Diamond Vogel | INDUSTRIAL COATINGS

TECHNICAL DATA SHEET

Product Description: Zinc Rich Epoxy Primer

PRODUCT CODES: PF-0266 – Zinc Rich

DESCRIPTION: Hyperprime Zinc Rich Epoxy Primer is a fast drying, high performance, high solids primer for Original Equipment Manufacturers that require excellent gloss holdout, adhesion, chip resistance and zinc rich corrosion resistance.

PHYSICAL PROPERTIES:

Weight Solids:	80%
Volume Solids:	47%
Resin Type:	Epoxy
Gloss:	Semi-Gloss
Theoretical Coverage:	753 square feet at 1.0 mil
Weight Per Gallon:	19.0 pounds
Blended Viscosity:	#3 Zahn – 10 to 20 seconds at 77ºF
VOC:	3.5 pounds per gallon
Sag Resistance:	12.0 mils
Zinc:	80+% zinc dust on total weight solids (mixed)

SURFACE PREPARATION: The service expectancy of a coating is primarily dependent upon good surface preparation. The surface to be coated should be free of mill scale, rust, oil, and other contaminates, including salt deposits. For optimum adhesion, hot rolled steel should have the mill scale removed by an abrasive blast to a minimum SSPC-SP-6 to an average profile of 1.5 mils and then coated before flash rusting occurs

ACTIVATION: Hyperprime Zinc Rich Epoxy Primer should be mixed 4 parts A to 1 part B (PF-0286) by volume. No sweat in time is necessary. The pot life will be approximately 8 hours at 77°F. This primer can be sprayed with all types of application equipment. PF-0285 or PF-1287 may be used as an intermediate coat.

REDUCTION:

Airless:	For airless application no reduction is necessary.
Conventional Air:	For conventional air spray some reduction may be necessary. Use MEK for reducing purposes.

APPLICATION:

Airless:	Airless tip sizes should be in the .015 to 0.19 range. Adjust pressures accordingly for best atomization and transfer efficiencies. Air-assist airless pressures will be in the 800 to 1000 pound range for fluid and 30 to 50 pound range for atomizing air.
Conventional Air:	Pressures are dependent upon the type of gun and fluid nozzle, but typically will be in the 45 to 60 pound range for proper atomization.
In-Line Heat:	In line heat may be utilized up to 100°F to improve application. Caution must be exercised to turn heat off during shut downs to avoid locking up the paint lines due to decrease in material pot life.
Dry Film Thickness:	For best results, dry film thicknesses should be 2.0 to 3.0 mils above surface profile. This will require wet film thicknesses of about 4.0 to 6.0 mils.

DRY TIMES: Recoat times may vary according to film thicknesses and curing conditions, but typically Hyperprime Zinc Rich Epoxy Primer can be recoated after set to touch or approximately 30 minutes. Dry to handle times will be about 3 to 4 hours. Hyperprime Zinc rich Epoxy Primer can also be force dried to desired hardness

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at 160° to 180°F. Overnight hardness will be 2H+. After overnight or force drying care must be taken to insure adequate inter-coat adhesion. Scuff sanding may be necessary

CLEAN UP: Use ketones to flush application lines and equipment. The pot life will be approximately 8 hours at 77°F. At higher temperatures, pot life will diminish.

PERFORMANCE: Typical, tested on B-1000 panels at 2.0 to 3.0 mils DFT

Gravelometer:	ASTM D-3170 – 2A Excellent
Salt Spray:	ASTM B-117 – 2,000 hours – Pass
Pencil Hardness:	ASTM D-3363 – 3H

SAFETY PRECAUTIONS: Contains Acetate and Ketones when blended. Avoid contact with skin. Vapor and spray mist harmful. Use proper respiratory protection, including positive air supplied respirators. Refer to SDS for specific information. All information subject to change without notice.

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