

# Technical Data Sheet (TDS)



## ARMEPOX® PRIMER 041 UHS

### DESCRIPTION:

A two-component, high-solids epoxy coating. Fast-drying, it is designed to meet the requirements of new construction, where minimizing overcoating and drying times is essential to expedite subsequent work. Contains zinc phosphate, providing reliable corrosion protection. It can be used as a primer or intermediate coat in protective coating systems for properly prepared carbon steel surfaces. It can be applied at temperatures down to -5°C.

### STANDARD USE:

Anti-corrosion protection of metal structures, buildings and structures in civil engineering, the petrochemical complex, and transport construction, operating in various corrosive environments:  
C2-C5 (ISO 12944-2)

### TECHNICAL SPECIFICATIONS:

Color	gray, reddish-brown (shade is not standardized)
Solids by Volume, %	70-72%
Gloss level	semi-matte
Density	1.4-1.5 g/cm <sup>3</sup>
Theoretical consumption (excluding losses)	180 g/m <sup>2</sup> - 100 microns
Drying time: stage 3 (touch dry) DFT 100 µm	1 hour, 20°C
Thickness of one layer (recommended)	70-150 microns
Viscosity	thixtropic
Adhesion	1 point (GOST 15140) 5 MPa (not less) GOST 32299

### APPLICATION METHOD

#### **Airless spraying (ALS)**

Recommended thinner: Thinner 7, up to 5% by weight  
Nozzle diameter 0.015" - 0.021" (0.38 - 0.53 mm)  
The pressure at the nozzle is not less than 160 MPa (160 bar)  
Note: Data for BVR application may vary depending on equipment configuration.

#### **Air spraying**

Recommended thinner: Thinner 7  
The amount of thinner is up to 10% by weight  
Nozzle diameter 1.8 - 2.5 mm  
Pressure 0.3 - 0.4 MPa (3 - 4 bar)

#### **Brush/roller**

The recommended thinner is Thinner 7 to 10% by weight. A brush should only be used for stripe coating. Using a roller for the first coat is not permitted.

**MIXING PROPORTIONS**

Mixing proportions		% by weight, g	% by volume, ml
<b>Component A</b>	Primer 041 UHS	100	100
<b>Hardener</b>	Hardener 5	15	25

Thinner 7

**POT LIFE**

3 hours. 20°C

**SURFACE PREPARATION****Carbon steel**

Surface preparation shall be carried out in accordance with GOST 9.402:

-first degree of degreasing

- abrasive blast cleaning to grade 2 according to GOST 9.402, Sa 2½ (ISO 8501-1). Surface profile 30-70 µm.

The weld seams, edges, and overall surface must be prepared to grade P2 (ISO 8501-3). For hard-to-reach areas, preparation up to grade St2 (ISO 8501-1) is permitted.

**Primed surface or old coating without traces of corrosion**

Thoroughly remove oil and grease stains using an appropriate detergent. Remove salts and other contaminants.

Check the compatibility of the old coating with ARMEPOX® PRIMER 041 UHS. Roughen the surface if necessary. Remove dust.

**APPLICATION CONDITIONS**

The coating should be applied only to a dry and clean surface. The surface temperature must be 3°C above the dew point. The minimum application temperature is -5°C (make sure there is no ice on the surface). The maximum humidity is 85%.

The primer temperature must be at least 15°C. Lower temperatures will increase viscosity, which may require additional thinner, resulting in slower drying and increased risk of drips. In enclosed spaces, adequate ventilation must be provided during application and drying of the coating.

**SHELF LIFE**

12 months

**SAFETY MEASURES**

Contains organic solvents. Perform painting work with local and general ventilation. Use rubber gloves to protect your hands and personal protective equipment for respiratory protection. Store the material in a tightly closed container. Keep away from ignition sources, heat, sparks, open flames, and static electricity. Do not smoke nearby. Use explosion-proof equipment, lighting, and spark-proof tools. Extinguish with water spray or air-mechanical foam and powders. In case of skin contact, wash the contaminated area with soap and water, dry, and apply a rich cream.

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