Polidura Epoxy AC Primer

Component A: 4042
Component B: 4099

Polidura Epoxy AC Primer uses specially selected raw materials, showing high performance.

TECHNICAL CHARACTERISTICS

TYPE

Polyamide-cured epoxy primer and sealer, two pack system.

USAGE

Primer for metal structures and carbon steel equipment in general.

TECHNICAL INFORMATIONS			
COLOR	Red Oxide		
FINISH	Matt		
VOLUME SOLIDS	40% ± 2	According to ISO 3233	
WEIGHT PER LITER	1.300 ± 0.05 g/ml	According to ASTM D 1475	
FLASH POINT	32°C		
MIXING RATIO		Weight	Volume
	Comp. A	100.0	8.0
	Comp. B	9.0	1.0
POT LIFE (25°C)	6 h		
INDUCTION TIME	15 to 30 min		
THEORETICAL SPREADING RATE	11.4 m²/l - 35 µm		
	8.8 m²/l - 45 µm		
WET THICKNESS	87.5 to 112,5 µm		
DRY THICKNESS	35 to 45 µm		
DRYING TIME, for 35 µm		25°C	
		Minimum	Maximum
	Touch		1 h
	Handle		5 h
	Recoat	8 h	72 h
ENVIROMENTAL CONDITIONS	**Temperature**	Should be between 5 to 52°C	
	Relative Humidity	Between 30 to 85%	
	Dew Point	Surface temperature is at least 3°C above dew point	
	Thinner	4097 - Epoxy Thinner	
APPLICATION	**Brush**	It is not necessary dilution. This method must be used only for retouch and backing of welding cords and corners.	
	Roller	Dilute up to 10% (vol.) with recommended thinner. Must be used solvent resistant roller (sheep wool). The wool must be cutted (small size) to avoid blistering during the application.	
	Conventional Spray Gun	Dilute up to 10% (vol.) with recommended thinner. Conventional DeVilbiss JGA 502 FX 704 spray gun or similar. Spray pressure between 2.5 to 3.0 kgf/cm^2 (35 to 43 psi). Tank pressure between 0.5 to 1.5 kgf/cm^2 (7 to 21 psi).	
	AirLess Spray Gun	Dilute up to 10% (vol.) with recommended thinner. Use nozzles between 19 to 25 and pump pressure between 140 to 175 kgf/cm^2 (2000 to 2500 psi).	

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SURFACE PREPARATION	**Direct over carbon steel**	The surface must be dry, free of contaminants such as salt deposits, oil, grease, fat, dust and other kind of contaminants. Wash it off with fresh water, detergents and solvents. Recommended suface treatment abrasive blasting ISO 8501-1 Sa 2½ (minimun) with blast profile whose height is between 40 and 70 µm.
	Recommended Primers	Not applicable.
	Coated Surfaces	The surface must be clean and free of contaminants as oils, fat, grease and dust. Must not present peeling's areas. Proceed light sanding (220) to break the gloss.
	Recommended Topcoat	Polidura Glossy Epoxy Topcoat. Others finishes, please consult.

SHELF LIFE	18 months
UN NUMBER	**1263**
HAZARD NUMBER	**33**

IMPORTANT RECOMMENDATIONS

1. The practical spreading rate of the product varies according to the applied thickness, application method and techniques, type and rugosity of the surface and ambient conditions.

2. The weight/l, viscosity and drying values were obtained in laboratory at a temperature of 25°C. At an altered temperature, the results might be different from the specified ones.

3. Low temperatures increase the curing time. At temperatures below 10°C, please contact our technical department.

4. For One component acrylic finish, alkyds, etc., respecting interval of at least 6 hours and up to 24 hours. Exceeding this term must proceed sanding.

5. In order to use the product as primer, the color of different lots may vary slightly, since it does not conform to any specific color standard.

6. Pot life is shortened by higher temperature and by the increase of catalyzed volume.

SAFETY PRECAUTIONS

1. Improper use and handling of this product can be hazardous to health and cause fire or explosion. Do not use it without first taking all appropriate measures to prevent property damage and injuries.

2. Storage: keep the product in sheltered, well-ventilated areas. Maximum temperature: 40°C. Must not be directly exposed to the sun.

3. Flammable: flammable product, which must be kept distant from ignition sources, and do not smoke nearby.

4. Inhalation: Avoid breathing vapors, keeping proper ventilation during application and drying.

5. Handling: wear proper protective clothing and masks, goggles, etc. Do not eat or drink nor allow children and animals to be near the application area.

HEALTH HAZARDS

1. Skin contact: wash affected area thoroughly with neutral soap.

2. Clothing contact: remove clothing and wash it.

3. Leakage: Isolate the area, and do not smoke nearby. If large quantity leaked in confined area, wear protective masks. Do not inhale vapors. Stop leakage with sand, sawdust or soil, and transfer liquid and solid to separated recipients for disposal.

4. Fire: protect non-affected recipients with water spray. Extinguish fire using carbon dioxide, foam or dry chemical.

5. Eyes contact: flush eyes with large amounts of clean water for at least 10 minutes, and get medical attention immediately.

IMPORTANT: For further information consult the product MSDS (Material Safety Data Sheet).