

APCOMIN HB ZINC PHOSPHATE PRIMER / APCOMIN 102



PRODUCT DESCRIPTION

Single pack, air drying phenolic modified oleo resinous composition with zinc phosphate pigment

FEATURES & RECOMMENDED USE

- Anti-corrosive primer for use in marine and mildly corrosive environment
- Heat resistant up to 175°C (dry heat)
- Good adhesion to prepared steel
- Easy application by brush
- Can be top coated by alkyd based top coats

TECHNICAL DATA

Colour	Red oxide & Grey
Gloss	Matt
Volume Solids	Approx. 46%
Recommended DFT / Coat	30 - 40 μm
Theoretical Covering Capacity	15.3 sq.mtr/ ltr @ 30 μm 11.5 sq.mtr/ ltr @ 40 μm
Drying Time at 30°C	Surface dry : 1 hour Hard dry : 16 hour
Overcoating interval at 30°C	Min. : 16 hours Max. : Unlimited, 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

DIRECTION 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 coating. Oil and grease should be removed as per SSPC-SP1 solvent cleaning
- 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 Apcomin HB Zinc Phosphate Primer / Apcomin 102, the surface should be re-blasted
- A blasting profile of (Rz) 40-50 μm 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

- If settling is observed in the drum, loosen the settled material with the help of hand stirrer followed by power driven stirrer for quick homogenous mixing
- Thinner should be added after mixing. Addition of excessive thinner will lead to reduced sag resistance

Application

Air Spray Recommended thinner Volume of thinner Nozzle Orifice Nozzle Pressure	T - 284 5 - 15% * 1.5 - 3.0 mm 0.3 – 0.4 MPa (= approx. 3 – 4 atm; 43 – 57 p.s.i.)
Airless Spray Recommended thinner Volume of thinner Nozzle orifice Nozzle pressure Cleaning Thinner	T - 284 0 - 10% * 0.38 - 0.46 mm (15 – 18 Thou) 12 – 15 MPa (= approx. 120 – 150 atm; 1700 - 2100 p.s.i.) t - 284
Brush / Roller Recommended thinner Volume of thinner	T - 284 0 - 5% *

**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 -284. 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 off in accordance with appropriate regional legislation

Product Characteristics

- The maximum performance is achieved after complete drying
- At higher relative humidity, drying may get retarded

PACK SIZE	20 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: Not less than 30°C VOC: 450 ± 30 gm/ltr (depending on shades) as per USA-EPA Method 24 Product Weight: Approx. 1.38 ± 0.04 kg/ltr

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 is always recommended while 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. The company reserves the right to modify data contained herein without prior notice. Any change in data would normally be followed by issue of a new data-sheet. The user should check with the nearest sales office of the company and confirm the validity of the information, prior to using the product.

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