



Product Description

Polyamide Cured Epoxy Primer is a two component polyamide cured primer which has excellent adhesion and anti-corrosive property, excellent resistance to water, chemicals and salt solutions for immersion and non – immersion services.

Recommended Use

This coating (in the epoxy system) is used for protection structural steel, machinery, oil refineries, pipes and tanks exteriors.

Surface Preparation

- 1: All surface to be coated clean ,dry and free from contamination prior to paint application ,all surfaces should be assessed and treated in accordance with ISO8504 :1992 ,where necessary ,remove weld spatter, and where required smooth weld seams and sharp edges. Oil or grease should be removed in accordance with SSPC-SP1 solvent cleaning.
- 2: Abrasive blast clean to Sa 21/2 (ISO 8501:1998) or SSPC-SP10 if oxidation has occurred between blasting and application of this coating, the surface should be re blasted to the specified visual standard.
- 3: Angular surface profile of 50-70 μ is recommended.

Product Description

Shade:	RAL colors
Percentage Of Solid Resin	20%-25%
Percentage Pigment & extender:	40%-45%
Percentage of volume solids:	45%-50%
Dry film thickness:	50μ
Theoretical Coverage:	8-9 m ² /kg
Mixing ratio by weight: B/A	25:5
Specific gravity :	1.3-1.4 Kg/Lit
Viscosity:	110-115 k
Salt spray chamber test:	300h(ASTM B-117)
Humidistatic chamber test:	300h(ASTM D -2247)
Recoating interval time:	1-30 days
Induction time at 25 °C:	20-30 minutes
Curing mechanical :	Solvent vaporization and reaction between two components
Thinner :	Epoxy Thinner Rangin Zereh Sepahan
Shelf life:	A= 12 month , B= 12 month
Flash point:	26°C

Temperature	Touch dry	Full cure	Interval coating	Pot life
15°C	4-6hours	Minimum 9 days	24-36 hours	10hours
25°C	2-3hours	7 days	16-24 hours	6hours
40°C	1-3hours	5 days	14-16hours	4hours

Environmental Conditions

To prevent moisture condensation during application surface temperature must be at least 3 °C above the dew point .In hot climate, material temperature should be 20 to 25°C.For satisfactory cure air and surface temperature must be above 10°C.Never apply coatings under reverse environmental condition .Paint shall not be applied when wind speed is in excess of 7 m/s.





Application Details

Airless spray

Tip range: 0.015-0.021

Total out put pressure at spray tip not less than 141 bar.

Air spray		Nozzle orifice:1.8-2.2 mm Nozzle pressure:3-5 bar
Brush		20-30μ (touch up)
	Roller	20-30μ (touch up)

Application Procedure

- 1: Flush all equipment with recommended clear before use.
 - 2: Stir part A with a power mixer.
 - 3: Add curing agent (part B) to part A, and continue stirring for 5 minutes.
- Note: since the pot life is limited and shortened by high temperatures, do not mix more material than will be use.
- 4: For air spray, thin with no more than 5-10% of recommend thinner for workability for airless spray 5% Of thinner is normally sufficient.
 - 5: Stir during application to maintain uniformity of materials apply wet coat by parallel passes overlap each pass 50% to avoid bare areas.
 - 6: Double coat all welds, rough spots, sharp edges, rivets, bolts, etc., to ensure proper thickness.
 - 7: If the minimum interval coating of this coating is exceeded, roughening of the surface in necessary to ensure inter coat adhesion. (If the adhesion is reduced, one layer of sealer epoxy or mist coat of after layer is recommended.)
- Note: Before recoating after exposure in contaminated environment, clean the surface thoroughly by (high pressure) fresh water hosing and allow to dry.
- 8: Clean all equipment with recommend cleaner immediately after use.

Safety

This product is flammable keep away from heat and open flame operator (accordance MSDS of this product) must use special mask and safety gloves and operation should be performed in environments which is equipped with suitable air conditions

Storage Conditions

Store in closed container and away from direct sunlight at temperature of 5-35 °C

