
EPOXY HOLDING PRIMER

Parsihold 4255

DESCRIPTION

- * Two component zinc phosphate epoxy holding primer to be used as holding and adhesion primer in internal lining paint systems.
- * It is pigmented with zinc phosphate and highly lamellar MIO to ensure good adhesion to other subsequent tank lining coat .

USES

- * It is usable as holding / adhesion primer in paint systems which are designed for internal coatings .

FEATURES

- * Excellent adhesion to carbon steel .
- * Excellent adhesion to epoxy paints .
- * To be walked over after 24 hours at 20 °C and more . If the average of temperature is less than this , the drying time would be increased .

TECHNICAL DATA

Finish	Flat
Colour	Grey
Specific gravity (at 20 °C , Mix)	1.30 ± 0.05 (gr/cc)
Volume solid	53 ± 2 %
Recommended DFT	30 -50 (mic)
Flash point	32 °C
Shelf life (at 20 °C)	12 months
Package	20 Liters, others on request

Higher thickness than recommended DFT should be avoided.

SURFACE PREPARATION

- 1 -Remove any oil, dirt, moisture and blast the surface up to SA2½

RECOMMENDED PAINT SYSTEMS

P: 4255 ¹	30- 50	micron
I&T: 4517B-1, 4517BP-1, 4517B , 4517BP 4522A, 4572, 4876	1 to 3 x (250-500)	micron

- ¹ Do not apply more than specified thickness.

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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 : 16.67	Base : 18 kg + Hardener : 3 kg	
Pot life (at 20 °C)	8 hrs		

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

Theoretical Coverage :

Dry film thickness (mic)	30	40	50
Coverage (m ² / lit)	17.66	13.25	10.60
Coverage (m ² / kg)	13.59	10.20	8.15

Touch dry (30 mic , 20 °C)	6 hrs
Fully Cured (30 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	40 °C
Min. Interval (hrs)	48	24	12	10
Max. Interval (days)	21	10	7	5

- The maximum chemical adhesion is started after minimum recoating interval times and is almost minimum on maximum interval time. If it is coated at longer interval time reaching to a reasonable intercoat adhesion is marginal . The stated maximum following recoating interval are maintain when conditions are provided :
 - 1-The coating has been applied in a DFT at specified range
 - 2-Good quality application with no dry spray
 - 3-Drying is done at given average temperature .
 - 4-There are no surface contamination , any loose dust should be abraded and surface must be quite cleaned .
 - 5- Surface is not exposed to any direct sun shine .

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**



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

APPLICATION INSTRUCTIONS :

	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 .