

# APCODUR HB ZP PRIMER / APCODUR 207

## PRODUCT DESCRIPTION

Two component, epoxy primer with zinc phosphate pigment

## FEATURES & RECOMMENDED USE

- Designed as an epoxy primer with very good resistance to saline, marine and chemical environments
- Free from lead and chromate containing pigment
- Good adhesion on steel
- Ease of application by spray & brush
- Can be over coated with alkyd, chlorinated rubber, acrylic, epoxy, polyurethane coating

## TECHNICAL DATA

Colour	Red Oxide & Grey
Gloss	Matt
Volume Solids	Approx. 40 %
Recommended DFT / Coat	35 - 50 $\mu$ m
Theoretical Coverage Capacity	11.4 sq.mtr/ltr @ 35 $\mu$ m DFT 8.0 sq.mtr/ltr @ 50 $\mu$ m DFT
Drying time at 30°C	Surface Dry : 1 hours Hard Dry : 12 hours 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 HB ZP Primer / Apcodur 207, the surface should be re-blasted
- A blasting profile of (Rz) 30 - 50  $\mu$ 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 HB ZP Primer / Apcodur 207 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

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

## Application

<b>Air Spray</b> 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 3-4 atm, 43-57 p.s.i.) T 141
<b>Airless Spray</b> Recommended thinner Volume of thinner Nozzle orifice Nozzle pressure Cleaning Thinner	T 141 0 – 15 % * 0.33 - 0.41 mm (13 – 16 Thou) 16 – 20 MPa (= approx. 160 – 200 atm; 2300 - 2800 p.s.i.) T 141
<b>Brush</b> <i>Suitable for stripe coating and small areas</i> Recommended thinner Volume of thinner	T 141 5 – 15 % *

\*Note : Depending on recommended thickness & application conditions

## 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 stripe coat and for smaller areas
- The maximum performance is achieved after complete curing
- As common with all epoxies Apcodur HB ZP Primer / Apcodur 207 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

<b>PACK SIZE</b>	20 L (Base: 15 L & Hardener: 5 L)
<b>STORAGE</b>	<b>Shelf Life:</b> At least 12 months at 30°C for original unopened pack, subject to inspection thereafter. Store in a cool, dry place and in accordance with local regulations
<b>REGULATORY INFORMATION</b>	<b>Flash Point:</b> Base: Not less than 24°C ; Hardener: Not less than 24 °C <b>VOC:</b> Approx. 510 ± 20 gm/ltr (depending on shades) as per USA-EPA Method 24 <b>Product Weight:</b> Approx. 1.29 ± 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 are always recommended when spraying paint
- Please refer our Material Safety Data Sheet prior to using the product

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