

EPOXY ZINC PRIMER (1 PACK)

PRODUCT DESCRIPTION

A single pack epoxy shop primer with a high zinc content for the protection of steel structures against corrosion during construction.

USES

Ideal for blast cleaned steel where a fast drying time is required. Can be overcoated with a variety of topcoats. This product can be used for the maintenance of zinc based primers.

TECHNICAL PROPERTIES

Colour	Grey
Finish	Matt
Curing Agent	n/a
Mix Ratio	n/a
Specific Gravity	2.25
Volume Solids	38%
Recommended Film Thickness	60-90µm WFT / 23-34µm DFT
Theoretical Spreading Rate	11-16 m ² /litre
Application Method	Brush, Roller, Spray
Flash Point	<12°C
VOC	560 g/litre

Drying Times	10°C	20°C	30°C
Touch Dry	6 minutes	3 minutes	2 minutes
Hard Dry	8 hours	4 hours	3 hours
Minimum Overcoat	12 hours	6 hours	4 hours
Maximum Overcoat*	Indefinite	Indefinite	Indefinite

* The surface should be dry and free from contaminants prior to overcoating. The best intercoat adhesion is achieved when the subsequent coat is applied before the preceding coat is fully cured. After prolonged exposure times it may be necessary to roughen the surface to ensure intercoat adhesion.

CERTIFICATION/APPROVALS

RECOMMENDED SYSTEMS

Bondon Primers, Bondon Topcoats, Epoxy Finishes, Hi-Dur AD100, Hi-Dur PU100

SURFACE PREPARATION

- Steel:** Ensure surfaces are clean, dry and free from dirt, grease and other contamination. Remove weld spatter and smooth weld seams and sharp edges as applicable. Blast clean to a minimum SA2½ and prime within 2 hours.
- Repair:** Corroded areas should be power tooled cleaned to ST3 or blast cleaned to SA2 or better. Existing systems should be dry and free from loose paint, salt, grease and other contaminants prior to overcoating.

PRODUCT APPLICATION

Mixing	Stir thoroughly before use.
Thinners	Thinner No.5
Brush	Use as supplied
Roller	Use as supplied
Conventional Spray	Thin up to 10% Thinner No.5 Use 40-50 psi pressure and 1.8 mm diameter nozzle.
Airless Spray	Use tip 0.38-0.53 mm, 40-80° angle and 2000-2500 psi pressure.
Air Assisted Airless Spray	Thin up to 5% Thinner No.5 Use 1000-1500 psi pressure, 50-65° angle and 1.5-1.8 mm diameter nozzle.
Cleaner	Thinner No.5
Cleanup Considerations	All equipment should be cleaned immediately after use with Thinner No.5 It is advisable that equipment should be cleaned/flushed during the course of application, the frequency of which will depend on the volume of material used and timescale over which applied. Ensure all waste materials (including packaging) are disposed of in accordance with local regulations.

HEALTH, SAFETY & ENVIRONMENTAL

This product must be used in accordance with the Material Safety Data Sheet supplied by Spencer Coatings Limited. The user must observe local health, safety and environmental regulations when using this product. Consult Spencer Coatings Limited if there are any concerns over the suitability of this product.

PACK SIZES

5 litre.

PACK WEIGHTS

5 litre: 11.25 Kg.

STORAGE CONDITIONS

Store away from extremes of temperature.
Shelf life 6 months in unopened tins.
Ensure water contamination is avoided.

LIMITATIONS

Do not apply when RH exceeds 85% or the surface is less than 3°C above dew point.
Air temperatures and relative humidity must be measured in the vicinity of the substrate.
Do not apply to damp surfaces.
Excessive coats may produce mild cracking.
Drying may be affected on surfaces below 5°C.

DISCLAIMER

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It is the user's responsibility to ensure that this sheet is current prior to using the product.