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# SURFACE TOLERANT ZINC RICH EPOXY PRIMER

( Level 1 of SSPC Paint 20 & IPS - M - TP205 )

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## Parsizinc 4424ST

### DESCRIPTION

\* Two component zinc rich epoxy primer formulated with high amount of super fine zinc dust and well selected epoxy resins and hardeners to provide enough surface tolerance when it is applied on non-blasted but wire brushed surfaces.

### USES

\* Excellent surface tolerant primer for heavy duty coating systems in severe industrial, chemical and marine environmental conditions when surface are non-blasted but are prepared at least up to ST2.

\* The primer meets SSPC Paint 20 , Type II ( Level 1) and equivalent performance to IPS -M-TP205 in table 7 of IPS-E-TP100.

### FEATURES

- \* Designed to tolerate low prepared surfaces
- \* High integrated zinc to zinc contact leading cathodic protection.
- \* Zinc dust contents in dry film is more than 85 % .
- \* Excellent anticorrosive properties.
- \* Smooth appearance due to super fine zinc dust .
- \* Long recoating interval, when free from salts and contaminations.
- \* Ensuring enough cathodic current.
- \* Due to high zinc content, using a powered mixer is a necessity .
- \* High thickness might lead to cracking.
- \* Quick drying, good selection for short recoating interval.

### TECHNICAL DATA

<b>Finish</b>	Flat
<b>Colour</b>	Grey
<b>Specific gravity ( at 20 °C , Mix )</b>	2.8 ± 0.05 ( gr/cc )
<b>Volume solid</b>	62 ± 2 %
<b>Recommended DFT</b>	60 - 80 ( mic ) <sup>1</sup>
<b>Flash point</b>	35 °C
<b>Shelf life ( at 20 °C )</b>	12 months
<b>Package</b>	20 Liters, others on request

<sup>1</sup>Avoid high thickness . See note B

### SURFACE PREPARATION

- 1 - Remove any dust , rust , oil & moisture .
- 2 - If blasting is not possible, wire brush up to at least ST2 and if possible near a bare metal surface ( SP 11 ) with a suitable roughness.

### RECOMMENDED PAINT SYSTEMS

<b>P : 4424ST<sup>2</sup></b>	60 - 80	micron
<b>I : 4211( all series) , 4204 (all series) 4205ZP, 4212, 3202</b>	100 - 200	micron
<b>T : 6591(all series), 4392 , 3391, 2932</b>	50 - 80	micron

<sup>2</sup> Zinc rich primers can form zinc salts on the surface, if they are weathered for long 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 MIO mist coat like 4211B 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	<b>Base: 25 kg , Hardener : 2 kg</b>	
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)	60	70	80
Coverage ( m <sup>2</sup> / lit )	10.33	8.86	7.75
Coverage ( m <sup>2</sup> / kg )	3.69	3.16	2.77

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 SAFETY

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.

- ▲ 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 .