



FEATURES

: Epozinc HB is a two-pack high-build zinc rich epoxy primer.
As a high-build anti-corrosive paint for rust preventive for steel structure, tank, pipe and highly resistance to heat, oil, water and solvent.

TECHNICAL INFORMATION

Type : Epoxy / Polyamide Anti-Corrosive Zinc Rich primer
Color : Grey
Film appearance : Matt
Specific gravity : 2.35 ± 0.05
Solid by volume : $54 \pm 2 \%$
Flash point : $18 \text{ }^\circ\text{C}$

		Minimum	Maximum	Recommended
Dry film thickness	(Microns)	75	100	75
Wet film thickness	(Microns)	139	185	139
Theoretical coverage.	m ² / Liter	7.2	5.4	7.2
	m ² / Gallon	27.3	20.4	27.3
Practical coverage.	m ² / Liter	6.5	5.0	6.5
	m ² / Gallon	24.5	18.4	24.5

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	20 mins	15 mins	10 mins
	Hard dry	4 hrs.	3 hrs.	2 hrs.
Full cure	Minimum	16 hrs.	8 hrs.	6 hrs.
	Maximum	180 days	180 days	180 days
Potlife		12 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	2H	Passed
Impact Test	ASTM D 2794	60 inch-pounds	Passed
Salt Spray Resistance	ASTM B 117	1000 hrs.	Passed

APPLICATION

Mixing Ratio	Part A	Part B
By Volume	4	1
By Weight	9	1



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Application Method	Airless Spray	Air Spray	Brush / Roller
Diluted by TOA Thinner 31	5-10	15-20	10-15
Applicator	Graco 621	Coventional Spray (Iwata)	Short Hair Stiff Nylon Roller (Stanley)
	Graco 623		Stiff Nylon Brush
Pressure	90-120 kg/cm ²	3-4 kg/cm ²	-

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

: 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.

Remover all oil, grease, dirt, oxide and other foreign material by Solvent Cleaning before coating.

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

Coating System

Protective Coating

: Primer	Epozinc HB	75 microns x 1 coat
: Undercoat	Epoguard HB or Epoguard MIO	100 microns x 1 coat
: 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.