

PRODUCT DATA SHEET

HDPRIME 902



Description: This is a two component polyamide cured epoxy coating. It has a semi glossy finish. To be used as topcoat in atmospheric and immersed environments.

Recommended use: Recommended for application on suitably primed steel structures exposed to industrial environment of paper, fertilizers, Pharmaceutical industries etc.

Service temperatures: Maximum, dry exposure only: 120°C

Physical Properties :

Colours/shade Nos.:	White*
Finish:	Semi Glossy
Volume solids, %:	40 %
Theoretical spreading rate:	8 m ² /litre, 50 micron
Flash point:	25°C
Specific gravity:	1.22 kg/litre
Surface-dry:	3 Hours at 30°C
Dry to Handle:	8 Hours at 30°C
VOC content:	550 g/litre

Application details:

Version, mixed product

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Mixing ratio:	HDPRIME 902 BASE: HDPRIME 902 Curing Agent 4 : 1 by volume		
Application method:	Airless spray	Air Spray	Brush
Thinner (max.vol.):	HDPRIME Thin (5%)	HDPRIME Thin (15%)	HDPRIME Thin (5%)
Pot life:	5-6 hours at 30°C		
Nozzle orific	.018"-.025"		
Nozzle pressure:	250 bar [3625 psi] <i>(Airless spray data are indicative and subject to adjustment)</i>		
Indicated film thickness, dry:	40 - 60 Micron		
Indicated film thickness, wet:	100-150 Micron		
Overcoat interval, min:	According to Specification		
Overcoat interval, max:	According to Specification		

Safety: Handle with care. Wear Necessary PPEs like safety shoes, gloves, goggles.

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Surface preparation:	Remove oil, grease and other contaminants by suitable detergent cleaning. Remove salts, detergents and other contaminants by high pressure fresh water cleaning. All damage of shop primer and contamination from storage and fabrication should be thoroughly mechanically/chemically cleaned prior to final painting. New build: When used as an intermediate or finishing coat please refer to the data sheet for the preceding primer
Application conditions:	To avoid condensation, apply on a clean and dry surface with a temperature that is at least 3°C [5°F] above the dew point. Surface temperature must be above -10°C [14°F] during application and curing. Temperature of product must be above 15°C [59°F] during application. Relative Humidity: Relative humidity must be below 85% during application. Relative humidity must be below 85% during curing. To obtain the drying time stated, it is important to maintain sufficient ventilation during application, drying and curing.
Previous Coat:	None
Subsequent Coat:	None or HD TOPCOAT
Remarks/Notes:	
Film thicknesses/thinning: (optional)	May be specified in another film thickness than indicated depending on purpose and area of use This will alter spreading rate and may influence drying time and recoating interval. Normal range dry is: 30 - 60 micron. Avoid application of excessive film thickness.
Overcoating note: (optional)	If the maximum over coating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion. The surface must be clean before over coating.

Note: **HDPRIME 902 is for professional use only.**

This Product Data Sheet supersedes those previously issued.

Data, specifications, directions and recommendations given in this data sheet represent only test results or experience obtained under controlled or specially defined circumstances. Their accuracy, completeness or appropriateness under the actual conditions of any intended use of the Products herein must be determined exclusively by the Buyer and/or User.

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