



Epoxy Zinc Phosphate Anti Corrosive Primer



# REDOPOXY PRIMER 630

## Description

REDOPOXY 630 is a Two component Polyamine cured anti corrosive high performance medium solid coating containing Zinc Phosphate as corrosion inhibiting pigments.

## Benefits

- Prevent rust by corrosion inhibition & water vapour infiltration
- Oil Resistance and abrasion protection qualities
- Excellent adhesion & Mild chemical resistance
- Good resistance to abrasion

## Application Area

- New construction coating on various substrates like carbon steel, stainless steel, aluminum, galvanized steel etc.
- Recommended for Heavy Duty Truck Trailers, General Industrial, Heavy Infrastructure, Bridges, Petrochemical, Electrical Transformers and Refineries
- Used in Fertilizer & chemical industries

## Technical Information

PROPERTIES	RESULTS
Color	Grey, Buff, Beige, Custom Shades
Finish	Matt to Eggshell
Volume Solids (ASTM D 2697)	60 ± 3%
Recommended DFT	50 -80µ in single coat
Wet Film Thickness	80-130µ in single coat
Specific Gravity	1.50 ± 0.05
Surface Dry	60 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.

- **Stainless steel :**

To be abrasive blast cleaned to a uniform, sharp, dense profile (ISO Comparator Medium (G), corresponding to Rz minimum 50 micron. Any salts, grease, oil, etc. to be removed before abrasive blasting is commenced.

- **Application Data :**

Application Method	Spray/ Airless Spray/Brush/ Roller
Mixing Ratio	4 Part (Base) : 1 Part (Hardener)
Pot Life	Three Hours at 30°C
Thinner and Cleaner	Epoxy Thinner
Airless Nozzle	0.38 - 0.53mm
Orifice Nozzle Pressure	155 kg/cm <sup>2</sup> or 2200 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 630 will give coverage of 10 sq.mt / lit at recommended DFT of 60μ

## Supply

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

## Self-Life

- 2 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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