
TWO COMPONENT ZINC RICH EPOXY PRIMER

Parsizinc 4424T3

DESCRIPTION

- * As primer for epoxy/coal tar epoxy paint systems.
- * Two component zinc rich epoxy primer formulated with super fine zinc dust and well selected epoxy resins and hardeners to meet requirements for zinc rich epoxy polyamide, SSPC Paint 20, Level 3)

USES

- * Excellent primer for anticorrosive coating systems in moderate industrial and chemical environmental conditions .
- * As primer for Epoxy / Epoxy / PU paint systems.

FEATURES

- * Zinc contents in dry film is more than 75 % .
- * Smooth appearance due to super fine zinc dust .
- * Long recoating interval, when free from salts and contaminations.
- * Due to zinc content, using a powered mixer is a necessity.
- * High thickness have to be avoided.
- * Quick drying, good selection for short recoating interval.

TECHNICAL DATA

Finish	Flat
Colour	Grey
Specific gravity (at 20 °C , Mix)	2.65 ± 0.05 (gr/cc)
Volume solid	60 ± 2 %
Recommended DFT	60 - 80 (mic) ¹
Flash point (at 20 °C)	35 °C
Shelf life (at 20 °C)	12 months
Package	20 Liters, others on request

¹Avoid 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 : 4424T3 ²	60 - 80	micron
I : 4211(all series) , 4204 (all series) 4205ZP, 4212, 3202	100 - 200	
T : 6591(all series) , 4392, 3391, 2932	50 - 100	micron

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



TWO COMPONENT ZINC RICH EPOXY PRIMER

Parsizinc 4424T3

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)	60	70	80
Coverage (m ² / lit)	10	8.57	7.50
Coverage (m ² / kg)	3.78	3.23	2.50

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	1.5 - 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 .