

TECHNICAL DATA SHEET

PERMAGRIP P984 ZINC RICH EPOXY PRIMER

DESCRIPTION: A two-pack epoxy, polyamide cured, zinc rich primer for use on abrasive blasted steel prior to application of final paint system. It is specially formulated for the use where high level of corrosion resistance is required.

RECOMMENDED USE: It is recommended for application under a wide variety of conditions and to a vast array of steel structures including, chemical plants, oil platforms, ships, power plants etc. It can also be used as a repair primer for galvanized surfaces.

RESISTANCE TO: Moisture – Good Weather – Excellent
Abrasion – Good Petroleum- Excellent

PRODUCT INFORMATION:

Colour: Grey
Finish: Matt
Volume solids %: 64 ± 2 % (ASTM-D2697-86)
V.O.C.: 310 g/l (NB. – Thinning will affect VOC compliance and volume solids)
Flash point: 25°C
Typical film thickness: 50 - 75 microns DFT
Mixing ratio: 4:1 by volume
Shelf life: 12 months from the date of manufacturing
Pot life: 24 hours
Pack size: 20 ltrs (Part A-16 ltr + Part B-4 ltrs)

FILM THICKNESS AND SPREADING RATE:	MIN.	MAX.	UNIT
Wet film thickness	78	117	µm
Dry film thickness	50	75	µm
Spreading rate	12.8	8.5	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 TEMPERATURE	10°C	23°C	40°C
Touch dry	30 mins	20 mins	10 mins
Through dry (Hard dry)	15 hours	12 hours	10 hours
Dried to over coat (minimum)	8hours	4 hours	2 hour
Hard dry	7 days	5 days	2 days

These figures are given as a guide only. Factors such as air movement and humidity must also be considered

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RECOMMENDED COATING SYSTEM:

Primer coat	PERMAGRIP P984
Intermediate	PERMAGRIP IT 880/IT 653/IT 401
Topcoat	PERMATHANE T 137

SURFACE PREPARATION:

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 APPLICATION METHODS:

Airless spray, conventional spray, roller (short pile only), brush

APPLICATION EQUIPMENT DETAILS:

AIRLESS SPRAY:

Nozzle Size: 0.38mm (15 thou)
Fan Angle: 40°
Operating Pressure: 115kg/cm² (2000 psi)

CONVENTIONAL SPRAY:

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

VENTILATION:

When used as a tank lining or in enclosed areas, thorough air circulation must be used during and after application until the coating is cured. The ventilation system should be capable of preventing the solvent vapor concentration from reaching the lower explosion limit for the solvents used. In addition to ensuring proper ventilation, appropriate respirators must be used by all application personnel.

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.

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