

**DESCRIPTION**

Two-component epoxy, micaceous iron oxide primer – sealer-coatings.

**PRINCIPALS CHARACTERSTICS**

- Prevents Corrosion Under Insulation
- Excellent adhesion ,sealing and weathered resistant
- Good adhesion to properly galvanized steel
- Can be used for atmospheric exposure systems, water-immersed exposure conditions
- Good abrasion and impact resistance
- Resistant to temperature up to 200°C(390°F)in dry atmospheric exposure conditions

**COLOR AND GLOSS LEVEL**

- Redbrown,greenish grey
- Low metallic sheen

**BASIC DATA AT 20°C (68°F)**

Data for mixed product	
Number of component	two
Mass density	1.6 kg/l
Volume solid	80 ±2 %
VOC (supplied)	Max 374 g/l
Recommended dry film thickness	100 – 200 µm (4 – 8 mils)depending on the system
Theoretical spreading rate	8 m <sup>2</sup> /l for 100 µm
Dry to touch	2 hours
Over coating interval	Min: 8 hours Max: 1 month
Full Cure	7 days
Shelf life	Base 24 months when stored cool and dry Hardener 24 months when stored cool and dry



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## Recommended substrate conditions and temperatures

### SUBSTRATE CONDITIONS

- Steel blast cleaned to ISO-SA2 ½, blasting profile 40 – 70 µm (1.6 – 2.8 mils)
- Shop primed steel, sweep blasted to SPSS-Ss or power tool cleaned to SPSS-Pt3
- Zinc reach epoxies and zinc silicates must be dry and free from any contamination
- Galvanized steel for atmospheric exposure conditions and for water immersed conditions sweep blasting is required
- Stainless steel ,Nonferrous metals should be sufficiently roughened by sanding
- Compatible previous coat must be dry and free from any contaminations

### Substrate temperatures and application conditions

- Substrate temperature during application and curing should be above 10°C(50°F)
- Relative humidity during application and curing should not exceed 85%
- Ambient temperature during applications at 5°C(41°F)is acceptable however curing to hardness takes longer and complete cure will be reached when the temperature increased

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## Instruction for use

### Mixing ratio by volume base to hardener 80:20

- Temperature of the mixed base and hardener preferably above 15°C(59°F)
- Adding to much thinner results in reduced sag resistance and slower cure.
- Thinner should be added after mixing two components



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Induction time

None

Pot life

8 hours @20°C (68 °F)

Air spray

**Recommended thinner**

Thinner no 90

Volume of thinner

10 to 30% depending on required thickness and application conditions

Nozzle orifice

1.5 – 2 mm

Nozzle pressure

0.3 – 0.4 MPA

Airless spray

**Recommended thinner**

Thinner no 90

Volume of thinner

1 to 10%, 30:40% when mist coat applied

Nozzle orifice

0.48 – 0.53 mm (0.019 – 0.021 in)

Nozzle pressure

12.0 – 0.15 MPA



**BRUSH / ROLLER****Recommended thinner**

Thinner no 90

Volume of thinner

0 – 5 %

**Cleaning thinner****Thinner No 50****ADDITIONAL DATA**

Spreading rate and film thickness	
DFT	Theoretical spreading rate
50 µm (2 mils)	13m <sup>2</sup>
100 µm (3.1 mils)	6m <sup>2</sup>

Curing time for DFT up to 100 µm (4 mils)			
Substrate temperature	Dry to touch	Dry to handle	Full cure
5°C (41°F)	8 HOURS	18 HOURS	N/A
10°C (50°F)	5 HOURS	8 HOURS	15 DAYS
20°C (68°F)	2 HOURS	4 HOURS	7 DAYS
25°C (77°F)	1.5 HOURS	4 HOURS	5 DAYS



Over coating interval for DFT up to 50 microns (2mils)					
Over coating with	Interval	10°C (50°F)	20°C (68°F)	30°C (77°F)	40°C (104°F)
Two component epoxies and poly urethanes	Minimum	16 hours	8 hours	6 hours	4 hours
	Maximum	6 months	6 months	3 months	3 months

Over coating interval for DFT up to 100 microns (4 mils)					
Over coating with	Interval	10°C (50°F)	20°C (68°F)	30°C (77°F)	40°C (104°F)
Two component epoxies and poly urethanes	Minimum	32 hours	16 hours	12 hours	8 hours
	Maximum	28 days	28 days	14 days	7 days

Pot life (application viscosity)	
Mixed product temperature	Pot Life
15°C (59°F)	10 HOURS
20°C (68°F)	8 HOURS
25°C (86°F)	6 HOURS
30°C (77°F)	5 HOURS
35°C (95°F)	4 HOURS

**SAFETY PRECAUTIONS**

- This is a solvent- borne paint and care should be taken to avoid inhalation of spray mist or vapor, as well as contact between the wet paint and exposed skin or eyes

