

2K ASIAN EPOXY PRIMER / APCODUR 1090



PRODUCT DESCRIPTION

Two pack, epoxy polyamide, zinc phosphate /zinc chrome primer

FEATURES & RECOMMENDED USE

- Recommended as a primer for protection of steel, galvanized steel in moderately to severely corrosive environment
- Good corrosion resistance
- Good adhesion on steel, galvanized steel and aged epoxy coatings

TECHNICAL DATA

Colour	Yellow Buff , Grey
Gloss	Matt
Volume Solids	Approx. 45 ± 5%
Recommended DFT / Coat	40 - 50 µm
Theoretical Coverage Capacity	10.0 sq mtr / ltr @ 40 µm 8.0 sq.mtr/ ltr @ 50 µm
Drying Time at 30°C	Surface dry : 15-20 minutes Hard dry : Overnight
Force drying schedule	70°C / 30 minute (EMT)
Overcoating interval at 30°C	Suitable for Wet on wet application or minimum 16 hrs.

The data given is for guideline only. The physical values are subject to normal manufacturing tolerances, colour and testing variances
 The volume solids indicated are as per ASTM D 2697 air drying method
 The actual drying time/ overcoat interval may be shorter or longer, depending on film thickness, ventilation, humidity, temperature etc.
 The information provided above is at 30° C and 65% relative humidity

DIRECTION FOR USE

Surface Preparation

General

- Surfaces must be dry, clean and free from contaminants
- Ensure removal of dirt, dust, oil and all other contaminants that could interfere with adhesion of the coating. Oil and grease should be removed as per SSPC-SP1 solvent cleaning
- Surface should be checked and treated in accordance with ISO 8504 prior to priming

Blast Cleaning

- Steel, abrasive blast clean to min. Sa 2.5 Swedish specification. In case oxidation has occurred between blasting and application of 2K Asian Epoxy Primer, the surface should be re-blasted
- A blasting profile of (Rz) 20 - 30 µm is recommended

Application Conditions

- Substrate temperature should be at least 3°C above dew point but not above 50°C
- Relative humidity should be below 85%
- Good ventilation is required in confined areas to ensure proper curing

Mixing

- 2K Asian Epoxy Primer / Apcodur 1090 is supplied in two packs. Stir the base and hardener separately. If settling is observed in the base, loosen the settled material with the help of hand stirrer followed by power driven stirrer for quick homogenous mixing
- Mix hardener gradually into the base under continuous stirring as per the mixing ratio. Once the unit has been mixed, it should be consumed within the working pot life. In case of part mixing (which should be avoided), close the lids of containers tightly to avoid contact with atmospheric moisture
- Thinner should be added after mixing the components and post the induction time. Addition of excessive thinner will lead to reduced sag resistance

Mixing Ratio (by volume)	Base : Hardener 3 : 1
Induction Time	15 minutes
Pot Life at 30°C	Min. 4 hours

Application

Air Spray	
Recommended thinner	T 391
Volume of thinner	5 - 10%
Nozzle Orifice	1.5 - 3.00 mm
Nozzle Pressure	0.3 - 0.4 MPa (approx 3-4 atm; 43-57 p.s.i.)
Cleaning Thinner	T 391

Cleaning

- Do not allow the product to remain in hoses, gun or spray equipment. Clean all equipment's immediately after use with T 391. It is recommended to periodically flush out spray equipment during the course of the working day. The frequency of cleaning will depend on amount sprayed, temperature and time gap
- All surplus material and empty containers should be disposed off in accordance with appropriate regional legislation

Product Characteristics

- The sheen and finish are dependent on the application method. The best finish is achieved by conventional spray application
- 2K Asian epoxy primer / Apcodur 1090 must be thinned with the recommended thinner only. Usage of alternate thinners will affect the drying and curing process
- The maximum performance is achieved after complete curing
- A minimum of two coats application is recommended over prepared
- As common to all epoxy, the product will chalk and discolour on exterior exposure. However these phenomenon are not detrimental to anti-corrosive performance
- For system recommendation or any specific query, please consult Asian Paints PPG technical representative

PACK SIZE	20 L (Base : 15 L & Hardener : 5 L)
STORAGE	Shelf Life: At least 12 months at 30°C for original unopened pack, subject to inspection thereafter Store in a cool, dry place and in accordance with local regulations
REGULATORY INFORMATION	Flash point: Base : Not less than 27°C, Hardener : Not less than 27°C VOC: Approx. 510± 50 gm/ ltr (depending on shades) as per USA-EPA Method 24 Product Weight: Approx. 1.24 ± 0.05 kg / ltr (depending on shades)

SAFETY INFORMATION

- As a general safety measure, inhalation of solvent vapours or paint mist and contact of liquid paint with skin & eyes, should be avoided. Forced ventilation should be provided when applying paint in confined spaces or stagnant air. Even when ventilation is provided, respiratory, skin and eye protection are always recommended when spraying paint
- Please refer our Material Safety Data Sheet prior to using the product

Disclaimer: To the best of our knowledge the information provided herein are true and accurate at the date of issuance. Since we have no control over the quality or condition of the substrate or the various factors affecting the use and application of the product, we do not accept any responsibility or liability arising out of use of the product. The company reserves the right to modify data contained herein without prior notice. Any change in data would normally be followed by issue of a new data-sheet. The user should check with the nearest sales office of the company and confirm the validity of the information, prior to using the product.

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Head Office: Asian Paints PPG Private Limited, Plot No-5, Gaiwadi Industrial Estate, S.V. Road, Goregaon (W), Mumbai 400 062

Tel No: 022 6218 2700, **CIN:** U24110MH2011PTC220557, **Email:** customercare.apppg@asianpaintsppg.com, **Website:** www.asianpaintsppg.com