

DESCRIPTION

Two-component, surface - tolerant, high build cured epoxy primer -coating

PRINCIPALS CHARACTERSTICS

- Excellent corrosion resistance
- Good flexibility
- Surface tolerant coating for lower grade of steel preparation
- Good drying and curing property
- Easy application by air less spray, brush, etc.

COLOR AND GLOSS LEVEL

- Gray ,off white (other color available on request)
- Aluminum (dark ,light)
- Egg shell

BASIC DATA AT 20°C (68°F)

| Data for mixed product | |
|--------------------------------|--|
| Number of component | two |
| Mass density | 1.46 kg/l |
| Volume solid | 80 ±2 % |
| VOC (supplied) | Max 240 g/L |
| Recommended dry film thickness | 75 – 200 µm (3 – 8 mils)depending on the system |
| Theoretical spreading rate | 10.7m ² for 75 µm |
| Dry to touch | 3 hours |
| Over coating interval | Minimum:8hours Maximum: Extended |
| Full cure after | 7days |
| Shelf life | Base: at least 12 months when stored cool& dry Hardener: at least 24 months when stored cool& dry |



Recommended substrate conditions and temperatures

Atmospheric exposure conditions

- Steel blast cleaned to ISO-SA2 ½, for excellent corrosion protection
 - Shop primed steel pretreated to SPSS-Pt2
 - Galvanized steel must be sweep blasted or roughened.
 - Stainless steel: degreased and sweep blast (sspc sp-16) cleaned to roughness of 40 -70 µm
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Immersion exposure

- Steel blast cleaned, to ISO-SA2
 - Steel with approved zinc silicate shop primer ,sweep blasted to SPSS –Ss or power tool cleaned to SPSS –Pt3
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SUBSTRATE TEMPERATURE

- Substrate temperature during application and curing should be above 5°C(41°F)
 - Relative humidity during application and curing should not exceed 85%.
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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 too much thinner results in reduced sag resistance and slower cure.
 - Thinner should be added after mixing two components
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Induction time

Non



Pot life

4 hours @20°C °(68 °F)

Air less spray

Recommended thinner

Thinner no 90

Volume of thinner

0 to 10% depending on required thickness and application conditions

Nozzle orifice

0.46 – 0.53 mm

Nozzle pressure

20 – 25 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 |
| 75 µm (3 mils) | 10.7m ² |
| 150 µm (6 mils) | 5.3 m ² |
| 200 µm (8 mils) | 4 m ² |

| Curing time for DFT up to 125 µm (5 mils) | | | |
|---|--------------|---------------|-----------|
| Substrate temperature | Dry to touch | Dry to handle | Full cure |
| 5°C (41°F) | 24 HOURS | 48 HOURS | 20 days |
| 10°C (50°F) | 12 hours | 24 hours | 14 days |
| 20°C (68°F) | 3 hours | 8 hours | 7 days |
| 30°C (86°F) | 2 hours | 6 hours | 4 days |
| 40°C (104°F) | 1 hours | 3 hours | 3 days |

| Pot life at application viscosity | |
|-----------------------------------|----------|
| Mixed product temperature | Pot life |
| 10°C (50°F) | 10 hours |
| 15°C (59°F) | 6 hours |
| 20°C (68°F) | 4 hours |
| 30°C (86°F) | 2 hours |
| 40°C (104°F) | 1 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 eye

Disclaimer

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