



## APCODUR HB ZP PRIMER

Two component, epoxy primer with zinc phosphate pigment

- Designed as an epoxy primer with very good resistance to saline, marine and chemical environments
- Free from lead and chromate containing pigment
- Good adhesion on steel and aged epoxy coatings
- Ease of application by spray & brush
- Can be over coated with alkyd, chlorinated rubber, acrylic, epoxy, polyurethane coating

### TECHNICAL DATA

Colour	Red oxide & Grey	Drying time at 30°C	Surface dry : 1 hour Hard dry : 16 hours Full cure : 7 days
Gloss	Matt	Over coating Interval at 30°C	Min. : 16 hours Max.: 1 month, provided surface is dry and clean from all contamination
Volume Solids	Approx. 40 %		
Recommended DFT/ Coat	35 - 50 microns	Shelf Life (cool and dry place)	At least 12 months
Theoretical covering capacity	11.4 sq.mtr/ l @ 35 microns DFT 8.0 sq.mtr/ l @ 50 microns DFT		
Flash point	Base : Not less than 24°C Hardener : Not less than 24°C		

### DIRECTIONS FOR USE

#### SURFACE PREPARATION & SUBSTRATE CONDITION:

- Steel; blast cleaned to Sa 2.5 of Swedish specification
- If blast cleaning is impractical, remove loose rust/ scale using power/ hand tool to achieve St 3/ St 2 grade of surface preparation, as per Swedish standards. Remove contaminants like grease, oil etc. with aromatic solvents. Ensure the surface is clean and dry before priming
- Substrate temperature should be at least 3°C above dew point but not above 50°C

#### MIXING

Stir the base and hardener separately. If settling is observed in the base or hardener, loosen the settled material with the help of hand stirrer followed by power driven stirrer for quick homogenous mixing. Mix hardener gradually into the base under continuous stirring.

<b>Mixing Ratio</b>	Base : Hardener	<b>Induction time</b>	30 minutes
(by volume)	3 : 1	<b>Pot life at 30°C</b>	6 hours

#### APPLICATION

Application Method	Brush/ Roller	Air Spray	Airless Spray
Recommended thinner	T - 121/ T - 141	T - 121/ T - 141	T - 121/ T - 141
Volume of thinner	0 - 10 %	10 - 20 %	0 - 10 %
Nozzle Orifice		1.5 - 3.0 mm	0.33 - 0.41 mm
Nozzle pressure		0.3 - 0.4 MPa (= approx. 3 - 4 atm; 43 - 57 p.s.i.)	16 - 20 MPa (= approx. 160 - 200 atm; 2300 - 2800 p.s.i.)

### STORAGE & PACKING

Storage : Store in a cool, dry place. Store in accordance with local regulations.

Packing : 20 litres

### SAFETY INFORMATION

As a general safety measure, inhalation of solvent vapours or paint mist and contact of liquid paint with skin & eyes should be avoided. Forced ventilation should be provided when applying paint in confined spaces or stagnant air. Even when ventilation is provided, respiratory, skin and eye protection are always recommended when spraying paint.

Please refer our Material Safety Data Sheet prior to using the product.

**Disclaimer:** To the best of our knowledge the information provided herein are true and accurate at the date of issuance. Since we have no control over the quality or condition of the substrate or the various factors affecting the use and application of the product, we do not accept any responsibility or liability arising out of use of the product.

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