



## DESCRIPTION

This is a two-component epoxy anti-corrosion primer, specifically formulated to be applied directly on sanded bare metal surfaces as the initial coat. The product boasts excellent adhesion, abrasion resistance, and hardness, alongside outstanding anti-corrosion properties. It is commonly utilized for safeguarding steel structures, machinery, and various metal substrates. Additionally, it is effective for repairing electrophoretic coatings.

## FEATURES

- ▶ Exceptional adhesion
- ▶ Remarkable anti-corrosion properties
- ▶ Superior hardness
- ▶ Surface tolerant

## COMPOSITION

- ▶ Epoxy Resin
- ▶ Micaceous iron oxide

## SPECIFICATION DATA

**Color:** Gray

**Finish:** Flat

**Clean up solvent:** Xylene

**Solids:** Volume: 48%

**Flash Point (°C):** 40±3

**VOC Emission (g/L):** ≤420

**Application Temperature:** 5°C–40°C

**Dry Time:** 77° F (25°C ) &75% RH:

To touch – 15 minutes. To recoat – 2 hours

### Recommended film thickness and coverage

Film Thickness	Dry Film Thickness (µm)	Wet Film Thickness (µm)	Theoretical Coverage (m <sup>2</sup> /L)
Minimum	40	80	12.5
Maximum	80	160	6.3
Typical	60	120	8.3

### Potlife after mixing

Ambient Temperature	Hardener Type	Thinner Type	Pot Life
5°C	Fast-drying	Fast-drying	8 hours
15°C	Fast-drying	Fast-drying	6 hours
23°C	Standard	Standard	5 hours
40°C	Standard	Standard	2.5 hours



## SURFACE PREPARATION

### NEW STEEL SURFACES

Ensure the substrate is clean, dry, and free from contaminants such as oil, dust, rust, and mill scale to achieve optimal adhesion. Use degreasers, high-pressure fresh water for cleaning, and sandblast to Sa2.5 grade. For temporary protection, apply shop primer if needed. Before final coating, manually sandblast to clean damaged areas, welds, or contaminants, and repair with this product.

### Refurbishment and Maintenance

Clean oil and grease using suitable cleaning agents. Remove salts and other contaminants with high-pressure fresh water. Use power tools to clean damaged areas to St3 level (localized repair) or sandblast to Sa2 level.

## DIRECTIONS FOR USE

## RECOMMENDED TOPCOATS

Application Method	Thinning Ratio	Nozzle Size (mm)	Spraying Pressure (MPa)	Spraying Distance (cm)
Airless Spraying	0-10%	0.42-0.53	15-20	40-50
Air Spraying	15-25%	1.5-2.0	0.3-0.5	30-40
Brushing/Rolling	0-5%	N/A	N/A	N/A

Acrylic PolyUrethane Topcoat

Aliphatic PolyUrethane Topcoat

Fluorocarbon Topcoat

## SHIPPING

**Freight Classification:**  
Combustible

**Packaging:** 1 gallon (3.785L)  
5 gallon (18.925L)

**Flash Point (°C):** 40±2

## LIMITATIONS OF LIABILITY

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