

CODE: EP-206-1

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PRODUCT NAME:

Zinc phosphate Polyamide Cured Epoxy Primer

DESCRIPTION:

EP-206-1 is a Special two component zinc Epoxy primer with excellent adhesion and anti-corrosive property for structural steel, machinery, pipes and tank exteriors in paper mills, oil refineries, power plants, chemical process and waste treatment plants as well as decks, superstructures of ships, barges and workboats.

The fast drying and handling properties, together with extended overcoat ability; make this an excellent primer for factory application prior to full system application on site.

With the proper topcoats, forms durable coating systems, withstands splash or spillage of water, solvents, chemicals and petroleum products. Suitable topcoats are epoxies, coal tar epoxies, acrylics, alkyds and polyurethanes.

EP- 206-1 may be used as a primer at 100 microns dry film thickness for up to 6 months without a topcoat. It is also suitable for drinking water tanks and pipes.

TECHNICAL DATA:

Binder	Epoxy resin
Pigment	Zinc phosphate
Finish (ASTM D 523)	Flat
Shade	Pink ,Grey ,White ,Beige ,Red, Green
Specific gravity after mixing (ASTM D 1475)	1.3 ± 0.1 Kg/Lit
Volume solids (ASTM D 2697)	55 ± 3%
Flash point	33 °C
Typical dry film thickness (ASTM D 1186)	30-75 Microns per one coat
Number of coat	One
Mixing ratio by weight	Base : 100 parts Hardener : 16 parts
Substrate	Blasted steel, Aluminum , galvanized surfaces, and Stainless steel
Application method (FED.ST 141(method4331))	Conventional or airless spray , brush , roller
Thinner / Cleaner	T-200
Weight of added thinner	5-15%
Temperature resistance	Up to 120°c
Induction time at 25 °C	20-30 minutes
Theoretical spreading rate (at 30 microns) (ASTM D 344)	18.3 M ² /Lit
Packing	Base : 25 kg (EP-206-1) Hardener : 4 kg (EP-206-1H)

***Note:** It is dependent on storage temperature and reduces at storage temperature above 20° C. Do not store above 40 °C. Shelf life is exceeded if the liquid is gelled or if the mixed product forms gels before application.

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Drying Time (ASTM D 1640)

Touch dry	Hard dry	Over coating		Full cure
		Min	Max	
hours 2-3	16-24 hours	16-24 hours	30 days	7 days

Note: Drying times are dependent on applied film thickness; all data in this catalogue are reported at recommended DFT.

Above Specification Is Based On Mixture Of The Two Components.

(23 ± 3 °C And , 30 ± 5 % RH.)

Pot life (ASTM D 1849)

Temp. of paint	15± 3°C	23± 3°C	40± 3°C
Pot life	9-12 hours	5-8 hours	2-3 hours

Surface Preparation

All surfaces to be coated should be clean, dry and free from contamination. Prior to paint application all surfaces should be assessed and treated in accordance with ISO 8504:1992.

Where necessary, remove weld spatter, and where required smooth seams and sharp edges. Oil or grease should be removed in accordance with SSPC-SP1 solvent cleaning

Abrasive Blast Cleaning

Abrasive blast clean to Sa2½ (ISO 8501-1:1988) or SSPC-SP10 .If oxidation has occurred between blasting and application of EP-206-1, the surface should be reblasted to the specified visual standard.

Surface defects revealed by the blast cleaning process, should be ground, filled, or treated in the appropriate manner.

A surface profile of 40-70 microns is recommended.

Shop primed Steelwork

EP-206-1 is suitable for application to steelwork freshly coated with zinc silicate shop primers.

If the shop primer show extensive or widely scattered breakdown, or excessive zinc corrosion products, overall sweep blasting will be necessary. Other types of shop primer are not suitable for overcoating and will require complete removal by abrasive blast cleaning.

Weld seams and damaged areas should be cleaned to SA 2 ½(ISO 8501-1:1988) or SSPC-SP10.

Surface preparation shall not take place in following conditions:

- 1-At temperature below 5 °C.
- 2-When the relative humidity greater than 85%.
- 3-When the metal surface temperature is less than 3 °C above the dew point.
- 4- Out side day light hours on exterior locations.

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Application Method

Material is supplied in two containers as a unit. Always mix a complete unit in the proportion supplied. Once the unit has been mixed it must be used within the working Pot life specified.

1-Agitate part A with a power agitator.

2-Combined entire contents of curing agent (part B) With Base (Part A) and mix thoroughly with power agitator.

-Stir during application to maintain uniformity of material

Application Equipments

Air less Spray	Tip range 0.015-0.021 inch tip not less than 176 Bar (2500 psi)	Total output pressure at spray
Air Spray	Nozzle Orifice:1.8-2.2mm Nozzle Pressure:3-5 Bar (43-72 psi)	
Brush	Typically 50 mic can be achieved.	
Roller	Typically 50 mic can be achieved.	

Flush Equipment with recommended Cleaner before and after use

ENVIRONMENTAL CONDITIONS:

- To prevent moisture condensation during application, surface temperature must be at least 3 °C above the dew point.

- Never apply coatings under reverse environmental condition.

- In hot climate, material temperature should be 20 to 25 °C prior to mixing; otherwise pot life becomes very short.

- For satisfactory cure, air and surface temperature must be above 10 °C

- Paint shall not be applied when wind speed is in excess of 7 m/s

Air temperature	10 to 40 °C
Surface temperature	10 to 50 °C
Material temperature	10 to 30 °C
Relative humidity	Max80 %

Health and Safety:

This product is Flammable. Keep away from heat and open flame .Keep container closed .Use with adequate ventilation. Avoid prolonged and repeated contact with skin. If used in confined areas, observe the following precautions to prevent hazards of fire or explosion or damage to the health:

1-Circulate adequate fresh air continuously during application and drying.

2-Use fresh air masks and explosion proof equipment.

3- Prohibit all flames, sparks, welding and smoking.

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