



PREMIUM TWIN PACK EPOXY PRIMER

HI-POXY PRIMER ALUMINIUM

CODE:

HEP03

DESCRIPTION:

A superior twin pack Epoxy primer, with aluminium flakes, for surfaces requiring a tough anti-corrosive primer. For interior/exterior surfaces requiring tough, long lasting protection in high corrosive areas. May be used as a primer, intermediate, or finishing coat. Designed for maintenance and repair in terrestrial and marine environments.

PRODUCT BENEFITS:

Good chemical and water resistance. Surface tolerant, high solids and high build primer. Can be used in offshore environments. Applied by spray, brush or roller. Good adhesion.

SURFACE PREPARATION:

All surfaces should be dry, clean and free from loose flaking paint, rust, oil or any other surface contamination. **PREVIOUSLY PAINTED:** Paint in a deteriorated state should be stripped back to original surface. Check compatibility with previous paint. Previous Epoxy Paint in good condition to be well sanded. Wipe off all sanding residue and wipe down with a dry cloth or blow dry. Remove zinc salts by high pressure water cleaning. **UNPAINTED METAL:** Surfaces to be cleaned well. Remove all dirt, oil, grease and other contaminants. Remove weld spatter and smooth down weld seams and sharp edges. Apply primer immediately after cleaning. Allow sufficient drying time before overcoating.

GENERAL:

Do not apply in wet/damp conditions. Do not apply over alkyd enamels or acid-curing wash or etch primers. **Limited Pot Life** - Do not mix more than the volume to be used in 4 hours.

APPLICATION:

Application by spray, brush or roller, after mixing with curing agent. Thin with Epoxy Thinners to 16 - 18 seconds Ford Cup 4 for conventional spraying. Airless spray - nozzle pressure 180 - 250 bars. Nozzle size 0.48 - 0.66mm. Spray angle 40 - 80 degrees. Volume thinner - maximum 5%. Airless spray recommended. Multiple coats required to achieve the specified DFT. Volume thinner - maximum 10%. Always thin after mixing base and curing agent. Avoid excessive thinning. Clean up with Epoxy Thinners.

TECHNICAL DATA:

Type:	Twin Pack Epoxy
Mixing Ratio:	4 Base : 1 Catalyst
Drying Time: (T)	4 Hours
@ 25°C (H):	12 Hours
Recoat:	12 Hours
Full Cure:	4 Days
Pot Life:	4 Hours
Solids by Volume (mixed):	80 - 84%
Solids by Mass (mixed):	86 - 88%
Spread rate:	2 - 8m ² /Lt depending on substrate porosity.
Recommended WFT:	155 microns
Recommended DFT:	125 microns
Flashpoint (mixed):	Above 24°C
Colour Range:	Aluminium

Health and Safety:

Refer to Material Safety Data Sheet