

**PRODUCT DESCRIPTION**

A two pack epoxy polyamide anti-corrosive shop primer containing chromate-free rust inhibitive pigments specially formulated for easy application and speed of handling.

- Welding Fume Certificate from North of England Industrial Health Service.
- Fast drying allowing quick and easy handling of coated steel.
- Compatible with impressed current cathodic protection.
- BS 5493 reference. Meets performance of AP 1A.

**DESIGNED USE**

- Prefabrication or post fabrication blast primer for onshore and offshore.
- Can be used on steelwork for immersed or non-immersed conditions.
- Suitable as blast primer for upto C5 Environment as per ISO12944 Part 2 along with suitable intermediate and topcoats

**PHYSICAL DATA**

<b>VOLUME SOLIDS</b> (Based on ASTM D2697)	33 % $\pm$ 2 %
<b>TYPICAL DRY FILM THICKNESS</b>	25 microns
<b>WET FILM THICKNESS</b>	75 microns
<b>THEORETICAL COVERAGE</b>	13.2 m <sup>2</sup> /litre @ 25 microns DFT
<b>VOC "As Supplied"</b> (Based on ASTM D3960)	583 gms/ltr
<b>COLOUR</b>	Red Oxide
<b>FINISH</b>	Slight Sheen

**APPLICATION DETAILS**
**METHOD OF APPLICATION :**
**AIRLESS SPRAY**

This is the recommended method of application:  
Maximum 5% Thinner may be added.  
Tip Size: 0.38 - 0.43 mm (0.015 - 0.017 in)  
Pressure: 110 - 160 kg/cm<sup>2</sup> (1600 - 2300 psi)

**CONVENTIONAL SPRAY**

This is also a suitable method of application.  
Maximum 20% Thinner may be added  
Tip Size: 1.80 - 2.20 mm (0.071 - 0.087 in)  
Pressure: 2.75 - 3.45 kg/cm<sup>2</sup> (40 - 50 psi)

**BRUSH OR ROLLER**

May be used for difficult shapes or touch-up.  
However, additional coats may be required to achieve the recommended film thickness.

**DRYING TIME:**

Surface Temperature	Touch Dry	Hard Dry	Re coating Interval		Pot Life
			Minimum	Maximum	
15°C	8 mins	40 mins	5 Hrs	Indefinite	24 Hrs
25°C	5 mins	30 mins	3 Hrs	Indefinite	12 Hrs
35°C	3 mins	20 mins	2 Hrs	Indefinite	6 Hrs
45°C	2 mins	15 mins	1 Hr	Indefinite	3 Hrs

**NO. OF COMPONENTS** Two

**Mixing Ratio** 3 parts Base to 1 part Hardener (by volume)

**Application Conditions** Do not apply this product if the Relative Humidity exceeds 85% or if the substrate temperature is within 3°C of the dew point

**ADDITIONAL INFORMATION**

Thinner / Cleaning solvent	Solvalux 7-45
Storage Instruction	Store in a cool shaded dry area
Flash Point	Mixed 15°C
Packaging	5 liters & 20 liters
Shelf Life	12 months from the date of manufacture.

**SURFACE  
PREPARATION**

- Remove all wax, oil and grease by solvent cleaning in accordance with the guidelines given by SSPC-SPI.
- Where necessary remove weld spatter and round off all rough weld seams and sharp edges to a smooth surface.
- Abrasive blast clean to a minimum standard of Sa 2 ½ Swedish Standard SIS 05 59 00 or ISO 8501-1 : 1988.
- Any surface defects revealed by blast cleaning should be ground, filled or treated in a suitable manner.
- An average surface profile of 25 microns is acceptable, but this average should not exceed 40 microns.
- After blasting, remove dust from the surface.
- The surface to be coated must also be clean and dry.

**PRODUCT USE  
RESTRICTIONS**

- This product contains low flash solvents - do not use inside a tank or in poorly ventilated areas
- The product will not cure in temperatures below 10°C.
- Dry heat resistant up to 120°C
- As common with all Epoxy products, this product also will tend to discolour and chalk on exposure to direct sunlight
- May also be applied between 20 and 50 Microns DFT
- Contact Berger Representative for suggesting suitable paint system

**SAFETY  
PRECAUTIONS**

- Avoid contact with the skin and eyes. Wear suitable protective clothing such as overalls, goggles, dust masks and gloves. Use a barrier cream.
- Ensure that there is adequate ventilation in the area where the product is being applied. Do not breathe vapor or spray.
- This product is flammable. Keep away from sources of ignition. Do not smoke. Take precautionary measures against static discharge. In case of fire – blanket flames with foam, carbon dioxide or dry chemicals
- Refer to MSDS for further information.

**FIRST AID**

- Eyes: In the event of accidental splashes, flush eyes with water immediately and obtain medical advice
- Skin: Wash skin thoroughly with soap and water or approved industrial cleaner.
- DO NOT USE solvent or thinners.
- Inhalation: Remove to fresh air, loosen collar and keep patient rested.
- Ingestion: In case of accidental ingestion, DO NOT INDUCE VOMITING. Obtain immediate medical attention

**DISCLAIMER**

The information provided on this data sheet is not intended to be complete and is provided as general advice only. It is the responsibility of the user to ensure that the product is suitable for the purpose for which he wishes to use it. As we have no control over the treatment of the product, the standard of surface preparation of the substrate, or other factors affecting the use of this product, we are not responsible for its performance nor would we accept any liability whatsoever or howsoever arising from the use of this product unless specifically agreed to in writing by us. The information contained in this data sheet may be modified by us from time to time, and without notice, in the light of our experience and continuous product development.