

PEACOPOXY ZP PRIMER

Product Code: 6503

Date: Sept 2012 (Page 1 of 2)

PRODUCT DESCRIPTION

- Two component high build polyamide cured recoatable Zinc Phosphate epoxy primer
- General purpose epoxy primer or build coat in protective coating systems for steel and concrete structures in atmospheric exposure
- Free from lead and chromate containing pigments
- Can be recoated with two component and conventional paints even after long weathering periods
- Resistant to water and splash of mild chemicals
- Good adhesion on most aged, sound alkyd, chlorinated rubber and epoxy coatings
- Good flexibility, easy application
- A high relative humidity max. 95%, during application and curing does not influence the quality of the coating

PHYSICAL PROPERTIES

Colours and gloss	Redbrown
Mass density	approx. 1.5g/cm ³
Solids content (by volume)	approx. 75%
VOC	235 g/litre
Recommended dry film thickness	75-150 μ m
Theoretical spreading rate	10 m ² /l for 75 μ m 7.5 m ² /l for 100 μ m 5 m ² /l for 150 μ m
Touch dry (25^oC)	2.5 hours (75 μ m)
Overcoating interval	min. 10 hours max. 3~6 months
Fully cured	3 days
Shelf life (cool and dry place)	at least 12 months
Flash point	base 26 ^o C, hardener 24.5 ^o C

APPLICATION CONDITIONS AND TEMPERATURE

- Steel, blast cleaned to ISO-sa2.5
- Previous coat; dry and free from any contamination
- During application and curing a substrate temperature down to 0^oC is acceptable provided the substrate is free from water or ice
- Substrate temperature should be at least 3^oC above dew point

APPLICATION INSTRUCTION

Mixing ratio

base to hardener 7.8 : 1 *by weight*

base to hardener 9:2 *by volume*

- The temperature of the mixture of base and hardener should be above 15^oC, otherwise extra solvent may be required to obtain application viscosity
- Too much solvent results in lower sag resistance and slower cure
- Thinner should be added after mixing the components
- Pot life at 20^oC - 6 hours

	AIR SPRAY	AIRLESS SPRAY
Recommended thinner	Thinner 066 (flash point 26 ^o C)	Thinner 066 (flash point 26 ^o C)
Volume of thinner	<10%	<5%
Nozzle orifice	1.5-3 mm	0.48 mm
Nozzle pressure	0.3-0.4 MPa (approx. 3-4 AT; 43-57 P.S.I.)	15MPa (approx. 150 AT; 2100 P.S.I.)

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BRUSH AND ROLLER

Recommended thinner Thinner 066 (flash point 26°C)

Volume of thinner <5%

CLEANING SOLVENT

Thinner 068 (flash point 30°C)

OVERCOATING TABLE

For two pack epoxy or polyurethane product

substrate temperature (°C)	5	10	15	20	30	40
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minimum interval (hours)	36	20	12	10	8	6
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maximum interval : not direct exposed to sunshine (months)	6	6	6	6	4	3
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maximum interval : direct exposed to sunshine (months)	3	3	3	3	2	2
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CURING TABLE

substrate temperature	dry to handle	full cure
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0°C	50 hours	9 days
5°C	40 hours	7 days
10°C	32 hours	5 days
15°C	28 hours	4 days
20°C	24 hours	3 days
30°C	20 hours	2 days
40°C	15 hours	1 days

POT LIFE(AT APPLICATION VISCOSITY)

INDUCTION

10°C	12 hours	20 mins.
20°C	6 hours	-
30°C	4 hours	-
40°C	3 hours	-

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