

PRODUCT DATA SHEET

HD ZR PRIMER 281



Description: A two component, high performance epoxy metallic zinc rich primer specially formulated for excellent corrosion resistance for high performance system. It contains 90% zinc on dry film.

Recommended use: A high performance zinc rich anti-corrosive primer for protection of steel in aggressive environment such as onshore and offshore structures, platforms, pipelines, refineries, petrochemical plants and bridges. Fast curing with rapid handling features with outstanding anti-corrosive performance. Maintenance and repair coating for inorganic zinc rich coatings. Long term re-coating properties. Dry heat resistance up to 150°C. In compliance with SSPC-Paint 20, type 2, level 2 and ISO 12944-5

Service temperatures: Maximum, dry exposure only: 160°C/320°F

Physical Properties :

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| Colours/shade Nos.: | Grey* |
| Finish: | Flat |
| Volume solids, %: | 65 ± 1 |
| Theoretical spreading rate: | 13m ² /litre, 50 micron/2 mils |
| Flash point: | 26°C [78.8°F] |
| Specific gravity: | 2.7 kg/litre |
| Surface-dry: | 30 minutes at 20°C |
| Touch-dry: | 1 hours at 20°C |
| Full Cure: | 7 days at 20°C |
| VOC content: | 345 g/litre |

Application details:

Version, mixed product

HD Zinc Rich Primer 281

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| Mixing ratio: | BASE : Curing Agent 8.5 : 1.5 by volume |
| Application method: | Airless spray /Air spray/Brush/Flow coating |
| Thinner (max.vol.): | Epoxy Thin (5%) / Epoxy Thin (15%) / Epoxy Thin (5%) |
| Pot life: | 2-3 hours at 30°C |
| Nozzle orifice: | .017"-.021" |
| Nozzle pressure: | 150 bar [2200 psi] <i>(Airless spray data are indicative and subject to adjustment)</i> |
| Indicated film thickness, dry: | 50 micron/2 mils <i>(see REMARKS overleaf)</i> |
| Indicated film thickness, wet: | 75 micron/3 mils |
| 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: | <p>New steel: Abrasive blasting to Sa 2½ (ISO 8501-1:1988). 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 painting.</p> <p>Other metals and light alloys: Thorough degreasing and (light) abrasive sweeping to remove contamination and to secure adhesion - surface profile depending on later exposure.</p> <p>Repair and maintenance: Remove oil and grease etc. thoroughly with suitable detergent. Remove salts and other contaminants by high pressure fresh water cleaning. Clean damaged areas thoroughly by power tool cleaning to St 3 (spot-repairs) or by abrasive blasting to min. Sa 2, preferably to Sa 2½(ISO 8501-1:1988). Improved surface preparation will improve the performance. As an alternative to dry cleaning, water jetting to min. WJ-3, preferably WJ-2 (NACE No. 5/SSPC-SP 12), may be used.</p> |
| Application conditions: | <p>Use only where application and curing can proceed at temperatures above: 15°C/59°F. Before exposure to outside temperatures below 15°C/59°F within the first day after application the coating must have been forced dried at minimum 15 minutes.</p> <p>The temperature of paint itself should be 15°C/59°F or above. Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. In confined spaces provide adequate ventilation during application and drying.</p> |
| Preceding coat: | According to specification. |
| Subsequent coat: | According to specification. |
| Stirring: | <p>Before mixing with the curing agent stir the base thoroughly in order to re disperse any possible settling after storage. After mixing it is equally important to maintain stirring to keep the wet paint as a homogeneous mixture.</p> <p>This is specifically important in case of a high level of thinning and/or long break in application, where the risk of settlement of zinc particles is the highest.</p> |
| Film thicknesses/thinning: (optional) | <p>Before recoating after exposure in contaminated environment, May be specified in another film thickness than indicated depending on purpose and area of use. Most typical range is 40-50 micron/1.6-2 mils, but thicknesses down to 15 micron/0.6 mils (extra thinning) and up to 80 micron/3.2 mils may be possible. This will alter spreading rate and may influence amount of thinning necessary, drying time, and recoating interval.</p> <p>(The dry film thickness range does not take into account the correction factors for rough surfaces as listed in ISO 19840).</p> |
| Safety Precaution: | <p>This product is intended for use only by professional applicators in industrial situations in accordance with the advice given on this sheet, the Material Safety Data Sheet and the container(s), and should not be used without reference to the Material Safety Data Sheet (MSDS) which Unilay Coatings has provided to its customers.</p> <p>All work involving the application and use of this product should be performed in compliance with all relevant national, Health, Safety & Environmental standards and regulations.</p> <p>In the event welding or flame cutting is performed on metal coated with this product, dust and fumes will be emitted which will require the use of appropriate personal protective equipment and adequate local exhaust ventilation.</p> |

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.

The Manufacturer and Seller disclaim, and Buyer and/or User waive all claims involving, any liability, including but not limited to negligence, except as expressed in said general conditions for all results, injury or direct or consequential losses or damages arising from the use of the Products as recommended above, on the overleaf or otherwise. Product data are subject to change without notice and become void five years from the date of issue.