

**Zepoxy Epo Iron Primer** is a Red-Oxide and Zinc-based epoxy primer designed for Iron-based substrates for subsequent protection from rusting. It has a high adhesive, mechanical and abrasive strength which ensures its corrosion protection properties even in rough and tough use conditions

## TECHNICAL DATA

Property	Test Method	Result
Appearance Part A	Visual	Low viscosity, red liquid
Appearance Part B	Visual	Low viscosity, yellow to brown liquid
Mix ratio (Part A : Part B)	Theoretical	100 : 16
Mix viscosity @ 25°C	ASTM D 2196	250 – 500 cPs
Solid Content	-	65 – 67 %
Flash Point	ASTM D 93	>14°C
Pot life (300g mix) @ 30°C	-	>1 hour
Coverage per kg material	-	80sq.ft, 30-50 microns thickness
Hardening time	-	24 hours
Full Cure	-	7 days

**Note:** • At 40°C pot life will halve so application should be planned accordingly.

## GENERAL INFORMATION

## SUBSTRATE PREPARATION

The surface of the substrate must be clean and dry. Remove all dirt, grease and foreign material by cleaning with suitable solvent, sand blasting, mechanical abrasion, or acid etching.

## MIXING

In order to obtain good results, resin should be pre-mixed and then the hardener should be added. Thorough mixing of the ingredients is essential. Usually the resin and hardener are mixed in small quantities to extend the working time and prevent high exothermic reaction and pre-gelling.

## APPLICATION

To ensure good adhesion between the substrates, it is recommended to apply rich layer of homogeneous blend uniformly on the surface and fill the dents and pinholes. Adequate curing normally takes place within 24 hours, post curing at temperatures more than 40°C is recommended.

## CLEANING AND MAINTENANCE OF EQUIPMENT

Tools and equipment used during the process are best cleaned immediately after use since removal of cured resin is difficult and time consuming. It is recommended that the bulk of the resin be removed using a scrapper and the remainder washed away using solvents such as toluene, xylene or acetone.

## PACKAGING

Zepoxy Epo Iron Primer is available as follows:

- 11.6 KG Set

## HEALTH AND SAFETY

Please dispose off containers of the materials as per local laws, rules and regulations. Usage of gloves, safety masks and other safety apparel as per health and safety laws should be done. Especially wear a respirator when sanding cured resin, and if you use alcohol inks DO NOT use a flame to remove bubbles, as alcohol is flammable. For further assistance, please refer to the MSDS of the product for further health and safety information.