ROPOXY ZINC PRIMER 631

Description

: two component polyamide cured zinc dust 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
Zinc dust in D.F.T	65%
Flash point (DIN 53213)	Base 27 ºC hardener 28 ° C.
Mass density	Approx. 2.6 gm. / cm3
Solid content	Approx. 44 ± 2 by volume
Theoretical spreading rate	15.0 m2/ltr for 25 ums.
Touch dry after	Approx. 15 mins
Recommended Dry film thickness	25 – 50 ums (depending upon blast profile). dry film thickness of more than 50 microns are not recommended underneath thick, rigid epoxy systems.
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 ums.

Instruction for use: by weight: base to hardener **16 : 1**

- 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. 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. RO1003 (flash point 26 °C)

Additional data

Curing table

Substrate Temperature	Dry to handle
20 ° C	6 hours
30 ° C	7 hours
40 ° C	5 hours

- 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