

PEACOPOXY WS PRIMER

Product Code: 6516

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PRODUCT INTRODUCTION

- Two component polyamide cured red oxide prefabrication primer
- Used as a shop primer suitable for automatic application on (shot) blasted steel plates
- fast drying properties
- good cutting and welding properties including MMA and gravity welding
- provides corrosion protection up to 6 months, when applied at a dft of 22 μm (depending on exposure conditions and blasting profile)

PHYSICAL PROPERTIES

Colours and gloss	redbrown - flat
Mass density	approx. 1.15 g/cm ³
Solids content (by volume)	approx. 23%
Recommended dry film thickness	22 μm
Theoretical spreading rate	10.5 m ² / l for 22 μm
Touch dry after	5 min. at substrate temperature of 20°C
	3 min. at substrate temperature of 40°C
Overcoating interval	min. 10 hours max. 6 months longer overcoating intervals can be permitted when primer is still in sound condition
Shelf life(cool and dry place)	base: at least 6 months hardener: at least 12 months
Flash point	base 3°C, hardener 6°C

APPLICATION CONDITIONS AND TEMPERATURE

- Steel; blast cleaned to ISO-Sa2½
- Blasting profile; (Rz) 40 -70 μm
- Substrate temperature may be up to 40°C
- For automatic application a substrate temperature of 35°C is recommended
- Substrate temperature should be at least 3 °C above dew point

SECONDARY SURFACE PREPARATION

exposure conditions	immersed	atmospheric
contamination	to be removed	to be removed
weldseams	ISO-Sa2½ (SPSS-Pt3)	SPSS-Pt2
burned areas	ISO-Sa2½ (SPSS-Pt3)	SPSS-Ss (SPSS-Pt2)
damaged corroded area	ISO-Sa2½ (SPSS-Pt3)	SPSS-Ss (SPSS-Pt2)

APPLICATION INSTRUCTION

Mixing ratio

base to hardener 75:25 *by weight*

base to hardener 77:23 *by volume*

- The temperature of the mixture of base and hardener should be above 15°C
- Strain mixture through a 30-60 mesh screen
- Mixed paint is ready for use. Some addition of thinner might be necessary depending on routing, line speed and steel temperature
- Agitate continuously during application

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	AIR SPRAY	AIRLESS SPRAY
Recommended thinner	Thinner 068 (flash point 30°C)	Thinner 068 (flash point 30°C)
Volume of thinner	<5%	<5%
Nozzle orifice	1-1.5 mm	0.43-0.48 mm
Nozzle pressure	0.15-0.2 MPa (approx. 1.5-2 AT; 21-28 P.S.I.)	12-15MPa (approx. 120- 150 AT; 1700- 2100 P.S.I.)

CLEANING SOLVENT

Thinner 068(flash point 30°C)

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