## **DESCRIPTION**

Two-component, polyamide-cured phenolic epoxy primer

## PRINCIPAL CHARACTERISTICS

- General-purpose epoxy primer/coating for atmospheric conditions
- Suitable for atmospheric exposure conditions
- EDF/ORANO (ex AREVA/COGEMA) and CEA-approved product
- PIA/PIB/PIC/PID qualified by EDF for use in nuclear power plants

## **COLOR AND GLOSS LEVEL**

- Light ochre
- Semi-gloss

# BASIC DATA AT 20°C (68°F)

Data for mixed product		
Number of components	Two	
Mass density	1.43 kg/l (11.93 lb/US gal)	
Volume solids	62 ± 2%	
VOC (Supplied)	Directive 2010/75/EU, SED: max. 278.0 g/kg max. 403.0 g/l (approx. 3.4 lb/US gal)	
Recommended dry film thickness	45 - 80 μm (1.8 - 3.1 mils) depending on system	
Theoretical spreading rate	13.8 m²/l for 45 µm (552 ft²/US gal for 1.8 mils) 7.8 m²/l for 80 µm (321 ft²/US gal for 3.1 mils)	
Dry to touch	2.5 hours	
Dry to handle	7 hours	
Overcoating Interval	Minimum: 7 hours Maximum: 12 months	
Shelf life	Base: at least 24 months when stored cool and dry Hardener: at least 24 months when stored cool and dry	

## Notes:

- See ADDITIONAL DATA Spreading rate and film thickness
- See ADDITIONAL DATA Overcoating intervals

## RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES

# **Substrate conditions**

- Steel; blast cleaned to ISO Sa 2% or SSPC-SP-10, blasting profile 50 –  $75~\mu m$  (2.0 – 3.0~mils)

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### Substrate temperature and application conditions

- Substrate temperature during application and curing should be above 5°C (41°F)
- Substrate temperature during application and curing should be at least 3°C (37°F) above dew point
- Relative humidity during application and curing should not exceed 80%
- Ambient temperature during application and curing should be between 5°C (41°F) and 35°C (95°F)

### **INSTRUCTIONS FOR USE**

## Mixing ratio by volume: base to hardener 82:18 (4.56:1)

- The temperature of the mixed base and hardener should be above 10°C (50°F), otherwise extra thinner may be required to obtain application viscosity
- · Adding too much thinner results in reduced sag resistance and slower cure
- · Thinner should be added after mixing the components

### **Induction time**

0 minute

### Note:

- No induction time required

## Pot life

8 hours at 20°C (68°F)

### Air spray

## **Recommended thinner**

THINNER 91-92 or DILUANT №1 Bis

# Volume of thinner

10 - 20%, depending on required thickness and application conditions

### **Nozzle orifice**

1.0 - 2.0 mm (approx. 0.040 - 0.079 in)

### Nozzle pressure

0.3 - 0.4 MPa (approx. 3 - 4 bar; 44 - 58 p.s.i.)

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## Airless spray

# **Recommended thinner**

THINNER 91-92 or DILUANT №1 Bis

# **Volume of thinner**

5 - 20%, depending on required thickness and application conditions

## **Nozzle orifice**

Approx. 0.43 - 0.53 mm (0.017 - 0.021 in)

## **Nozzle pressure**

20.0 - 25.0 MPa (approx. 200 - 250 bar; 2901 - 3626 p.s.i.)

## **Brush/roller**

· For stripe coating and spot repair only

### **Recommended thinner**

THINNER 91-92 or DILUANT №1 Bis

# **Volume of thinner**

0 - 5%

# **Cleaning solvent**

• THINNER 91-92 or DILUANT №1 Bis

## **ADDITIONAL DATA**

Spreading rate and film thickness		
DFT	Theoretical spreading rate	
45 μm (1.8 mils)	13.8 m²/l (552 ft²/US gal)	
80 μm (3.1 mils)	7.8 m <sup>2</sup> /l (321 ft <sup>2</sup> /US gal)	

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Overcoating interval for DFT up to 40 µm (1.6 mils)			
Overcoating with	Interval	20°C (68°F)	
itself	Minimum	7 hours	
	Maximum	12 months	
CENTRIFUGON EAP EVO	Minimum	7 hours	
	Maximum	12 months	
HYDROCENTRIFUGON PEINTURE NF	Minimum	7 hours	
	Maximum	12 months	

#### Note:

- Surface should be dry and free from any contamination

### **SAFETY PRECAUTIONS**

- This is a solvent-borne paint and care should be taken to avoid inhalation of spray mist or vapor, as well as contact between the wet paint and exposed skin or eyes
- See Safety Data Sheet and product label for complete safety and precaution requirements

### **WORLDWIDE AVAILABILITY**

It is always the aim of PPG Protective & Marine Coatings to supply the same product on a worldwide basis. However, slight modification of the product is sometimes necessary to comply with local or national rules/circumstances. Under these circumstances an alternative product data sheet is used.

### **REFERENCES**

• Information sheet | Explanation of product data sheets

## **WARRANTY**

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