

DESCRIPTION

A two pack, iron oxide epoxy shop (pre-construction) primer.

RECOMMENDED USE

As a shop (pre-construction) primer for the protection of steel during fabrication and assembly. Suitable for use with controlled cathodic protection.

For use at Newbuilding.

SPECIFICATION DATA

Gloss	Flat
Colour	Red Brown
Specific gravity	1.15 ± 1 kg/ litre.
Solid by volume	30 ± 2%
Recommended	Dry film thickness : 20 – 30 microns. Wet film thickness : 50 – 75 microns.
Coverage theoretical	15 m ² / litre – 20 microns, 10m ² / litre – 30 microns
Dry time	

Temperature	Touch dry	Hard dry
20°C	4 minutes	2 Hours
30°C	3 minutes	1 Hours

Full cure	7 days.
Painting interval	Min: 8 Hours Max: 90 Days at @30°C
VOC(EPA Method 24)	624 g/lit (5.21 lb/US gal) as supplied (EPA Method 24)
Flash point (DIN 53213)	25°C for base and 26°C for hardener
Pot life	24 Hours @30°C and less at higher temperature. (After mixing the components).
Shelf life	24 months (cool & Dry Place) In some markets commercial shelf life can be dictated shorter by local legislation. The above is minimum shelf life, thereafter the paint quality is subject to re-inspection.

SURFACE PREPARATION

- ❖ All surfaces should be clean, dry and free from contamination. The surface should be assessed and treated in accordance with ISO 8504.
- ❖ In case of new steel, abrasive sand blasting to minimum Sa 2½ in accordance with ISO 8501-1 : 1988 or SSPC-SP-10.
- ❖ Roughness: using abrasive suitable to achieve grade Fine to Medium S/G (35 – 60 µm, Ry5) (ISO 8503-2).
- ❖ Provide adequate ventilation during application and drying.

The information in this product data sheet is given to the best of our knowledge based on laboratory testing and practical experience. If the product is used under condition beyond our control, we cannot guarantee anything but the quality of the products it self. The information in this product data sheet is liable for modification from time to time in the light of experience and our policy of continuous product development, and without further notice.

SURFACE PREPARATION

Mixing

Material is supplied in 2 containers as a unit. Always mix a complete unit in the proportions supplied. Once the unit has been mixed it must be used within the working pot life specified.(1) Agitate Base (Part A) with a power agitator.(2) Combine entire contents of Curing Agent (Part B) with Base (Part A) and mix thoroughly with power agitator.

Mixing by Volume

(3 : 1)

Thinner

Epoxy Thinner (if required).
Thinning 0 – 10% by Volume

Airless Spray

Recommended

Tip Range 18-31 thou (0.46-0.79 mm)
Total output fluid pressure at spray tip not less than 1250 psi (88 kg/cm²)

Conventional Spray

Suitable.

Use suitable proprietary equipment. Thinning may be required.

Brush

Application by brush is recommended for small areas only.

Roller

Application by roller is recommended for small areas only.

SAFETY PRECAUTION

Keep away from heat, spark and open flames. Avoid breathing of vapour on skin and eye contact. Keep container closed and store in cool, ventilated area when not in use. Proper ventilation and protective measures must be provided during mixing, application and drying, to keep vapour concentration within safe limits and to protect against toxic hazard. Necessary safety equipment must be used and ventilation requirements carefully observed, especially in confined or enclosed spaces, such as tank interior and building.

The information in this product data sheet is given to the best of our knowledge based on laboratory testing and practical experience. If the product is used under condition beyond our control, we cannot guarantee anything but the quality of the products it self. The information in this product data sheet is liable for modification from time to time in the light of experience and our policy of continuous product development, and without further notice.

Rev.0 20 September 2023

www.ken-gloss.com