

# HIGH SOLID EPOXY COATING

( Surface Tolerant Primer )

## Parsikraft 4242G1

### DESCRIPTION

\*Hi-performance self-primed epoxy coat with high tolerance to moist and low degree prepared surfaces.  
It is compatible with almost all range of top coats such as epoxies, polyurethane acrylic and so on.

### USES

\* Excellent self-primed and surface tolerant coat in paint systems when blasting is not desired and lower level of surface preparation is due.  
\* Excellent mid layer in various atmospheric paint systems.

### FEATURES

\* Excellent adhesion to mechanically cleaned surfaces  
\* High build, hi solid and self primed for low degree prepared iron steel  
\* Due to high volume solid , it has high coverage and low consumption.  
\* Thanks to its high volume solid and low VOC, a thick layer of 200 microns can be achieved in one application.

### 2 TECHNICAL DATA

|  |                              |
|--|------------------------------|
| <b>Finish</b>                              | Flat                         |
| <b>Colour</b>                              | Grey                         |
| <b>Specific gravity ( at 20 °C , Mix )</b> | 2.00 ± 0.05 ( gr/cc )        |
| <b>Volume solid</b>                        | 85 ± 2 %                     |
| <b>Recommended DFT</b>                     | 100 - 400 ( mic )            |
| <b>Flash point</b>                         | 35 °C                        |
| <b>Shelf life ( at 20 °C )</b>             | 12 months                    |
| <b>Package</b>                             | 20 Liters, others on request |

### SURFACE PREPARATION

- 1 - The best result is attained by SA2½ , but when it is impossible, the power tools is acceptable.
- 2 - As an intermediate, the primed or previous layer should be quite free of any oil, grease, dirt, dust and moisture.
- 3 - Pay attention to maximum recoating interval of previous layer.

### RECOMMENDED PAINT SYSTEMS

|  |                    |        |  |
|--|--------------------|--------|--|
| <b>A : As mid coat</b>   |                    |        |  |
| P : 7411 <sup>1</sup> , 4424 (all series)                                    | 70 - 90            | micron |  |
| <b>I : 4242G1</b>  | 1 or 2 × (100-200) | micron |  |
| T : 6591(all series), 4392, 3391   | 50 - 100           | micron |  |
| <b><sup>1</sup> See note J when selecting or using zinc ethyl silicate .</b> |                    |        |  |
| <b>B : As surface tolrant primer and Intermediate</b>                        |                    |        |  |
| <b>P &amp; I : 4242G1</b>  | 1 or 2 × (100-200) | micron |  |
| T : 6591(all series), 4392, 3391   | 50 - 100           | micron |  |

**<sup>2</sup> See note J when selecting or using zinc ethyl silicate .**  
7411 needs 4252 as tie-coat or a thin mist coat of 4242G1 before applying main thickness of intermediate.

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### APPLICATION DATA

|                        |  |                                       |  |
|------------------------|--|---------------------------------------|--|
| Method                 | Air / Airless spray , Brush (just for inaccessible area or touch up) |                                       |  |
| Thinner / Cleaner      | T - 404  |                                       |  |
| Mixing ratio by weight | 100 : 8  | <b>Base : 25 Kg , Hardener : 2 Kg</b> |  |
| Pot life ( at 20 °C )  | 1 hr   |                                       |  |

- Different thinner with different suffix maybe offered in hot and cold seasons.

#### Theoretical Coverage :

|                                   |      |      |      |
|-----------------------------------|------|------|------|
| Dry film thickness (mic)          | 100  | 250  | 400  |
| Coverage ( m <sup>2</sup> / lit ) | 8.5  | 3.4  | 2.13 |
| Coverage ( m <sup>2</sup> / kg )  | 4.25 | 1.70 | 1.06 |

|                                 |     |      |
|---------------------------------|-----|------|
| Touch dry ( 150 mic , 20 °C )   | ≤10 | hrs  |
| Fully Cured ( 150 mic , 20 °C ) | 7   | days |

- At higher dry film thickness, lower temperature and poor ventilation drying time will be longer.
- Application in closed area results in long touch & tack drying time and therefore longer minimum intervals. So sufficient air draft is required for maintaining normal application condition.

#### Recoating interval :

|                        |      |      |      |
|------------------------|------|------|------|
| Surface temperature    | 10°C | 20°C | 30°C |
| Min. Interval ( hrs )  | 30   | 24   | 18   |
| Max. Interval ( days ) | 7    | 6    | 5    |

- For having required interchemical bonding, maximum interval must be strictly followed for immersion uses, but for atmospheric application it is possible to recoat it after few weeks .

#### See note E

### APPLICATION INSTRUCTIONS

- \* Check all equipments are dust, oil and moisture free. If needed , flush with cleaner thinner.
- \* It is recommended to use the paint with the temperature above 15°C, otherwise more thinner would be required to reach the application viscosity. Too much thinner may results in sagging, low thickness and poor hiding. In cold seasons it is recommended to keep the paint at a warmed up storage at least 3 days before use.
- \* Stir the paint well by a forced mixer before use and add the entire hardener to it and mix it again up to get a homogenous mixture.
- \* Thin the paint with defined thinner depend on required thickness & application viscosity.
- \* Stirring the material in low speed during painting is necessary . **See note H**

#### The given data could be adjusted by applicator in practical situation by his own actual trial.

|                | Pressure (atm)                  | Orifice     | Tip Range | Thinner (vol%) |
|----------------|---------------------------------|-------------|-----------|----------------|
| Air spray      | 3 - 4                           | 1.3 - 3 mm  |           | 5 - 20         |
| Air less       | 6 - 7                           | 19 - 23 mic | 219 -323  | 5 - 10         |
| Brush / Roller | Suitable for small areas only . |             |           |                |

### SURFACE TEMPERATURE

Must be at least 3°C above dew point, apply the coats when surface temperature is from 10°C to 40°C. Please consult Parsifam if the substrate temperature is lower or higher.

### SAFETY

- ▲ Due to high flammability , keep away the paints from heat , sparks and flames.
- ▲ Avoid contact the paints with eyes and skin.
- ▲ Use mask and gloves and provide suitable ventilation for the reasons of health and safety.

**REMARKS :** The information submitted in this data sheet is based on our best current knowledge and experience. The ultimate performance of this coating is quite related to performance of surface preparation, application procedure and conditions that limits our liability to the figures of submitted technical and application data .