

STOPCOAT 73

Zinc Rich Two component Epoxy Primer

NATURE AND USE : Zinc rich (**organic Type**) Epoxy Primer made of epoxy polyamide resins with a rich content of zinc powder . It is suitable to coat steel substrates, sandblasted at the degree SA 2.5 -SA 3 according to ISO 8501/1,(Refer to roughness profile indicated in the paragraph "Substrate preparation") or for touch-up painting (A< 0,15 m² each.) after sandpapering at the degree St3 according to ISO 8501/1 in coating systems to protect structures generally in Atmospheric Service Conditions.

Thanks to its rich zinc content (organic type), its corrosion protection function is highly performing on pipelines, wharfs, steel marine structures and all other constructions operating in areas exposed to severe conditions (cathodic protection). Important to avoid the coating application in critical conditions of humidity and temperature. The Substrate must always be duly prepared.

TECHNICAL DATA	Specific gravity:	Kg/l	2.2 ± 0,1 (A+B)
	Solids Content by weight:	%	81 ± 3 (A+B)
	Solids Content by volume:	%	53 ± 2 (A+B)
	Mixing ratio:		
	(by weight)		90 A + 10 B
	(by volume)		77 A + 23 B
	Pot-life at 20°C :		≥ 6 h
	Colour:		Zinc Grey
	Temperature Resistance (in air – dry conditions)		Continuous :+ 130 °C ; Occasional + 180°C

SUBSTRATE PREPARATION **Steel :** The surface must be cleaned to eliminate possible traces of dirt or salt residuals. The substrate must be free from all residuals of oils, grease and any contaminant .Abrasive Sandblasting is recommended at the degree SA 2.5 minimum according to ISO 8501-1(with medium roughness profile 40-70 µm. Rz DIN (cut-off 2,5 mm) or (for touch-up painting A< 0,15 m² each) sandpapering at the degree St3 – ISO 8501/1.

PRODUCT PREPARATION Mix Separately each component in the original can as supplied. Mix respecting the mixing ratio Base and Hardener agitating the mix for 5 minutes to reach complete homogenization. Then pour into the dedicated tank of the application equipment. Let the mix rest for 5 minutes before starting the application.

APPLICATION DATA	Application:	Brush, roller (ONLY touch-up painting), Conventional spray, airless
	Suggested humidity:	max. 85 %
	Thinner :	Epothinner
	Thinning :	0-10% with Epothinner, according to the application method.
	Tools cleaning :	Epothinner
	Drying at + 25°C:	Touch dry ≤120 min.; Through dry ≤ 24 h Recoat Interval : min. 24 h
	Application temperature:	Min. +8°C / max. +40°C
	Suggested product temperature :	+25°C /+30°C
	Substrate temperature :	from +5°C up to +40°C (always +3/+ 5°C above the dew point.)
	Relative humidity:	<85 %
	Typical film Thickness dft :	50 µm per coat (wet about 90/100 µm)- Min. 50 µm / Max 100 µm
	Theoretical spreading rate:	4,5 – 5,5 m ² /Kg at the thickness of 50 µm dry.

HANDLING STORAGE AND .SAFETY PRECAUTIONS

Handling	Use individual protection means: gloves glasses and mask
Storage :	Keep at min +5°C / max +40°C temperature in the original sealed cans Keep far from flames, sparks and heat sources.

Shelf-life 12 months in the original sealed can, duly stored.

Safety precautions Inflammable. Use only in a well ventilated place.
Refer to Material Safety Data Sheet.

Product for professional use only and exclusively for the uses not regulated under CE Directive 2004/42/CE.

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