



The Ultimate Protective Solution

SP PRIME 34

TECHNICAL DATA

A two pack Epoxy, polyamide cold cured, zinc phosphate Grey Primer for **GI & Aluminum** substrates.

INTENDED USES

For protection against corrosion, chemicals, solvents etc., recommended for direct application on Ferrous as well as non ferrous metals like **Aluminium, stainless steel, zinc alloy, cast iron & galvanized substrates** after proper surface preparation. This product is compatible with our epoxy or polyurethane topcoats. This high performance Red oxide Primer is recommended to OEM's, Automobile & Locomotives, Marine structures, Process Industry etc.

PHYSICAL PROPERTIES

Colour	: Grey (self standard)
Finish	: Matt
% Solids by Volume	: $42 \pm 2 \%$
Flash Point	: Above 25°C
Mixing ratio (Base : Hardener)	: 3:1 by Volume
Thinner intake	: 5 to 10 %
Maturation time	: Allow the mixed material for 10-15 minutes before use.
Recommended D.F.T.	: 25-30 μm per coat.
Drying time @ 30°C & at recommended D.F.T.	: a) Surface Dry : $\frac{1}{2}$ hr. b) Hard dry : 10-12 hrs. c) Complete Cure: 7 days (for chemical testing)
Over coating Interval	: 4 to 24 hrs. @ 30°C
Recommended Thinner	: T-1000 for thinning & equipment cleaning
Pot Life	: 4 – 6 hrs. @ 30°C
Shelf life	: 12 months (Individual sealed components under normal storage condition)
Theoretical Coverage	: $14\text{m}^2/\text{litre}$ on smooth & non-absorbent surface @ recomd. DFT
Application method	: By conventional Spray / Airless spray / Brush
Compatibility	: Can be over coated with Epoxy or Polyurethane topcoats.

SURFACE PREPARATION :

Remove all loose particles, dust, and mill scales by shot blast cleaning or 7 tank phosphating, where-ever possible is recommended. Mill scales should be removed for optimum performance. Remove all other contaminants, oil, grease etc. by use of our thinner.

Blast clean to Sa 2 1/2 (ISO 8501-1), steel profile recommended 25 – 50 μm . Check the steel profile, if it is between 25–30 μm then the (DFT) thickness of the total paint system should be 90 – 100 μm . (The DFT of the total paint system should be thrice to profile of the blasted surface.)

APPLICATION CONDITIONS AND OVERCOATING :

This product should preferably be applied at temperatures in excess of 10°C. In conditions of high relative humidity i.e. 80-85% good ventilation conditions are essential. Substrate temperature should be at least 5°C & above the dew point. This product can be over coated after 3-4 hrs.

The maximum air and substrate temperature for application is 50°C providing conditions allow satisfactory application & film formation. If the air & substrate temperature exceed 50°C & this coatings are applied under these conditions, paint film defects such as dry-spray, bubbles & pinholes etc. can occur within the coating.

Application at ambient air temperatures below 5°C is not recommended. Do not apply when relative humidity rises above 90%. Do not apply during rain, fog or mist. Such conditions do not permit adhesion of coating with the substrate. **(For details please refer our painting procedure.)**

POT LIFE OF MIXED MATERIAL :

At the time of mixing the material, if the temperature exceed of 35°C the pot life will be approximately halved. Use of this product outside of the pot life may result in inferior adhesion properties even if the material appears fit for application. Thinning the mixed product will not alleviate this problem.

Thinner should be added after mixing the Base & Hardner in recommended mixing ratio by volume.

RESISTANCE GUIDE (With Suitable Topcoat) :

EXPOSURES	SPLASH & SPILLAGE	FUMES & OUTDOOR EXPOSURE
Acids	Good	Good
Alkalies	Good	Good
Solvents	Very Good	Excellent
Salt	Good	Excellent
Water	Excellent	Excellent
Industrial Oils	Excellent	Excellent

Temperature Resistance : Intermittent 150°C & Continues 120°C

ADDITIONAL NOTES :

Drying times, curing times and pot life should be considered as a guide only.

The curing reaction of this product commences immediately the two components are mixed, and since the reaction is dependent on the atmospheric **temperature**.

Numerical values quoted for physical data vary slightly from batch to batch & against the temperature.

Immediately close the partly used Hardner container, it is very sensitive to atmospheric moisture.

SAFETY PRECAUTIONS :

While applying this product in closed structures, arrangements for adequate ventilation must be ensured. Smoking and naked lights should not be permitted. Mask should be worn when spraying. To avoid skin contamination use barrier cream or disposable gloves. Wash hands and face regularly with hot water and soap. Brushes & equipment should be cleaned with recommended thinner immediately after use.

DISCLAIMER : The information in this data sheet is given to the best of our knowledge based on laboratory testing & practical experience. It is the user's responsibility to conduct all necessary trials & tests to confirm the suitability of any product or system to their intended use. Our all recommendations or suggestions whether in technical documentations in writing or verbal are given in good faith but without any type of warranty or liability on us. We have no control over either the quality or condition of the substrate, or the factors affecting the use & applications of the product. Therefore we do not accept any liability arising from loss, injury or damage resulting from such uses.

**SWARAJ POLYCOATS**

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