TWO COMPONENT ZINC RICH EPOXY PRIMER

(According to IPS- M-TP 205, Level 3)

Parsizinc 4424S8

DESCRIPTION

* Two component zinc rich epoxy primer formulated with super fine zinc dust and pure epoxy resin & special hardeners .
It can serve good corrosive resistance in industrial and chemical environments and meets SSPC Paint 20 specification level III .
It should be coated with alkaline resistant coatings . It's dry heat resistance is up to 120 ° C .

USES

* Zinc rich primer for anti corrosive paint systems in mild to moderate industrial environmental conditions.

FEATURES

* Anti-corrosive cathodic protection .
* Zinc dust content in dry film is 66% .
* High coverage.
* Long intercoat adhesion.
* Economical without loss of performance.
* Smooth appearance due super fine zinc dust .

TECHNICAL DATA

Finish	Flat
Colour	Grey
Specific gravity (at 20 °C , Mix)	2.70 ± 0.05 (gr/cc)
Volume solid	60 ± 2 %
Recommended DFT	50 - 75 (mic)[1]
Flash point	35 °C
Shelf life (at 20 °C)	12 months
Package	20 Liters, Others on request

[1]Avoid high thickness . See note B

SURFACE PREPARATION

1 - Remove any dust , rust , oil & moisture .

2 - Blast up to SA 2 ½. If blasting is not possible, wire brush up to near a bare metal surface (SP 11) with a suitable roughness.

RECOMMENDED PAINT SYSTEMS

P : 4424S8 [2]	60 - 80	micron
I : 4211(all series) , 4204 (all series) 4205ZP, 4212, 3202	100 - 200	micron
T : 6591(all series), 4392 , 3391, 2932	50 - 80	micron

[2] Zinc rich primers can form zinc salts on the surface, if they are weathered for long times periods before over coating. In this case zinc salts and any contamination should be removed by high pressure water cleaning, sand paper, sweep blasting or other mechanical cleanings. For a long recoating interval, application of a suitable thin mid coat like 4211B or directly after minimum interval is recommended.

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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	**Base: 25 kg , Hardener : 2 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)	50	60	75
Coverage (m^2 / lit)	12	10	8
Coverage (m^2 / kg)	4.44	3.70	2.96

Touch dry	(70 mic , 20 °C)	1	hr
Fully Cured	(70 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)	12	8	6
Max. Interval (days)	14	10	7

- The maximum recoating times are for reaching the maximum chemically intercoat adhesion, but it is possible to reach a reasonable adhesion even up to few months .**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 .

Parsifam
Producer of Paints & Coatings