

## FEATURES

: Epoguard Primer is a high-build Epoxy / Polyamide Zinc Phosphate primer.

: As a high-build rust-preventing epoxy primer for steel structure, tank, pipe, bridge and chemical plant.

## TECHNICAL INFORMATION

Type	: Epoxy / Polyamide Anti-Corrosive Zinc Phosphate primer
Color	: Reddish Brown
Film appearance	: Semi-Gloss
Specific gravity	: 1.36 ± 0.05
Solid by volume	: 58 ± 2 %
Flash point	: 21 °C

		Minimum	Maximum	Recommended
Dry film thickness	(Microns)	100	150	100
Wet film thickness	(Microns)	172	259	172
Theoretical coverage.	m <sup>2</sup> / Liter	5.8	3.9	5.8
	m <sup>2</sup> / Gallon	22.0	14.6	22.0
Practical coverage.	m <sup>2</sup> / Liter	5.2	3.5	5.2
	m <sup>2</sup> / Gallon	20.0	13.2	20.0

Remark : Actual Surface coverage will depend on surface irregularities, Mixing, Application Condition method and technique; as well as the structure and dimensions of the object to be coated.

	Temperature	25 °C	30 °C	35 °C
Touch dry	Surface dry	1 hr.	45 mins	30 mins
	Hard dry	8 hrs.	6 hrs.	4 hrs.
Full cure	Minimum	12 hrs.	10 hrs.	8 hrs.
	Maximum	-	-	-
Potlife		10 hrs.	8 hrs.	6 hrs.

Remark : Drying times are generally related to air circulation, temperature, film thickness and number of coats, and will be affected correspondingly.

## FILM PERFORMANCE

Properties	Test Method	Criteria	Results
Adhesion	ASTM D 3359	5B	Passed
Pencil Hardness	ASTM D 3363	H	Passed
Flexibility	ASTM D 522 (Method B)	3 mm	Passed
Abrasion Resistance	ASTM D 4060	200 mg (loss)	Passed
	<small>CS-17 Wheels, 1000 g load, 1000 cycles</small>		
Impact Test	ASTM B 2794	60 inch-pounds	Passed
Salt Spray Resistance	ASTM B 117	500 hrs.	Passed

## APPLICATION

Mixing Ratio	Part A	Part B
By Volume	4	1
By Weight	7	1

Application Method	Airless Spray	Air Spray	Brush / Roller
Diluted by <b>TOA Thinner 31</b>	5-10	15-20	10-15
Applicator	Graco 419	Coventional Spray (Iwata)	Short Hair Stiff Nylon Roller (Stanley)
	Graco 412		Stiff Nylon Brush
Pressure	150-180 kg/cm <sup>2</sup>	3-4 kg/cm <sup>2</sup>	-

Mix Part A and Part B, strictly follow mix ratio recommendations before dilute by Thinner mixing and stir for 2-3 minutes until the mixture is homogeneous after leave 5 minutes before application.

## APPLICATION SYSTEM

### Surface Preparation

#### Steel

Remover all oil, grease, dirt, oxide and other foreign material.

#### High Quality

: Should be blast cleaned in accordance with NACE No.2 / SSPC-SP10 / ISO 8501:1 / SIS Sa 2.5 to a near-white finish using a suitable abrasive.

#### Medium Quality

: Treatment by using Power tool cleaning in accordance with SIS St 3 or SSPC-SP3 .

**Remark** : The surface must be thoroughly dry and apply the protective coating within 4 hours to cleaned surface.

#### Before Recoat by Topcoat

: Remover all oil, grease, dirt, oxide and other foreign material by cleaning per SSPC-SP1, Solvent Cleaning before coating.

: If over 7 days gives cleaning surface by sand paper no. 320-400 and cleaning surface per SSPC-SP1, Solvent Cleaning before coating.

: Surface repaire (cracks, pores, holes) done with TOA Epoxy putty and polishing of surface with moltoprene disk.

### Coating System

#### Protective Coating

: <b>Primer</b>	<b>Epoguard Primer</b>	<b>100 microns x 1 coat</b>
: Topcoat	Epoguard Enamel (for inside area) or Topguard (for outside area)	50 microns x 2 coats  50 microns x 2 coats

### Recommendation

: The proper relative humidity in the work shall not exceed 85% RH.

: The temperature of the substrate should be minimum 10°C and at least 3°C above the dew point of the air , temperature and relative humidity measured in the vicinity of the substrate for prevent moisture and water drop on substrate effective adhesion and drying time.

## HANDLING AND STORAGE

### Storage condition

: The product must be stored in accordance with national regulations. Storage conditions are to keep the containers in a dry, cool, well ventilated space and away from source of heat and ignition.

### Shelf life

: 24 months at 30-35 °C

### Package

Packaging size	Part A :	Part B :
1 Gallon Set	1 Gallon	1/4 Gallon

**HEALTH AND SAFETY**

: Please observe the precautionary notices displayed on the container. Use under well ventilated conditions. 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.

: For detailed information on the health and safety hazards and precautions for use of this product, we refer to the Safety Data Sheet.

**DISCLAIMER**

: The information in this data sheet is given to the best of our knowledge based on laboratory testing and practical experience. However, as the product is often used under conditions beyond our control, we cannot guarantee anything only the quality of the product itself. We reserve the right to change the given data without notice.