



REDOPOXY PRIMER 670HS

Epoxy High Solid Zinc Phosphate MIO Coating

Description

REDOPOXY 670HS Two component highly Corrosion Protective (Polyimide cured) coating, pigmented with Zinc Phosphate and Micaceous Iron Oxide. It provides a tough coating with long term protection. It has excellent adhesion and moisture barrier action for steel structures especially exposed to marine conditions.

Benefits

- Solves problem of chalking as it is unattacked by UV radiation
- Highly performance coating
- Excellent adhesion & moisture barrier action for steel structure
- Excellent chemical & corrosion protection

Highly resistance to the permeability of water, moisture, oxygen and other atmospheric pollutants.

Application Area

- undercoat and/ or Intermediate coat on Structures, Equipments, Pipe Lines, Vessels, Machinaries, Storage Tanks etc
- Infrastructure projects, Bridges, Refineries Pipelines, Chemical Plants, Steel Plants, Cement Plants, Petrochemicals Plants, Power Plants, Food Processing Plant, Railway wagons & coaches etc.

Technical Information

PROPERTIES	RESULTS
Color	Grey
Finish	Eggshell to Semi Glossy
Volume Solids (ASTM D 2697)	75 ± 3%
Recommended DFT	75 -150μ in single coat
Wet Film Thickness	100-200μ in single coat
Specific Gravity	1.70 ± 0.05
Surface Dry	45 min

The data given is for guideline only. The physical values are subject to normal manufacturing tolerances, colour and testing variances. The actual drying time/ overcoat interval may be shorter or longer, depending on film thickness, ventilation, humidity, temperature etc. The information provided above is at 30°C and 65% relative humidity

Direction For Use

- **SURFACE PREPARATION:**

All surfaces to be coated should be clean, absolutely dry and oil or moisture free before painting application. Oil and grease should be removed by solvent cleaning.

- **Repair Cases :**

Corroded areas should be power tool cleaned to St3 or blast cleaned to Sa2 or better. Existing system should be dry and free from loose paint, salt, grease and other contaminants prior to overcoating.

- **New steel :**

Abrasive blasting to Sa 2½ (ISO 8501-1:2007). For temporary protection, if required, use a suitable shopprimer. All damage of shopprimer and contamination from storage and fabrication should be thoroughly cleaned prior to final painting.

- **Maintenance :**

Remove oil and grease etc. thoroughly with suitable detergent. Remove salts and other contaminants by high pressure fresh water cleaning. Clean damaged areas thoroughly by power tool cleaning to St 3 (ISO 8501-1:2007) (minor areas) or by abrasive blasting to min. Sa 2, preferably to Sa 2½ (ISO 8501-1:2007). Improved surface preparation will improve the performance of the product.

- **Aged Surface :**

REDOPOXY 670HS is suitable for overcoating a limited range of intact, tightly adherent aged coatings. Loose or flaking coatings should be removed back to a firm edge. Glossy finishes require light abrasion by emery paper or power tool to provide a physical key.

- **Application Data :**

Application Method	Spray/ Airless Spray/Brush/ Roller
Mixing Ratio	4 Part (Base) : 1 Part (Hardener)
Pot Life	Four Hours at 30°C
Thinner and Cleaner	Epoxy Thinner
Airless Nozzle	0.45 - 0.53mm
Orifice Nozzle Pressure	176 kg/cm ² or 2500 psi

- **Working Precautions:**

Material should not be allowed to remain in pipeline, hoses, gun or spray equipment. Thoroughly flush all equipment with epoxy thinner. Once units of paint have been mixed they should not be resealed and it is advised that after prolonged stoppages, the work should recommences with freshly mixed units.

- **Maintenance:**

Clean all equipment immediately after use with epoxy thinner. It is good working practice to periodically flush out spray equipment during the course of the working day. All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.

Coverage

- REDOPOXY 670HS will give coverage of 10 sq.mt / lit at recommended DFT of 75 μ

Supply

- It is supplied in 20 lit set (16 lit base & 4 lit hardener).

Self-Life

- 1 year from the date of manufacturing. This is solvent based coating and the containers should be kept in a dry, cool, well ventilated space and away from sources of heat and ignition. Containers must be kept tightly closed.

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