

Epoxy Multi Prime

Solvent based zinc phosphate epoxy primer

A two component, high build, polyamide cured, zinc phosphate pigmented, re-coatable epoxy primer.

Intended Uses:

Epoxy Multi Prime is a general-purpose high build epoxy primer for steel and concrete surfaces. It provides excellent adhesion to steel, galvanized steel, and aged epoxy surfaces.

Epoxy Multi Prime 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 structural steel fabrication.

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

Properties:

- Contains Zinc Phosphate to provide corrosion protection.
- 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.
- Cures at temperature down to +5°C.
- Can be used as an epoxy primer/finish in dry areas.

Technical Data:

Colour	Standard red oxide. Available in other colours upon request.
Finish	Smooth semi-matt
Mix Ratio (Volume)	4 : 1
Activator	Epoxy Activator Multi
Induction Period	Not required
Density	1.58 Kg/ Litre (For red oxide)
Volume Solids	63% (Red oxide)
Typical Film Thickness	75 – 150µm DFT
Theoretical Coverage	6.3 m ² / Litre @ 100µm DFT, allow for loss factors
Method of Application	Brush, roller, or spray
Flash Point	26°C
Temperature Resistance	Dry continuous – 150°C
Number of Coats	1 coat by brush or spray

Drying Information:

	0°C	5°C	10°C	20°C	30°C	40°C
Touch Dry	-	8 hrs	-	2 hrs	-	-
Hard Dry	-	18 hrs	12 hrs	6 hrs	4 hrs	3 hrs
Full Cure	-	-	15 days	7 days	3 days	2 days
Overcoating Data – See Limitations						
Substrate Temp.	0°C	5°C	10°C	20°C	30°C	40°C
Minimum	-	3 days	16 hrs	8 hrs	5 hrs	3 hrs
Maximum	No limitation provided that the surface is free from any contamination. Extended*					

Note:

* See Specialized Coating Systems Definitions & Abbreviations.

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 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 or alternatively mechanically abrade the surface using grinding or flapper discs to achieve a similar profile.

Shop Primed Steel

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.

If the shop primer shows extensive or widely scattered breakdown overall sweep blasting 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. Ensure that sufficient material be mixed so that the product can be applied within its use-able life.	
	The temperature of the mixed product should preferably be above 10°C.	
Pot Life	16 hours at 10°C 10 hours at 15°C 8 hours at 20°C 5 hours at 30°C 4 hours at 35°C	
Thinner	SA65 Thinners	0 – 20% depending on application

Airless Spray	Tip range 15 – 21 Thou. Pressure at the tip should not be less than 150 bar (2200 PSI) For dry paint & equipment.	
Air Spray	Gun	Pressure/Gravity Feed
	Fluid Tip	1.6mm to 1.8mm
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 good working practice to periodically flush out the spray equipment during the course of the working day. Frequency of cleaning will depend upon the amount sprayed, temperature and elapsed time, including delays	

Environment:

	Surface Temperature	Ambient Temperature	Relative Humidity
Minimum	5°C*	10°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 over-coatable 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 Multi Prime 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 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 & 20 Litre.

Storage:

- Shelf Life:
 - Part A: 24 months minimum at 25°C from date of manufacture. Subject to inspection thereafter.
 - Part B: 12 months minimum 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.

Precautions:

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