

# APCOMIN INDUSTRIAL ROZC PRIMER / APCOMIN 92



## PRODUCT DESCRIPTION

Single pack, air drying, oleoresinous composition with zinc chrome & red oxide pigments

## FEATURES & RECOMMENDED USE

- Designed as an anticorrosive primer for industrial application
- Suitable for use in mildly corrosive environments
- Easy application by brush
- Can be top coated by alkyd based top coats

## TECHNICAL DATA

Colour	Red oxide
Gloss	Matt
Volume Solids	Approx. 30 %
Recommended DFT / Coat	25 - 35 $\mu$ m
Theoretical Coverage Capacity	15.0 sq.mtr/ ltr @ 20 $\mu$ m DFT 12.0 sq.mtr/ ltr @ 25 $\mu$ m DFT
Drying time at 30°C	Surface Dry : 1 hours Hard Dry : 12 hours
Over coating interval at 30°C	Min : 12 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

## 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 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 Industrial ROZC Primer, 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

- 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

<b>Air Spray</b>	
Recommended thinner	T - 284
Volume of thinner	5 - 10 % *
Nozzle orifice	1.5 - 3.0 mm
Nozzle Pressure	0.3 – 0.4 MPa (= approx. 3 – 4 atm; 43 – 57 p.s.i.)
Cleaning Thinner	T - 284
<b>Airless Spray</b>	
Recommended thinner	T - 284
Volume of thinner	0 – 5 % *
Nozzle orifice	0.38 - 0.46 mm (15 – 18 Thou)
Nozzle Pressure	10 – 13 MPa (= approx. 100 – 130 atm; 1400 - 1800 p.s.i.)
Cleaning Thinner	T - 284
<b>Brush / Roller</b>	
Recommended thinner	T - 284
Volume of thinner	0 – 5 % *

*\*Note: Depending on recommended thickness & application conditions*

## Cleaning

- Do not allow the product to remain in hoses, gun or spray equipment. Clean all equipments 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

<b>PACK SIZE</b>	20 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> Not less than 30°C <b>VOC:</b> 210 ± 30 gm/ ltr (depending on shades) as per USA-EPA Method 24 <b>Product Weight:</b> Approx 1.40 ± 0.07 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

**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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**Head Office:** Asian Paints PPG Private Limited, Plot No-5, Gaiwadi Industrial Estate, S.V. Road, Goregaon (W), Mumbai 400 062

**Tel No:** 022 62182700, **CIN:** U24110MH2011PTC220557, **Email:** customercare.apppg@asianpaintsppg.com, **Website:** www.asianpaintsppg.com