MAKEPaints

MAKEZINC EPOXY PRIMER 302
Zinc Rich Epoxy Primer

Base 302 : Curing Agent 3201

PRODUCT DESCRIPTION

Two Components Polyamide Cured Zinc Rich Epoxy Primer

RECOMMENDED USE

A zinc primer for applications in aggressive environments in a wide range of industries and to repair organic / inorganic zinc primer.

CHARACTERISTIC

- Excellent adhesion to inorganic zinc primer.
- Good corrosion prevention properties.
- Quick drying and can be over coated after a short interval.
- Excellent abrasion resistance which minimize transit and handling damages.
- Not recommended for immersion service in acid and alcohols.

PHYSICAL DATA

- **Colour** : Grey.
- **Gloss level** : Flat.
- **Specific Gravity** : 1.8 ± 0.5 kg/litre.
- **Volume Solid** : Approx. 50 ± 2%.
- **Dry Film Thickness** : 75 microns per coats.
- **Theoretical Coverage** : 6.7 sq.m/litre for 75 microns.
- **Dry Time** :

Temperature	Touch Dry	Hard Dry
26°C	30 minutes	6 hours
32°C	20 minutes	5 hours
36°C	10 minutes	4 hours
40°C	5 minutes	3 hours

- **Full Cure** : 7 Day
- **Painting Interval** : Min : 6 Hours, Max 6 Months
- **VOC** : Max. 482.2 g/litre
- **Flash Point(DIN 53213)** : 29°C for base and 26°C for hardener
- **Pot Life** : 6 hours (after mixing the components)
- **Service Temperature** : Continuous : 120°C ; Periodic : up to 150°C.
- **Shelf Life** : 12 months (cool and dry place)

SURFACE PREPARATION

Steel : blast cleaned in situ to at least SSPC – SP10 and free from rust, scale, shop primer and any other contamination

CONDITION OF APPLICATION

Temperature ; minimum 5°C : maximum 50°C.

Relative Humidity maximum 85%.

Substrate temperature should be at last 3°C above dew point.

SYSTEM SPECIFICATION

Suitable top coat, epoxy/coal tar epoxy, vinyl, chlorinate rubber or polyurethane.

INSTRUCTION FOR USE

- Mixing ratio by volume ; Base; Hardener 4 : 1.
- The temperature of mixed base and hardener should be above 15°C, otherwise extra solvent may be required to obtain application viscocity.
- Stir well before use preferable by means of mechanical mixer. Thinner should be added after mixing the components.
- Too much solvent result in lower sag resistance and slower cure
- Thinner should be added after mixing the components

APPLICATION DETAILS

Methode Application	Airless Spray	Air Spray	Roller Brush
Thinner No	MAKE 906	MAKE 906	MAKE 906
Volume of Thinner	Max 10%	Max 5-15%	Max 5%
Nozzle orifice	0.017 (0.43m)	2 mm	-
Nozzle Presure	150 bar (2100 psi)	4 bar / 57 psi	-
Cleaning Solven	MAKE 10	-	-

ADDITIONAL DATA

Film Thickness ad spreading rate

DTF in micron	25	35	50
Theoretical spreading Rate m²/litre	20	14.3	10

Over coating table for DFT 35 - 50 microns

Substrate Temp	**10°C**	**26°C**	**30°C**	**40°C**
Min interval	8 hours	5 hours	4 hours	3 hours
Max interval	Several months when free from zinc salt and contaminat			

- Zinc rich primer can from zinc salt on the surface, they should be not be weathered for long period be for over coating.
- An interval of several months can be allowed , however , under iclean nterior exposure condition.
- In clean exterior condition maximum interval of 14 days can be toleranted. but in industrial or marine condition this interval should be reduce to the practical minimum.
- At all time visible surface contamination must be remove before over coating by high pressure water cleaning, sweep blasting or machanical cleaning.

STORAGE & HANDLING

The product must be stored in accordance with national regulation. Storage conditions are to keep the containers in a dry, cool, well ventilated space and away from source of heat and ignition. Containers must be kept tightly closed. Handle with care, stir well before use.

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.

DISCLAIMER

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.