



## Product Description

Shop Primer is a two component ,containing low zinc dust which high corrosion and abrasion resistance ,heat resistance up to 420 °C.

## Recommended Use

This coating is used for cathodic protection blast cleaned structures which is not passible application of paints.

## Surface Preparation

- 1: All surface to be coated clean, dry and free from contamination. Fresh water wash or water wash with high pressure, as appropriate, and remove all oil or grease, soil contaminants, and other detrimental foreign matter in accordance with SSPC-SP1 solvent cleaning.
- 2:For optimum performance " Near White Blast Clean "blast cleaning sa2 1/2(ISO 8501-1 :1998) or SSPC- SP 10 is recommended 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 40-50  $\mu$  is recommended.

## Product Description

Shade:	Gray
Volume solid:	25%-30%
Weight solid:	50% $\pm$ 2%
Specific gravity:	1.2-1.4 kg/lit
Mixing rate by weight:	A/B = 1.6 /1
Shelf life:	A= 6 month , B= 12 month
Dry film thickness:	15-30 $\mu$
Wet film thickness:	55-135 $\mu$
Theoretical coverage:	8-10 m <sup>2</sup> /kg
Flash point:	14°C
Thinner:	Shop Primer Thinner

Temperature	Humidity	Touch dry	Full dry	Interval	Pot life
15°C	30-50%	50 minutes	5-6 days	Relation of atmospheric conditions	3 hours
	50%<	40-45 minutes	4 hours		
25°C	30-50%	20-25 minutes	2-3 days	24 hours	2 hours
	50%<	10-15 minutes	2 hours	16 hours	
40°C	30-50%	10-20 minutes	1-2 hours	16 hours	1 hours
	50%<	5-10 minutes	1hours to 30 minutes	12 hours	

Dry times are dependent on applied film thickness, all data in this catalogue are reported at recommended D.F.T in laboratory conditions.





## 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: 0.019-0.021 Total out put pressure at spray tip not less than 141 bar.
Air spray	Nozzle orifice:1.8-2.2 mm Nozzle pressure:2-4 bar
Brush	10μ (touch up)
Roller	Not commended

## Application Procedure

- 1:-Flush all equipment with recommended cleaner before use.
- 2: Pour the liquid slowly in to the zinc paste with constant mechanical stirring do not mix in the reverse order. Continue stirring until the mixture is free of lumps. .
- 3: For air spray, thin with no more than 2-5% of recommend thinner for workability for airless spray thinner is not recommended.
- 4: Apply wet coat by parallel passes overlap each pass 50% to avoid bare areas.
- 5: Shop Primer must be fully cured before recoating.
- 5: 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.

