

DESCRIPTION

A two-component, zinc phosphate pigmented, polyamide cured, epoxy based anti-corrosive primer.

PRODUCT FEATURES AND RECOMMENDED USES

- Provides excellent and long term anti-corrosion protection as part of a high performance coating system.
- Very good adhesion to properly prepared steel substrate.
- Very durable and flexible film.
- Can be over-coated with a wide variety of product both one and two-component products.

PHYSICAL DATA (@25°C)

Mass density	: 1.55 + 0.02 kg/lt.
Volume Solids	: 60 + 2 %
Mixing Ratio	: By weight 88.0:12.0; By volume 80.0:20.0
Pot Life	: 5 hours
Color	: Oxide Red, Oxide Yellow, Gray
Gloss Gradation	: Matt
Flash Point	: Part A 25 °C (77 °F); Part B 29 °C (82 °F)
VOC	: 425 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	4 hours	8 hours	6 hours	4.5 hours	3 hours
Over-Coating Time (min)	12 hours	18 hours	10 hours	8 hours	6 hours
Over-Coating Time (max)	24 months	6-12 months	6-12 months	6-12 months	6-12 months
Curing	7 days	5 days	4 days	3 days	2 days

Registered Office:

Phoenix Fire Technologies (UK) Ltd
2nd Floor, 40 Gerrard Street, London W1D 5QE, United Kingdom

APPLICATION INSTRUCTION

As a standard practice for optimum performance, surface 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 blast profile of 25-50 micron.
- Shop primed steel : Only two-component shop primer. Clean, dry and undamaged. Weld seams and damaged area must be abrasive blast-clean to Sa 2½ or SSPC-SP10.
- Galvanized Steel : Hand tool clean to SSPC-SP2.

APPLICATION CONDITIONS

This is a two-component and cross-linking product, curing will be uncompleted if temperature falls below 5 °C (41 °F). For optimum performance, the product should be applied when ambient temperature is above 10 °C (50 °F). Surface temperature must always be at least 3 °C (5 °F) above dew point.

MIXING PROCEDURE

The product is supplied in two containers as a complete set. Stir both containers separately until its content is homogenous. Measure that required quantities in accordance with the specified mixing ratios. Add Part B into Part A and mix with power stirrer until homogenous. Add the required quantity of thinner and mix thoroughly. Only Phoenix Thinner PT-683 should be used. Use of thinners other than that specified or recommended by Phoenix may adversely affect the performance of the product.

APPLICATION METHOD

	Airless Spray	Air Spray	Roller/Brush
Nozzle orifice	0.38-0.53 mm	1.4-1.8 mm	-
Nozzle pressure	1800-2200 p.s.i.	50-60 p.s.i.	-
Volume of Thinner	0-5 %	5-10 %	0-5 %
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 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.

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