

TECHNICAL DATA SHEET

PERMAGRIP P 400

EPOXY ZINC PHOSPHATE PRIMER

DESCRIPTION:	A two component, Polyamide cured epoxy primer containing zinc phosphate as an anti-corrosive pigment.	
RECOMMENDED USE:	Anti-corrosive protection of steel surfaces prepared by abrasive blast Cleaning. Can be used as primer for high performance Epoxy - Polyurethane systems. It can also be used as a repair primer for galvanized surfaces	
RESISTANCE TO:	Moisture – Excellent Abrasion – Excellent Aliphatic Solvents – Excellent Acid spillage - Moderate	Alkali spillage – Excellent Weather – Excellent Petroleum Solvents – Excellent
PRODUCT INFORMATION:		
Colour:	Red and grey	
Finish:	Matt	
Volume solids %:	53 ± 2% (ASTM-D2697-86)	
V.O.C.:	346 g/l (NB. – Thinning will affect VOC compliance and volume solids)	
Typical thickness:	40 - 60 microns dry film thickness	
Theoretical coverage:	13.25 m ² /ltr. @ 40 microns dft	
Density:	1.53 ± 0.1 g/cc (mixed)	
Flash point:	Base : 25°C C/A : 31°C	
Mixing ratio:	4 : 1 by volume	
Shelf life:	24 months from the date of manufacture	
Pot life:	8 hours @ 35°C	
Pack size:	Comp. A – 16 liters + Comp. B – 4 liters = 20 liters	

FILM THICKNESS AND SPREADING RATE:	MIN.	MAX.	UNIT
Dry film thickness	40	60	µm
Wet film thickness	75	113	µm
Spreading rate	13.25	8.83	m ² /l (theoretical)

This figure makes no allowance for surface profile, uneven application, overspray or losses in containers and equipment. Film thickness will vary depending on actual use and specification.

SERVICE TEMPERATURE: 150°C maximum dry

RECOMMENDED THINNER: Thinner No.5 (5%)

DRYING & CURING TIME:

SUBSTRATE TEMPRATURE	15°C	23°C	35°C
Touch dry	2 hours	1.5 hours	1 hour
Dried to over coat (minimum)	6 hours	4 hours	3 hours
Hard dry	24 hours	16 hours	12 hours

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SURFACE PREPARATION:

Steel: Remove all oil and grease in accordance with SSPC-SP1. Manually prepared surfaces should be prepared in accordance with SSPC-SP2 or SSPC-SP3. For more severe exposure, conditions blast cleaning to SSPC-SP 7 may be required. Abrasive blast clean to Sa 2 ½ BS7079:Part A1:1989. Average surface Profile 35 - 75 microns.

RECOMMENDED COATING SYSTEM:

Primer	PERMAGRIP P 400
Intermediate:	PERMAGRIP IT 880 / PERMAGRIP IT 401 / PERMAGRIP IT 653
Topcoat:	PERMATHANE T 137

Note: The above mentioned is a generally used system for steel structures, and if any alternative systems are required, please contact the KPC's technical team.

RECOMMENDED APPLICATION METHODS:

Airless spray, conventional spray, roller, brush

APPLICATION EQUIPMENT DETAILS:

CONVENTIONAL SPRAY

Nozzle Size: 1.27mm (50 thou)
Atomising Pressure: 2.8kg/cm² (40 psi)
Fluid Pressure: 0.7kg/cm² (10 psi)

AIRLESS SPRAY

Nozzle Size: 0.38mm (18 thou)
Fan Angle: 40°
Operating Pressure: 115kg/cm² (2200 psi)

APPLICATION CONDITIONS AND OVER COATINGS:

This material should preferably be applied at temperatures in excess of 10°C. In conditions of high relative humidity, i.e. 80-85%, good ventilation conditions are essential. Substrate temperature should be at least 3°C above the dew point and always above 0°C. At application temperatures below 10°C, drying and curing times will be significantly extended, and spraying characteristics may be impaired. Application at ambient air temperatures below 5°C is not recommended.

HEALTH AND SAFETY:

Please observe the precautionary notices displayed on the container. Do not breathe or inhale mist. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water and medical attention sought immediately.

Consult Product Health and Material Safety Data Sheet for information on safe storage, handling and application of this product.

Disclaimer: The information in this document is given to the best of KPC Paint's knowledge that based on laboratory testing and practical experience Products are often used under conditions beyond KPC's control and KPC Paints cannot guarantee anything but the quality of the product itself.

Date of issue 22.02.2021. Please note that this data sheet supersedes the previous version.