

Epoxy 8930 ST

Solvent based surface tolerant epoxy primer

A two component, high solids, zinc phosphate pigmented, polyamide cured cross linked, surface tolerant, re-coatable epoxy primer.

Intended Uses:

Epoxy 8930 ST Primer is a general-purpose high build surface tolerant epoxy primer/finish for lower grade steel preparation. It provides excellent adhesion to steel, galvanized steel, and aged epoxy surfaces.

Remains easy re-coatable after prolonged exposure.

Epoxy 8930 ST has excellent corrosion protection properties in new construction and as an industrial maintenance primer in industrial and coastal atmospheres such as chemical, petrochemical, pulp and paper and bridge industries.

The fast drying and handling properties together with extended over-coatability make this an excellent primer for factory application prior to full coating system application on site. Epoxy 8930 ST has good abrasion resistance to help resist mechanical damage during transportation.

Excellent as an intermediate coat over inorganic zinc.

Properties:

- High solids coating.
- Good adhesion to multiple substrates such as steel, cast iron, galvanized steel, aluminium, GRP, stainless steel and aged epoxies.
- Can be over coated with various topcoat systems after extended* exposure.
- Tough and flexible.
- Can be used as an epoxy primer/finish in dry areas.
- Can be used in immersion conditions.
- Resistant to water and splashes of mild chemicals.
- Resistant to temperatures up to 200°C.

Technical Data:

Colour	Various
Finish	Smooth semi-gloss
Mix Ratio (Volume)	4 : 1
Activator	Epoxy Activator 8930 ST
Induction Period	Not required
Density	1.55 Kg/ Litre (mixed)
Volume Solids	83%
Typical Film Thickness	125 – 200µm DFT
Theoretical Coverage	6.64 m ² / Litre @ 125µm DFT, allow for loss factors
Method of Application	Brush, roller, or spray
Flash Point	18°C
Number of Coats	1 – 2 depending on specification

Drying Information:

	0°C	10°C	20°C	30°C	40°C	50°C
Touch Dry	-	-	6 hrs	-	-	-
Hard Dry	-	-	9 hrs	-	-	-
Full Cure	-	-	7 days	-	-	-
Overcoating Data – See Limitations (With Itself)						
Substrate Temp.	0°C	10°C	20°C	30°C	40°C	50°C
Minimum	-	20 hrs	9 hrs	5 hrs	3 hrs	-
Maximum	-	12 months	9 months	6 months	3 months	-
Overcoating Data – See Limitations (With Various Alkyds)						
Substrate Temp.	0°C	10°C	20°C	30°C	40°C	50°C
Minimum	-	24 hrs	16 hrs	8 hrs	5 hrs	-
Maximum	-	21 days	10 days	7 days	3 days	-
Overcoating Data – See Limitations (With Polyurethanes)						
Substrate Temp.	0°C	10°C	20°C	30°C	40°C	50°C
Minimum	-	48 hrs	24 hrs	12 hrs	6 hrs	-
Maximum	-	6 months	3 months	1 month	1 month	-
Overcoating Data – See Limitations (With Two Pack Epoxies)						
Substrate Temp.	0°C	10°C	20°C	30°C	40°C	50°C
Minimum	-	20 hrs	9 hrs	5 hrs	3 hrs	-
Maximum	-	6 months	3 months	1 month	1 month	-

Note:

*See Specialized Coating Systems Definitions and Abbreviations.

- Surface should be dry and free from any contamination.
- Best intercoat adhesion occurs when the subsequent coat is applied before the preceding coat is fully cured.
- If time has been exceeded, Specialized Coating Systems technical department should be contacted.

Surface Preparation:

The performance of this product will depend upon the degree of surface preparation. The surface to be coated must be cleaned and free from contamination. Prior to paint application all surfaces should be assessed and treated in accordance with ISO 8504:2000.

Accumulated dirt and soluble salts must be removed. Dry bristle brushing will normally be adequate for accumulated dirt. Soluble salts should be removed by freshwater rinsing. Oil or grease should be removed in accordance with SSPC-SP1 solvent cleaning.

Abrasive Blast Cleaning and Mechanical Preparation – Steel

All surfaces to be coated must be dry, clean, and free from chalking and contamination. This product should be applied to surfaces prepared by abrasive blast cleaning to SA 2½ in accordance with International Standard ISO 8501:2007 and SSPC-SP6. A blast profile of 40 – 70 microns is recommended.

Hand Preparation

Weld seams and damaged areas should be cleaned to St3 (ISO 8501-1:2007) or SSPC SP3. When using power tools care should be taken to avoid surface polishing. Optimal performance will be achieved with blasting, where this is not practical hand preparation to SSPC-SP11 is recommended.

Shop Primed Steel

If the shop primer shows extensive or widely scattered breakdown overall sweep blasting or hand preparation may be necessary.

Application:

Mixing	Material is supplied in two containers as a kit. Always mix a complete kit in the quantities supplied. Once mixed the product should be used within the pot life specified. Stir the base component well with a flat-bottomed paddle or mechanical mixer until product is uniform. Continue stirring and add the entire contents of the activator container. Continue stirring until the mixture is homogeneous. Transfer the mixed contents to a clean container and continue to mix with a clean mixer to avoid any contamination by unmixed material. Ensure that just enough material is mixed so that the product can be applied within its use-able life. The temperature of the mixed product should preferably be above 15°C.		
Pot Life	3 hours at 15°C 2 hours at 20°C 1 hours at 30°C 30 minutes at 40°C		
Thinner	SA65 Thinners	0 – 15% depending on application	
Airless Spray	Recommended	Tip range 19 – 23 Thou. Pressure at the tip should not be less than 150 bar (2200 PSI)	
Air Spray	Recommended	Gun	Pressure/Gravity Feed
		Fluid Tip	1.8mm to 2mm
Brush/Roller	Suitable (Typically, 40 – 50µm can be achieved)		
Work Stoppage	Thoroughly flush all equipment with SA65 Thinners . All unused material should be stored in tightly closed containers. Partially filled containers may show surface skinning and/or a viscosity increase of the material after storage. Material should be filtered, and viscosity re-adjusted before used.		
Clean Up	Clean all equipment immediately after use with SA65 Thinners . It is advisable to periodically flush out spraying equipment throughout the course of the working day. Frequency of cleaning is dependant of upon the amount sprayed, temperature and elapsed time, including delays.		

Environment:

	Surface Temperature	Ambient Temperature	Relative Humidity
Minimum	-10°C*	-12°C	No lower limit
Maximum	45°C	45°C	95%

* Or 3°C above dew point

Limitations:

- The maximum overcoating interval will be dependent upon the integrity of the exposed film. A film of 75 microns DFT will normally be Overcoat able after 6-12 months exposure (depending on the corrosivity of the environment) provided it is adequately cleaned and any areas of mechanical damage repaired.
- Over-application will extend both the minimum overcoating periods and handling times and may be detrimental to long term overcoating properties.
- In common with all epoxies, Epoxy 8930 ST Primer will chalk and discolour on exterior exposure. However, these phenomena are not detrimental to long term overcoating properties.
- Overcoating information is given for guidance only and is subject to local climate and environmental conditions. Consult a Specialized Coating Systems representative for specific recommendations.
- Test performance results were obtained in a controlled laboratory environment and Specialized Coating Systems makes no claim that the exhibited published test results, or any other tests, accurately represent

Industrial & Protective Steel & Concrete Protection - Climatic

Page 3 of 4

Whilst we endeavour to ensure that all advice we give about the product is correct, the information given in this data sheet is not intended to be exhaustive and any person using the product for any purpose other than that specifically recommended in this sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so entirely at his own risk. As conditions of use, method of application and suitability of the substrate prior to painting are beyond our control, no guarantee is implied by the recommendations contained herein. We therefore do not accept any liability whatsoever or howsoever arising from the performance of this product or for any loss or damage arising out of the use of this product. The information contained in this sheet is liable to modification from time to time in the light of experience and ongoing product development programmes. It is the user's responsibility to ensure that this sheet is current prior to using the product

Issue Date:
01/05/2019

results found in all field environments. As application, environmental and design factors can vary, due care should be exercised in the selection and verification of the performance and use of the coating.

Pack Size:

5 Litre.

Storage:

- Shelf Life: 12 months at 25°C from date of manufacture. Subject to inspection thereafter.
- Store in dry conditions out of direct sunlight, away from sources of heat or ignition.
- Store at temperatures between 5°C and 35°C.

Precautions:

For complete safety and handling information please refer to the appropriate Safety Data Sheets prior to using this product.