RED IRON OXIDE ZINC PHOSPHATE EPOXY PRIMER

Product information

1-Poly amide epoxy primer.

2-Excellent rust inhibitive shop primer in corrosive environments.

3-High chemical and water resistance.

Physical data

Colour:	red - brown
Finish:	Flat
Flash point:	
resin:	34 °c
cure:	36 °c
solvent:	28 °c
Volume solids:	60±2%
D.F.T:	60 -70 microns
Specific gravity(mixed):	1.68± 0.05gr/cm^3
Theoretical coverage:	10 m^2 /lit (at 60 µ D.F.T)
Drying time at 25°c:	
touch dry:	2 hrs
dry to handle:	6-8hrs
full cure:	7days
Component:	2
Pot life:	8 hrs at 25 °c:
Mixing ratio(by volume):	
resin:	refer to can label
cure:	refer to can liable
Application methods:	conventional spray or brush or airless spray or roller

Recoat intervals*:	10 °c	25 °c	40 °c
(mild condition) : Min:	25 hrs	12 hrs	5 hrs
Max:	70 hrs	36 hrs	18 hrs

Recommended thinner:	FARCO THINN 10
Recommended cleaner:	FARCO CLEAN 10
Shelf life:	12 months when stored indoors in unopened Original containers at 5 to 40 °c (cool and dry place).
Curing mechanism:	by solvent release and reaction by curing agent and resin
Substrate:	steel

**: For recoating the surface should be free of dust ,grease and contamination .*

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Typical uses

As a blast primer for epoxy systems According to specification.
Structural steel,machinery,pipes and tank exteriors
decks,hulls,bottoms and super structures
of ships,barges and work boats,offshore platforms and related structures.

Application information

This Rangan Far's product is a red iron oxide epoxy
primer for industrial and marine use.
To obtain the maximum performance for which this product
is formulated,strict adherence to all application,instructions,
precautions,conditions and limitations is necessary.

Application equipment

The following equipment is listed as a guide and suitable
equipment from other manufactures may be used.
adjustments of pressure and change of tip size may be
Needed to obtain the proper spray characteristics.
1-Airless spray:standard airless spray equipment having
a 28:1 or higher pump ratio and a fluid tip with a 0.457 to 0.660 mm orifice.
2-Conventional spray:Industrial equipment with suitable
aircap having a fluid tip with a 1.8-2 mm orifice .
3 -Mixer: mixer must be powered by an air motor or an explosion proof electric motor.
4-Brush or roller.

Caution

1-Handle with care.
2-Avoid inhalation of possible solvent vapours or
paint mist, as well as paint contact with skin and eyes.
3-Apply only in well ventilated areas and ensure that
adequate forced ventilation exists when paint applies is
in confined spaces or when the air is stagnant.
4-Always take precautions against the risks of fire and explosions.
5-Harmful or fatal if swallowed,immediately seek medical assistance.
6-Use fresh air masks and explosion proof equipment.

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Application procedures

1-Flush equipment with cleaner before use.
2-Stir resin to an even consistency with a power mixer.
3-Add cure to resin and continue stirring for 5 minutes.
Note: since the pot life is limited and shortened by high temperatures ,do not mix more material than will be used in 8 hours at 25 °c .
4- Thinning with FARCO THINN 10 as needed for workability.
5-Stir during application to maintain uniformity of material and apply a wet coat in even parallel passes after 20 minutes.
6-Clean all equipment with cleaner immediately after use .

Environmental condition

Environmental temperature must be 10-40°c.
Surface temperature must be at least 3°c above dew point to prevent condensation. At freezing temperature surface must be free of ice and relative humidity below 80 %.

Surface preparation

Sand blasting to a standard Sa 2.5 – Sa3 , SIS 05 5900 , ISO 8501-1.

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