ROPOXY ZINC PRIMER 625

Description
two component polyamide cured zinc epoxy primer .

Principal Characteristics

- Designed as a system primer for various paint systems.
- Suitable long pot life for tropical conditions.
- Good corrosion prevention properties.
- Quick drying can be over coated after a short interval.
- Can serve as a holding primer for various maintenance systems.
- The superimposed system must be unsaponifiable.

Technical data (for mixed product)

Color & gloss	Grey – flat
Flash point (DIN 53213)	Base 27 ºC hardener 28º C.
Mass density	Approx. 2.9 gm. / cm3
Solid content	Approx. 73 ± 2 by volume
Theoretical spreading rate	14.0 m2/Kg for 50 um.
Zn dust in dry film thickness%	90%
Touch dry after	Approx. 15 mins
Recommended Dry film thickness	25 – 50 um (depending upon blast profile). Dry film thickness of more than 50 microns are not recommended underneath thick, rigid epoxy systems .
Wet film thickness	65 – 70 µ
Over coating interval	Min. 6 hours. Max. 3 months
Full cure after	7 days
Pot life	24 hrs.
Shelf life (cool and dry place)	At least 6 months
Recommended substrate conditions	steel : blast cleaned to ISO – Sa 2.5 or power tool cleaned to SPSS – ST3 - blasting profile (Rz) – 70 um .

Mixing ratio (by weight)	Base 16 : hardener 1
Instruction for use	Substrate temperature should be at least 5 ° C and at least 3 ° C above the dew point during application and curing rate will be very low. • The temperature of the mixed base and hardener should be above 15 ° C, otherwise extra solvent may be required to obtain the correct 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.
Recommended thinner	Roots thinner no 10455(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 27° C)

Additional data

Curing table:

Substrate temperature	Dry to handle
20ºC	6 Hrs.
30ºC	7 Hrs.
40ºC	5 Hrs.

- Zinc rich primers can form zinc salts on the surface, they should not be weather for long periods prior to over coating.
- Internal ; in clean exposure conditions an interval of several months can be allowed
- External ; in normal exposure conditions a maximum interval of 14 days can be tolerated , but in industrial or marine conditions this interval should be reduced to a practical minimum .
- Before over coating, visible surface contamination must be removed by high pressure fresh water cleaning, sweep blasting or mechanical cleaning.