

## DESCRIPTION

Two-component zinc-filled epoxy primer. The zinc dust content in the epoxy resin is not less than 80%.

Possible modifications:

**Grey.**

## PRODUCT FEATURES

- Is used as a primary primer in three-layer coating systems for a long service life (more than 15 years) under conditions of maximum corrosion load C5;
- Provides cathodic protection of steel;
- Allows to carry out welding work;
- Is applied only to a shot-blasted surface up to the degree of Sa2½ according to ISO 8501.

## Mixing ratio

		% in weight, g	% in volume, ml
<b>Product</b>	Zn Primer 042	100	100
<b>Hardener</b>	Hardener №4	10	30
<b>Thinner</b>	Thinner 7, 8	5-20	5-40

**Volume solids** 54%

**Viscosity comp. A+B** Thixotropic

**Weight solids** 82-92 %

**Density A+B** 2,7 kg/l (+/- 0,1g)

**Viscosity comp. A** Thixotropic

**Pot life** 4 h

DFT 40 mkm	+10 °C	+23 °C	+35 °C
<b>Dust dry</b>	30 min	15 min	10 min
<b>Touch dry</b>	2 h	1 h	30 min
<b>Minimal drying between layers</b>	2 h	1 h	1 h

The data are given at a relative humidity of 65%. If the humidity changes, the data may change.

Complete formation of the coating during natural drying – 7 days.

## RECOMMENDATIONS FOR APPLICATION

- Is applied in 1-2 layers. Theoretical consumption without a thinner at DFT 40 mkm is 210 g/m<sup>2</sup>.
- For airless spraying, the product is thinned depending on the temperature of the components (base, hardener, thinner) and the required viscosity approximately 0–5%. Recommended nozzle tip is 0.015"–0.021" and pressure 120–180 bar. Spray angle shall be chosen according to the shape of the object.
- For conventional spraying, the product is thinned depending on the temperature of the components (base, hardener, thinner) and the required viscosity the paint approximately 20%. Recommended nozzle tip is 1.6–2.0 mm and pressure 3–4 bar.
- For brush application product should be thinned according to the circumstances.

## SHELF LIFE

6 months

## SURFACE PREPARATION

Surface cleaning to Sa2½ according to ISO 8501. All surfaces must be clean, dry and free from contamination. The temperature of the ambient air, surface and paint should not fall below +5°C during application and drying. Relative humidity of the air should not exceed 80% during application and drying. The surface temperature of steel should remain at least 3°C above the dew point. Good ventilation and sufficient air movement is required in confined areas during application and drying.

## SAFETY MEASURED

Contains organic solvents. Perform painting work with local and general ventilation. Use rubber gloves to protect your hands, and personal protective equipment to protect your respiratory organs. Store the product in a tightly closed container. Keep away from sources of ignition, heat, sparks, open fire, static electricity. Do not smoke nearby. Use explosion-proof equipment, lighting, intrinsically safe tools. Extinguish by spraying water or using an air-mechanical foam and powders. In case of contact with the skin, wash the contaminated areas with soap and water, dry and lubricate with a fat-based cream.

**For industrial and professional use only.**

The above information is not intended to be exhaustive or complete. The information is based on laboratory tests and practical experience, and it is given to the best of our knowledge. As a manufacturer we cannot control the conditions under which the product is being used or the many factors that have an effect on the use and application of the product. We disclaim liability for any damages caused by using the product against our instructions or for inappropriate purposes. We reserve the right to change the given information unilaterally without notice.

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