

DESCRIPTION

A two-component, polyamide cured, epoxy primer and intermediate coat for corrosion protection coating system for steel, galvanized steel and non-ferrous metal substrates.

PRODUCT FEATURES AND RECOMMENDED USES

- Specially formulated for use as anti-corrosive primer to be applied directly onto non-ferrous metal substrates such as galvanized steel and aluminum.
- Can be used as primer and intermediate coat in anti-corrosion protection coating system.
- Very suitable as a non-inhibitive pigmented primer in the superior duplex high performance system for the painting of galvanized steel.
- Very good water and corrosion resistance.

PHYSICAL DATA (@25°C)

Mass density	: 1.57 + 0.02 kg/lt.
Volume Solids	: 60 ± 2 %
Mixing Ratio	: By weight 88.0:12.0; By volume 80.0:20.0
Pot Life	: 8 hours
Color	: Oxide Red, Oxide Yellow, Gray, White
Gloss Gradation	: Matt
Flash Point	: Part A 26 °C (79 °F); Part B 25 °C (77 °F)
VOC	: 390 g/lt.



RECOMMENDED DRY FILM THICKNESS AND THEORETICAL COVERGE RATE

Recommended film thickness		Theoretical Coverage
Dry	Wet	
50 microns	85 microns	12.0 sq.m./lt.
75 microns	125 microns	8.0 sq.m./lt.

Practical coverage depends on several factors such as method of application used, surrounding conditions, shape and roughness of the surface to be coated as well as skill and experience of the applicator.

DRYING TIME (@ DFT = 60 microns)

Substrate Temperature	5-10°C	10-15°C	15-25°C	25-35°C	>35°C
Touch dry after	5 hours	2.5 hours	2 hours	1.5 hours	1 hour
Hard dry after	20 hours	16 hours	8 hours	5 hours	3 hours
Over-Coating Time (min)	24 hours	16 hours	8 hours	5 hours	3 hours
Over-Coating Time (max)	1-3 months	1-3 months	1-3 months	1-3 months	1-3 months
Curing	14 days	10 days	7 days	5 days	3 days

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APPLICATION INSTRUCTION

As a standard practice for optimum performance, surfaces to be coated must be dry, clean, free of oil, grease and contaminants that could interface with adhesion of the coating. Before applying the coating, all surfaces should be assessed and treated in accordance with ISO 8504:1992 or equivalent standard procedure.

SURFACE PREPARATION

- Steel surfaces : Abrasive blast-clean to Sa 2 1/2 (ISO 8501-1-1988) or SSPC SP-10 with 25-50 microns blast profile.
- Shop primed steel surface : Two-pack type only. Clean, dry and free from oil, grease and other contaminants. Roughen, if necessary.
- Galvanized Steel : Degreasing or solvent cleaning to SSPC-SP1. Light abrasion is preferred possible, but ensure that excessive amount of zinc is not removed.

APPLICATION CONDITIONS

It is required that the substrate temperature to be at least 3 °C above the dew point for the application of this product. Application of the product should not be carried out if substrate temperature falls below 5 °C (41 °F) or is higher than 50 °C (122 °F).

MIXING PROCEDURE

Mix each component thoroughly separately. Always add pre-measured Curing Agent (Part B) into pre-measured Base (Part A). Mix two parts together until homogenous. Thinning can be done up by adding Phoenix Thinner PT-683 up to 6 percent by volume. Use of thinners other than those supplied or recommended by Phoenix may adversely affect the performance of the product.

APPLICATION METHOD

	Airless Spray	Air Spray	Roller/Brush
Nozzle orifice	0.38-0.46 mm	1.5-2.0 mm	-
Nozzle pressure	1800-2200 p.s.i.	40-60 p.s.i.	-
Volume of Thinner	5-10 %	10-15 %	5-10 %
Thinner	PT-683	PT-683	PT-683

HEALTH AND SAFETY

Safety Data Sheet of the product should be thoroughly studied. All precautionary statements should be strictly followed. This product contains solvent, user should employ standard precaution measures to avoid inhalation of vapor and spray mist as well as skin and eye contact with wet paint. Protective clothing, gloves, safety glasses or safety goggles should be used during application.