PEACOPOXY HS ZINC PRIMER (low VOC)

Product Code: 6518

Date: Sept 2014 (Page 1 of 2)

PRODUCT INTRODUCTION

- Two component polyamide cured Zinc epoxy primer
- Used as a system primer and holding primer for various maintenance systems.
- Excellent corrosion prevention properties
- Quick drying, can be overcoated after a short interval
- Contains not less than 95% zinc dust and conforms to BS4652:1995

PHYSICAL PROPERTIES

Colours and gloss	gray - flat
Mass density	approx. 2.5g/cm ³
Solids content (by volume)	approx. 72%
VOC	244 g/litre
Recommended dry film thickness	50-100μm
Theoretical spreading rate	14.4m ² /l for 50μm 9.6 m ² /l for 75μm 7.2 m ² /l for 100μm
Touch dry after	15 mins.
Overcoating interval	min. 7 hours
	max. several months
Curing time	7 days
Shelf life(cool and dry place)	at least 12 months
Flash point	base 29°C, hardener 26°C

APPLICATION CONDITIONS AND TEMPERATURE

- Steel; blast cleaned to ISO-Sa2¹/₂
- Blasting profile; (Rz) 40 -85 μm
- Substrate temperature should be at least 3 °C above dew point

APPLICATION INSTRUCTION

Mixing ratio

base to hardener 13:1 by weight

base to hardener 4.6:1 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

	AIR SPRAY	AIRLESS SPRAY
Recommended thinner	Thinner 066 (flash point 26°C)	no thinner to be added
Volume of thinner	<15%	0%
Nozzle orifice	1.5-3 mm	0.43-0.48 mm
Nozzle pressure	0.3-0.4MPa (approx. 3-4 at; 43-57 psi)	15MPa (Approx. 150 AT; 2100 psi)

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Date: Sept 2014 (Page 2 of 2)

BRUSH AND ROLLER

Recommended	
thinner	

Thinner 066(flash point 26°C)

Volume of thinner < 0-5%

CLEANING SOLVENT

Thinner 053(flash point 40°C)

OVERCOATING TABLE

substrate temperature	10°C	20°C	30°C	40°C
minimum interval	6 hours	5 hours	4 hours	2 hours
maximum interval	several r contamir	months wi nation	thout Zinc	salt

CURING TABLE

substrate temperature	touch dry	dry to handle	full cure
10°C	30 mins	3 hours	15 days
15°C	25 mins	2 hours	10 days
20°C	15 mins	1.5 hours	7 days
30°C	8 mins	1 hour	5 days

note

The curing rate of Peacopoxy Zinc Primer between 5° C and 10° C will be very slow.

Adequate ventilation is required during application and curing

POT LIFE (AT APPLICATION VISCOSITY)

20°C	48	hours
35°C	6	hours

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PEACOPOXY ZINC PRIMER

6515

JULY 94 Page 1

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