

ALPHAGAM

TECHNICAL DATA SHEET

PRIMER

APP10034 2K EPOXY ZINC RICH PRIMER 004 TDS

2K EPOXY ZINC RICH PRIMER 004

Product Code: APP10034

PRODUCT INFO

2K EPOXY ZINC RICH PRIMER 004 is a modified zinc rich epoxy primer for anticorrosive protection of steel structures in aggressive environments with a fast handling and recoatability.

2K EPOXY ZINC RICH PRIMER 004 is very resistant to mud cracking, and easy to apply by airless, roller or brush, and can be used over commercial abrasive blasted steel (grade Sa 2 - ISO 8501), which makes it also ideally suited for touch-up and maintenance

Coverage: 5 - 6 m²/l at 40 - 50 μm DFT

FEATURES

- Fast handling and over coating times.
- Exceptional corrosion resistance.
- High Build application (150 dry microns) with no cracking.
- Low temperature cure (-5° C).
- Recoatable with any intermediate without risk of bubbles and/or pinholes (tie-coat is not required).
- Excellent adhesion.
- Easy to apply by brush, roller or spray.
- Accepts a wide variety of topcoats for severe exposures (not unsaponifiable coatings).

RECOMMENDED USE

- Suitable for indoor and outdoor use, workshop, new construction and maintenance services in tanks, piping, ships, equipment and any other steel surfaces.
- For all environments like offshore platforms, refineries, chemical plants, etc.
- Used over new steel or shop primer.
- For touch-up and maintenance work.
- Typical systems: see technical bulletin.

This data sheet is for information purpose only. To our knowledge the data provided complies with the latest standard and is based on years of experience in the manufacture of our products. However the data is not binding and without warranty. Please follow recommendations stated on the relevant precautions stated on the product label. We reserve our right to make additions, deletions or modifications to the information at any time without prior notification.

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SURFACE PREPARATION

All surfaces must be dry, clean, and free from other foreign substances

Steel: abrasive blast to minimum Sa 2; recommended Sa 2½ (ISO 8501 or SSPC-SP10) with a surface roughness equivalent to Rugotest N°3, BN9-BN10, or Rz 35 to 65 µm profile according to Keane Tator comparator or similar, obtained with the adequate form and granularity abrasive to reach the profile required.

APPLICATION INSTRUCTIONS

2K Epoxy Zinc Primer 004 is supplied as two cans set that must be mixed for the application. Both components must be homogenized (make sure there is no pigment remaining on the bottom of the cans).

Slowly add all the hardener into the base while stirring and homogenize the mixture.

It is recommended that the product temperature is above 10°C.

It must be ensured that continuous ventilation and the correct EPI's are used during the application. For indoor application, proper ventilation is recommended in order to facilitate curing and solvent evaporation



Application Method

Application method	Pressure/bar	Nozzle/mm	Spray Passes	Thinner (%)
Gravity spray gun (high pressure)	1.6 - 2	1.3 - 1.8	2 - 3	0 - 25
HVLP (low pressure)	1.6 - 2	1.3 - 1.8	1 - 2	0 - 25
Airmix / Airless	100 - 120	0.23 - 0.33	1 - 2	0 - 5
Brushing, Rolling	-	-	-	0 - 5

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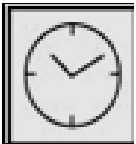
Pot life :
4 - 6 hrs @ 30 °C



Hardener:
1-UP 2K PU Epoxy Hardener @ 30°C



Thinner:
NA



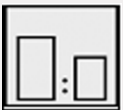
Drying time :

Object temperature	Dust Dry/min	Set to touch	Ready for assembly	Sandable	Recoatible
30°C	30 min	2 - 3 h	12 h	NA	4 h
60°C	NA	45 min	NA	NA	2 h

Technical Information



Colour :
Dark Grey



Mixing Ratio :
10 : 1





Spraying Viscosity :
NA

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	Flash Off Time : 10 - 15 min.
	Dry Coat Thickness : 70 - 90 µm

Storage :	1year from the date of manufacturing at 30° C, if stored in a dark / dry place in a tightly closed container
VOC Regulation :	–
Processing Conditions :	From +10°C and up to 80% relative air humidity. Ensure an adequate air ventilation.