

APCODUR EPOXY ZINC CHROME PRIMER / APCODUR 96



PRODUCT DESCRIPTION

Two component, epoxy primer with zinc chromate pigment

FEATURES & RECOMMENDED USE

- Designed as an anti-corrosive epoxy primer in protective coating system
- Good resistance to saline, marine and chemical environments
- Can be over coated with alkyd, chlorinated rubber, acrylic, epoxy, polyurethane coating
- Ease of application by spray & brush

TECHNICAL DATA

Colour	Red Oxide
Gloss	Matt
Volume Solids	Approx. 40%
Recommended DFT / Coat	35 - 50 μ m
Theoretical Coverage Capacity	11.4 sq.mtr/l @ 35 μ m DFT 8.0 sq.mtr/l @ 50 μ m DFT
Drying Time at 30°C	Surface dry : 1 hour Hard dry : 12hours Full cure : 7 days
Over coating interval at 30°C	Min. : 12 hours Max. : 1 month, provided surface is dry and clean from all Contamination

The data given is for guideline only. The physical values are subject to normal manufacturing tolerances, colour and testing variances
The volume solids indicated are as per ASTM D 2697 air drying method
The actual drying time/ overcoat interval may be shorter or longer, depending on film thickness, ventilation, humidity, temperature etc.
The information provided above is at 30°C and 65% relative humidity

DIRECTIONS FOR USE

Surface Preparation

General

- Surfaces must be dry, clean and free from contaminants
- Ensure removal of dirt, dust, oil and all other contaminants that could interfere with adhesion of the primer. Oil and grease should be removed as per SSPC-SP1 solvent cleaning with aromatic solvents
- Surface should be checked and treated in accordance with ISO 8504 prior to priming

Blast Cleaning

- Steel, abrasive blast clean to min. Sa 2.5 Swedish specification. In case oxidation has occurred between blasting and application of Apcodur Epoxy Zinc Chrome Primer / Apcodur 96, the surface should be re-blasted
- A blasting profile of (Rz) 30 - 50 μ m is recommended

Application Conditions

- Substrate temperature should be at least 3°C above dew point but not above 50°C
- Relative humidity should be below 85%
- Good ventilation is required in confined areas to ensure proper curing

Mixing

- Apcodur Epoxy Zinc Chrome Primer / Apcodur 96 is supplied in two packs. 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 (at lower RPM) for quick homogenous mixing
- Mix hardener gradually into the base under continuous stirring as per the mixing ratio. Once the unit has been mixed, it should be consumed within the working pot life. In case of part mixing (which should be avoided), close the lids of containers tightly to avoid contact with atmospheric moisture
- Thinner should be added after mixing the components and post the induction time. Addition of excessive thinner will lead to reduced sag resistance

Mixing Ratio (by volume)	Base : Hardener 3 : 1
Induction Time	30 minutes
Pot Life at 30°C	6 hours

Application

Air Spray Recommended thinner Volume of thinner Nozzle orifice Nozzle pressure Cleaning Thinner	T 141 10 - 20% * 1.5 - 3.0 mm 0.3 – 0.4 MPa (approx. 3 – 4atm; 43 – 57 p.s.i.) T 141
Airless Spray Recommended thinner Volume of thinner Nozzle orifice Nozzle pressure Cleaning Thinner	T 141 0 - 10% * 0.33 - 0.41mm (13 – 16Thou) 16 – 20 MPa (approx. 160 – 200 atm; 2300 - 2800p.s.i.) T 141
Airless Spray <i>Suitable for stripe coating and small areas</i> Recommended thinner Volume of thinner	T 141 0 - 10% *

*Note: Depending on recommended thickness & application condition

Cleaning

- Do not allow the product to remain in hoses, gun or spray equipment. Clean all equipment's immediately after use with Thinner T 141. It is recommended to periodically flush out spray equipment during the course of the working day. The frequency of cleaning will depend on amount sprayed, temperature and time gap
- All surplus material and empty containers should be disposed of in accordance with appropriate regional legislation

Product Characteristics

- Higher film build up in single coat can be attained only by airless spray. Conventional Air spray or application using pressure pot may require multiple coats to achieve desired film build. Restrict brush and roller application only for stipe coat and for smaller areas
- The maximum performance is achieved after complete curing
- As common with all epoxies Apcodur Epoxy Zinc Chrome Primer / Apcodur 96 will chalk and discolour on exterior exposure. However, these phenomena are not detrimental to anti-corrosive performance. The actual rate of chalking will depend upon climatic conditions and will normally be limited to a thin surface layer

PACK SIZE	20 L (Base: 15 L & Hardener: 5 L)
STORAGE	Shelf Life: At least 12 months @ 30°C for original unopened pack, subject to inspection thereafter Store in a cool, dry place and in accordance with local regulations
REGULATORY INFORMATION	Flash Point: Base: Not less than 24°C ; Hardener: Not less than 24°C VOC: Approx. 510 ± 20 gm/ ltr as per USA-EPA Method 24 Product Weight: Approx. 1.29 ± 0.04kg/ ltr (Red Oxide)

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

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