DESCRIPTION

It is a Surface Tolerant Primer, two-component, high solids polyamine adduct cured epoxy coating.

PRINCIPAL QUALITIES

- Can be applied directly to metal
- Very good surface wetting
- Excellent anti-corrosive properties
- Superb salt water resistance

COLOR AND GLOSS LEVEL

- Standard Colours Available
- Gloss

BASIC INFORMATION AT 20°C (68°F)

Information for mixed product	
Number of components	Two
Mass density	1.6 kg/l (13.4 lb/US gal)
Volume solids	74%
VOC (Supplied)	Directive 1999/13/EC, SED: max. 158.0 g/kgmax. 221.0 g/l (approx. 1.8 lb/US gal)
Recommended dry film thickness	150 - 250 µm (6.0 - 10.0 mils) depending on requirements
Theoretical spreading rate	5.5 m²/l for 150 µm (219 ft²/US gal for 6.0 mils)
Touch dry	1.5 hrs
Overcoating Interval	1.5 to 6 hours depending on ambient temperature
Shelf life	Base: at least 24 months when stored cool and dry Hardener: at least 24 months when stored cool and dry

RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES

Immersion exposure

- Steel; blast cleaned to ISO-Sa2½, blasting profile 40 – 70 µm (1.6 – 2.8 mils)
- Steel with approved zinc silicate shop primer; pretreated according to SPSS-Ss

Atmospheric exposure conditions

- Steel; pretreated preferably to ISO-Sa2½, , blasting profile 40 – 70 µm (1.6 – 2.8 mils) or according to ISO-St3
- Shop primed steel; pretreated to SPSS-Pt3

Substrate conditions

- Previous coat (specific epoxy) must be dry and free from any contamination and within overcoating time

Substrate temperature

- Substrate temperature during application and curing should be above 5°C (41°F)
- Substrate temperature during application and curing should be at least 3°C (5°F) above dew point

INSTRUCTIONS FOR USE

Mixing ratio by volume: base to hardener 75:25 (3:1)

- The temperature of the mixed base and hardener should be above 10°C (50°F), otherwise extra thinner may be required to obtain application viscosity
- Adding too much thinner results in reduced sag resistance and slower cure
- Thinner should be added after mixing the components

Pot life

2 hours at 20°C (68°F)

Note: See ADDITIONAL DATA - Pot life

Airless spray

Volume of thinner
0 - 5%, depending on required thickness and application conditions

Nozzle orifice
Approx. 0.48 - 0.53 mm (0.019 - 0.021 in)

Nozzle pressure
15.0 MPa (approx. 150 bar; 2176 p.s.i.)

ADDITIONAL DATA

Spreading rate and film thickness	
DFT	Theoretical spreading rate
150 µm (6.0 mils)	5.5 m²/l (219 ft²/US gal)
250 µm (10.0 mils)	3.3 m²/l (132 ft²/US gal)

Curing time for DFT up to 150 µm (6.0 mils)	
Substrate temperature	Service- water immersion
5°C (41°F)	10 days
10°C (50°F)	7 days
15°C (59°F)	5 days
20°C (68°F)	3 days
30°C (86°F)	60 hours
40°C (104°F)	36 hours

Pot life (at application viscosity)	
Mixed product temperature	Pot life
15°C (59°F)	3 hours
20°C (68°F)	2 hours
30°C (86°F)	1 hour
40°C (104°F)	30 minutes

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