate Condition

- * Steel; blast cleaned to Sa 2½ 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.
- * Substrate temperature must be atleast 3°C above dew point but not above 50°C

New concrete surface

Ensure that the concrete surface is cured for minimum 3 months. In case of large areas and for severe exposure conditions, the surface has to be prepared by light blasting. In less critical areas where blasting is not practical, wire brushing has to be adopted to remove lattices, followed by treating with dilute (10%) hydrochloric acid.

Remove acid and contaminants by liberal wash with water. Ensure that acid solution does not retain on the surface & joints. Allow the surface to dry thoroughly before applying primer.

Old concrete surface

Remove the surface contaminants like grease, oil etc., by solvent wiping or by 10% caustic solution. Preferably the surface has to be prepared by light blasting. In case, blasting is not practical, etch the surface to get a good profile by treating white dilute (10%) hydrochloric acid. Remove acid and contaminants by liberal wash with water. Ensure that acid solution does not retain and penetrate through the joints and concrete surface. Allow the surface to dry thoroughly before applying primer.

- * Surface should be thoroughly dry before application of primer. This will have a major influence on the performance of the coating.

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

Application

Brush

Recommended thinner	:	T - 121 / T 141
Volume of thinner	:	0- 10 %

Air Spray

Recommended thinner	:	T - 121 / T 141
Volume of thinner	:	5 - 20 %
Nozzle Orifice	:	1.5 - 3.00 mm
Nozzle Pressure	:	0.3- 0.4 MPa (43-57 p.s.i.)

Airless Spray

Recommended thinner	:	T - 121/ T 141
Volume of thinner	:	0 - 15%
Nozzle orifice	:	0.33 - 0.41 mm
Nozzle pressure	:	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 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.