

APCODUR EPOXY PRIMER

Two components, polyamide cured, epoxy primer



PRODUCT DESCRIPTION

Two components, polyamide cured, epoxy primer.

FEATURES AND RECOMMENDED USE

- Designed for use as a primer for mild aggressive environment
- Good adhesion properties for subsequent coats
- Excellent water & corrosion resistance
- Good flow and wetting properties

TECHNICAL DATA

Color	Red Oxide, Grey & Clear
Gloss	Matt
Volume Solids	Approx. 48%
Recommended DFT/ Coat	30 - 40 microns
Theoretical covering capacity	16.0 sq.mtr/ l @ 30 microns DFT 12 sq.mtr/ l @ 40 microns DFT
Flash point	Base : Not less than 24° C Hardener : Not less than 24° C
Drying time at 30° C	Surface dry : 60 minutes Hard dry : 16 hours Full cure : 7 days
Over coating Interval at 30° C	Min. : 16 hours Max. : 1 month, provided surface is dry and clean from all contamination
Shelf Life (cool and dry place)	At least 12 months

DIRECTION FOR USE

SURFACE PREPARATION

General Cleaning

- Surfaces must be dry, clean and free from contaminants
- Ensure removal of dirt, dust, oil and all other contaminants that could interfere with adhesion of the primer. Oil and grease should be removed as per SSPC-SP1 solvent cleaning with aromatic solvents.
- Surface should be checked and treated in accordance with ISO 8504 prior to priming

Blast Cleaning

- Steel, abrasive blast clean to min. Sa 2^{1/2} (ISO 8501-1:200) or SSPC-SP 10. In case oxidation has occurred between blasting and application of Apcodur Epoxy Primer, the surface should be re blasted.
- A blasting profile of (Rz) 30 - 40 microns is recommended. ® Surface should be thoroughly dry before application of primer. This will have a major influence on the performance of the coating

MIXING

Stir the base and hardener separately. If settling is observed in the base or hardener, loosen the settled material with the help of hand stirrer followed by power driven stirrer for quick homogenous mixing. Mix hardener gradually into the base under continuous stirring.

Mixing Ratio	Base: Hardener
(by volume)	2 : 1
Induction time	30 minutes
Pot life at 30o C	6 hours

APPLICATION

Brush/ Roller

Recommended thinner	: Apcodur Epoxy Thinner/Thinner T 141
Volume of thinner	: 0 - 10 %

Air Spray

Recommended thinner	: Apcodur Epoxy Thinner/Thinner T 141
Volume of thinner	: 5 - 15 %
Nozzle Orifice	: 1.5 mm - 3.00 mm
Nozzle pressure	: 0.3 - 0.4 Mpa (43 - 57 p.s.i.)

Airless Spray

Recommended thinner	: Apcodur Epoxy Thinner/Thinner T 141
Volume of thinner	: 0 - 15 %
Nozzle Orifice	: 0.33 - 0.38 mm
Nozzle pressure	: 15 MPa (= approx.150 atm; 2100 p.s.i)

STORAGE & PACKING

Storage: Store in a cool, dry place. Store in accordance with local Regulations.

Packing: 4 ltr (Base: 2 x 4 ltrs & Hardener: 1 x 4 ltrs)

SAFETY INFORMATION

- As a general safety measure, inhalation of solvent vapors or paint mist and contact of liquid paint with skin & eyes, should be avoided. Forced ventilation should be provided when applying paint in confined spaces or stagnant air. Even when ventilation is provided, respiratory, skin and eye protection are always recommended when spraying paint.
- Please refer our Material Safety Data Sheet prior to using the product.

Disclaimer:

To the best of our knowledge the information provided herein are true and accurate at the date of issuance. Since we have no control over the quality or condition of the substrate or the various factors affecting the use and application of the product, we do not accept any responsibility or liability arising out of use of the product.

The company reserves the right to modify data contained herein without prior notice. Any change in data would the usually be followed by issue of a new datasheet. The user should check with the nearest sales office of the company and confirm the validity of the information, prior to using the product.

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