

PEACOPOXY MULTI-PURPOSE PRIMER

Product Code: 6511

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PRODUCT DESCRIPTION

- Two component polyamide cured epoxy primer
- Used as multipurpose epoxy primer in protective coating systems for steel and non ferrous metals
- Good adhesion to steel and galvanized steel and non ferrous metal.
- Good flow , wetting properties and corrosion resistance
- Cure at temperature down to +5°C
- Long recoating intervals are possible when overcoating with epoxy and polyurethane coating
- Can be overcoated with most alkyd-, chlorinated rubber-, vinyl-, epoxy- and 2 component polyurethane coatings
- Compatible with cathodic protection systems

PHYSICAL PROPERTIES

Colours and gloss	Yellow
Mass density	approx. 1.5g/cm ³
Solids content (by volume)	approx. 73%
VOC	210 g/litre
Recommended dry film thickness	50-100 µm
Theoretical spreading rate	14.6 m ² /l for 50µm, 9.7 m ² /l for 75µm, 7.3 m ² /l for 100µm
Touch dry after	2.5 hours
Overcoating interval	min. 8 hours max. 2-6 months
Fully Cured	7 days
Shelf life(cool and dry place)	at least 12 months
Flash point	base 26°C, hardener 26°C

APPLICATION CONDITIONS AND TEMPERATURE

- Substrate temperature must be above 5°C during application and curing and at least 3°C above dew point

Under water area:

- Steel; blast cleaned (dry or wet) to ISO-Sa2½
- Steel; with approved Zinc Silicate shop primer; pretreated according SPSS-Ss

Above water area:

- Steel; pretreated preferably to ISO-Sa2½ or according to ISO-St3

Shop primed steel; pretreated to SPSS-Pt3

Galvanized steel; cleaned from grease, salts contamination

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°C, 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

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	AIR SPRAY	AIRLESS SPRAY
Recommended thinner	Thinner 066 (flash point 26°C)	Thinner 066 (flash point 26°C)
Volume of thinner - for 125 µm	<5%	<5%
Nozzle orifice	1.5-2 mm	0.46 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.)

BRUSH AND ROLLER

Recommended thinner	no extra thinner is necessary but
Volume of thinner	up to 5% thinner 066 can be added if desired

CLEANING SOLVENT

Thinner 068(flash point 30°C)

OVERCOATING TABLE

For two pack epoxy or polyurethane paint

substrate temperature (°C)	5	10	15	20	30	40
minimum interval (hours)	36	18	12	8	6	4
when not exposed to direct sunshine						
maximum interval (months)	6	6	5	5	4	3
when exposed to direct sunshine						
maximum interval (months)	3	3	2	2	2	2

Figure are valid for a dft of 50 µm Peacopoxy Multi-Purpose Primer.

Surface should be dry and free from any contamination.

On top of gloss finishes, an undercoat is required.

CURING TABLE

substrate temperature	touch dry	dry to handle	full cure
5°C	8 hours	40 hours	21 days
10°C	6 hours	32 hours	14 days
15°C	4 hours	28 hours	10 days
20°C	2.5 hours	24 hours	7 days
30°C	1.5 hours	20 hours	5 days

adequate ventilation is required during application and curing.

POT LIFE (AT APPLICATION VISCOSITY)

15°C	8 hours
20°C	6 hours
25°C	5 hours
30°C	4 hours
35°C	3 hours

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