

EPOXY ZINC PHOSPHATE PRIMER

FOSTITE#5000-HB

1. DESCRIPTION

A high build coating two component paint, based on polyamide cured epoxy resins, pigmented with inert pigments.

The cured film is excellent in anti-corrosion, adhesion, oil resistance, chemical Resistance and other physical properties.

It can be used for interior of freight container as primer and topcoat.

It has excellent adhesion to galvanized steel and zinc rich primer.

2. USES

It is publicly admitted that epoxy resins exceed in anti-corrodibility adherence and chemical resistance, as a result of which its use is now increasing in various fields, such as plant equipment, vessels, oceanic development, various types of tanks etc.

3. PHYSICAL CONSTANTS

1) Color and gloss	: All color-semi gloss
2) Solid by volume	: 50 ± 2 %
Solid by weight	: 70 ± 2 %
3) Specific gravity	: 1.4 ± 0.1 (kg/l)
4) Theoretical spreading rate	: 12.75 m ² /l - 40μm
5) VOC	: 426 g/l - 3.6 lbf/gal

	10℃	20℃	30℃
Dry to touch	13 M	8 M	4 M
Dry hard	6 H	5 H	3 H

*Note : H (Hours), M (Minutes)

4. APPLICATION DETAILS

1) Mixing ratio	: Base to hardener 85 : 15 (by weight)
	: Base to hardener 4 : 1 (by volume)
2) Thinning ratio	: 10~30% (volume) airless spray
3) Thinner No.	: Thinner 600
4) Pot life	: 18 hours (at 20℃/ 68 °F)
5) Nozzle orifice	: 0.017 ~0.021 inch
Nozzle pressure	: 150 bar/2100 PSI

V.1A

* These information are based on laboratory testing and practical experience.
These data are believed to be reliable and accurate, however without any obligation.

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6) Film Thickness

Recommended per coat 30 ~ 75 microns dry

May be specified in another film thickness than indicated depending on purpose and areas of use.

5. SURFACE PREPATATION

- 1) New Steel : Abrasive blasting to SIS Sa 2^{1/2} (SSPC-SP-10) For temporary protection, if required, use a suitable shop primer. All damage of shop primer and contamination from storage and fabrication should be thoroughly cleaned prior to final coating. For repair and touch-up use Fostite#5000 paint.
- 2) Repair and maintenance : Remove oil and grease, etc. with suitable detergent. Remove salt and other contaminants by high pressure fresh water cleaning. Clean damaged areas thoroughly by power tool cleaning to SIS Sa 2^{1/2} Improved surface preparation will improve the performance of Fostite#5000

6. PAINT PREPERATION

Before mixing with the curing agent stir the base thoroughly in order to disperse any possible settling after storage. After mixing it is equally important to maintain stirring to keep the paint as a homogeneous mixture. This is specifically important in case of a high level of thinning and long break in application where the risk of settlement of zinc particles is the highest

- 1) Stir to be mixed uniformly before use.
- 2) Keep correct mixing ratio.
- 3) Mixed paint should be used within pot life.

7. RECOATING INTERVAL

Clean the surface thoroughly before recoating.

- 1) Minimum : 20 minutes' flash-Off time for micron (1.6mils)
Fostite#5000 when to coated with designed container coating, epoxy polyurethane, Acrylic or chlorinated rubber types.
- 2) Maximum : Recoating interval for no-immersion services is 24 hours for acrylic or chlorinated rubber, 3days for polyurethane and none for epoxies.
In the case of long recoating intervals, a completely clean surface is mandatory to ensure inter coat adhesion.

8. CHEMICAL RESISTANCE

	Acids	Alkalis	Solvents	Salts	Water
Splash & Spillage	Fair	Excellent	Good	Excellent	Excellent
Fumes	Very Good	Excellent	Very Good	Excellent	Excellent

V.1A

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Any dirt, oil and grease to be removed with suitable detergent followed by high pressure fresh water cleaning, salts to be removed by fresh water hosing. Any degraded surface layer, as a result of a long exposure period, must be removed as well. In addition, scrubbing with a stiff brush may be necessary to remove zinc corrosion products(white rust)

9. APPLICATION CONDITIONS

Avoid coating under low temperature and high humidity, because it may result in poor curing.

Apply only on a dry and clean surface with a temperature above 5 °C / 41°F.

The surface must be dried and should keep temperature above the dew point.

In a confined area, sufficient ventilation is necessary during application and drying to assist evaporation of solvent.

10. STORAGE

- 1) Shelf temperature : -10°C ~ 40°C
- 2) Shelf life : 12 months (at 20°C / 68 °F)
- 3) Flash point : 26 °C / 79 °F (closed cup)

11. PRECAUTION

This product is combustible.

- 1) Keep away from heat and open flame.
- 2) Keep container closed.
- 3) Use with adequate ventilation.
- 4) Avoid prolonged breathing of vapor.
- 5) Avoid prolonged and repeated contact with skin.
- 6) Store in a cool and dark place.