ROPOXY PRIMER 621

Description

two component general purpose high build polyamide cured zinc phosphate epoxy primer.

Principal Characteristics

- Epoxy primer for steel structures
- For atmospheric exposure.
- Easy to apply by spray, roller or brush.
- Suitable long pot life for tropical conditions
- Good corrosion resistance
- Resistant to splash and spillage of mild chemicals and solvents.
- Good adhesion properties on steel structures

Technical data

Color & gloss	Red brown – White - gray / eggshell
Flash point (DIN 53213)	Base 27 ºC hardener 28 ° C.
Mass density	Approx. 1.38 gm. / cm3
Solid content	Approx. 54 ± 2 by volume
Theoretical spreading rate	10.8 m2/Kg for 50 ums.
Touch dry after	Approx. 3 hours
Recommended Dry film thickness	50 – 100 um
Over coating interval	Min. 10 hours. max. 3 months
Full cure after	4 days
Shelf life (cool and dry place)	At least 12 months
Recommended substrate conditions	Concrete ; dry free from any contamination steel : blast cleaned to ISO – Sa 2.5 or power tool cleaned to SPSS – ST3

Instruction for use

Mixing ratio by weight: base to hardener **8 : 1**

- The temperature of the mixed base and hardener should be above 15ºC otherwise extra solvent may be required to obtain application viscosity.

- too much solvent results in lower sag resistance and slower cure.
- Thinner should be only added after proper mixing of the base and hardener.

Pot life at 20 °C : 8 hrs.

Recommended thinner: Roots thinner No. RO10455 (flash point 26 °C)

Airless spray

Volume of thinner : 0 - 5 % depending on required D.F.T.

Nozzle orifice : approx. 0.48 mm(= 0.019 inch)

Nozzle pressure : 0.5 MPa (= Approx. 150 at ; 2100 p.s.i)

Air spray

Volume of thinner : 5-10 % depending on required D.F.T.

Nozzle orifice : 1.5 – 3 mm

Nozzle pressure : 0.3 – 0.4 MPa (= Approx. 3-4 at ; 43-57 p.s.i.

Brush / Roller

Volume of thinner : 0 - 5 %

Cleaning solvent :Roots thinner no.1003 (flash point 26° C)

Additional data

Max. dft without sagging with airless spray :150 um

Min. dft for closed film with airless spray : 40 um

Max dft when brushing : 50 ums

Curing table substrate

Temperature	Dry to handle	full cure handle
20 ° C	10 hours	4 days
30 ° C	7 hours	3 days
40 ° C	5 hours	2 days

Pot life @ 20 °C. 8 hours