

## TECHNICAL DATA SHEET

Version 1.1 / 09.07.2020

# 2 Pack Epoxy Zinc Rich Primer

### Production Description

A two pack epoxy zinc rich primer for steelwork.

Features & Intended Use:

- Conforms to ISO 12944 zinc content composition
- Excellent resistance to undercutting from damaged areas
- Over-coatable with epoxy, epoxy pitch, chlorinated rubber, vinyl or polyurethane coatings
- Suitable for inland, aggressive and coastal environments where long life expectancy is required
- May be used for protection in a single coat where cosmetic appearance is not important

### Product Information

<b>Colour:</b>	Grey		
<b>Finish:</b>	Matt		
<b>Volume Solids:</b>	52% +/- 2%		
<b>Film Thickness:</b>	Dry Film Thickness	Wet Film Thickness	Theoretical Coverage
	Minimum	91µm	m <sup>2</sup> /litre
	Maximum	182µm	5.5 m <sup>2</sup> / litre
<b>Practical Coverage:</b>	471 ± 20 g/litre		
<b>Specific Gravity:</b>	2.50 -2.54 kg/ltr mixed		
<b>Flash Point:</b>	23-60°C		
<b>Mixing Ratio:</b>	Base: 2 pack Epoxy Zinc Rich primer – 4 parts by volume Hardener: CP 1500 Epoxy Activator – 1 part by volume		
<b>Pot Life:</b>	8 hours @ 23°C		

### Surface Preparation

Blast clean to Sa 2.5 (ISO 8501-1:2007), surface profile 50-75 microns

All surfaces to be coated should be dry and cleaned as necessary to remove all oil, grease, salts, weld flux or other contamination. Where necessary, remove weld spatter and grind smooth all sharp edges and weld seams

### Application Details

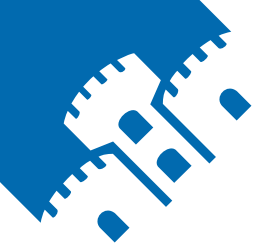
Only apply in conditions of good ventilation which must be maintained during drying and curing.

Do not apply when rain, mist, sleet or snow are imminent.

During application and drying time of the paint coating, the surface should be dry, the relative humidity should not exceed

85% and the steel temperature should remain at least 3 °C above the dew point.

Only apply this product when the above conditions can be maintained throughout the critical application and drying/curing process. Paint temperature should ideally be at a minimum of 15°C.



## TECHNICAL DATA SHEET

Version 1.1 / 01.12.2019

### 2 Pack Epoxy Zinc Rich Primer

<b>Application Methods</b>	<b>Airless Spray:</b>	Output fluid pressure at tip 200-2500 psi minimum, Tip Size: 15-20 thou (0.38 -0.53mm)
	<b>Conventional Spray:</b>	Will require equipment with an agitated pot
	<b>Brush:</b>	Application by brush will result in reduced film thickness and is recommended only for small areas of touch up/remedial work

Drying Time	Applied to 75 microns dft	+10°C	+23°C	+35°C
		<b>Dust Free:</b>	50 min	30 min
<b>Hard Dry:</b>		6 hr	4 hr	2 hr
<b>Overcoating:</b>	Minimum	8 hr	4 hr	2 hr
	Maximum	7 days	7 days	3 days

Drying and recoating times related to the film thickness, temperature, the relative humidity of the air and ventilation.

<b>Storage &amp; Handling</b>	<p><b>Storage:</b> Always store and transport in a secure upright position. Store the closed container in a cool dry place. Keep away from extremes of temperature.</p> <p><b>Pack Size:</b> 5 Litre.</p>
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<b>Health &amp; Safety</b>	<p>Paint product - flammable</p> <p>Keep away from sources of ignition</p> <p>Do not take internally</p> <p>Keep out of reach of children</p> <p>In case of contact with eyes rinse immediately with plenty of water</p> <p>In case of insufficient ventilation wear suitable respiratory equipment</p> <p>Remove splashes from skin using soap and water or a recognised skin cleaner</p> <p>Dispose of container and contents in accordance with local/national regulations</p> <p>Do not empty product into drains or watercourses</p> <p>Contains no added lead</p> <p>See MSDS for more information</p>
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<b>Quality Assurance</b>	<p>Castle Paints products are manufactured using only the highest quality raw materials. We guarantee the quality of our products. This guarantee does not include labour or cost of labour for the application of any paint.</p>
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The user will be deemed to have satisfied him/herself independently as to the suitability of our products for his/her own particular purpose. In no event shall Castle Paints be liable for consequential or incidental damages.

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