

DESCRIPTION

IJmopox ZF Primer is a general purpose, two component primer based on epoxy resin and apolyamide hardener.

PRINCIPAL CHARACTERISTICS

- Contains zinc phosphate as corrosion inhibitor;
- Recommended as primer in paint systems for the protection of steel, aluminium, wood, etc.;
- Excellent anti corrosion properties;
- Excellent adhesion to plastics and GRP;
- Suitable to repair small hair cracks and eliminate micro porosity in GRP;
- May be recoated with both two component or conventional coatings, even after a long weathering interval;
- Excellent mechanical properties;
- Application and curing at temperatures as low as 5 °C and relative humidifies as high as 90%;
- Excellent resistance to various chemicals and (sea) water;
- Easy to apply by brush or spray.

COLOURS AND GLOSS

Off-white - Eggshell

BASIS PROPERTIES (AT 23 °C AND 50% R.H.)

Density	: approx. 1,4 g/cm ³
Solid content	: approx. 55 % (volume)
Recommended d.f.t.	: 50 - 100 µm (depending on application), see additional information
Dust dry after	: approx. 2 hours
Full cure after	: approx. 5 days, see additional information
Recoating interval	: min. 16 hours, see additional information max. unlimited, provided clean and dry
Shelf life	: separate components, stored cool and dry in original packaging, minimum 12 months
Flash point (DIN53213)	: base component 25 °C hardener 30 °C

SPREADING RATE

at 50 µm (d.f.t.)	: 11,0 m ² /l
at 75 µm (d.f.t.)	: 8,3 m ² /l
at 100 µm (d.f.t.)	: 5,5 m ² /l

The practical spreading rate depends on a number of variables, such as: shape and size of object to be painted, the condition and profile of the substrate, the method of application, climatologic conditions and skill of labour.

SUBSTRATE CONDITION AND TEMPERATURE

Steel	: preferably grit blasted to ISO Sa 2½ or powertool cleaned to ISO St 3 (grit paper P24-36);
Aluminium	: sanded wit grit paper P60-80;
Wood	: moisture content maximum 12%, sanded with grit paper P120-180;
Reinforced polyester	: dry, sanded with grit paper P120-180;
Previous coatings	: two component coatings, clean and dry, in good condition, free from any contamination and loose particles, sanded with grit paper P80. IJmopox ZF primer is not compatible with one component coatings;
Other substrates	: clean and dry, in good condition, free from any contamination and loose particles, sanded with grit paper P80.

During application and curing a minimum temperature of 5 °C is allowed. The temperature of the substrate should be minimum 3 °C above dew point.

INSTRUCTIONS FOR USE

Before use, mix base and hardener components thoroughly.

Mixing ratio : 87,0 base : 13,0 hardener (by weight)
80,0 base : 20,0 hardener (by volume)

Do not prepare more material than can be applied within the pot life of the mixture.

Induction time : 10 minutes at temperatures of 15 °C and lower;
none at temperatures above 15 °C

Instructions for use

Pot life : 5 hours at 25 °C
8 hours at 20 °C
16 hours at 10 °C

Application with :

	Brush/roller	Air spray	Airless spray
Type thinner	IJmopox thinner	IJmopox thinner	IJmopox thinner
% of thinner	0 - 5 %	10 - 15 %	0 - 10 %
Nozzle orifice	n.a.	1,5 -2,5 mm	0,013 - 0,018 inch
Nozzle pressure	n.a.	3 - 4 bar	150 - 200 bar
Cleaning	IJmopox thinner	IJmopox thinner	IJmopox thinner

ADDITIONAL INFORMATION

- Recoating and curing of IJmopox ZF Primer:

	5 °C	10 °C	20 °C	30 °C
Minimum	48 hours	24 hours	16 hours	8 hours
Maximum, with IJmopox ZF Primer or Double Coat, without sanding	96 hours	96 hours	48 hours	48 hours
Maximum, with IJmopox ZF Primer or Double Coat, after sanding	unlimited	unlimited	unlimited	unlimited
Fully cured after	10 days	7 days	5 days	4 days

- Recommended filmthickness

The recommended filmthickness in this datasheet is for each separate layer and depends on application method. How many layers are recommended depends on the field of application, the exposure conditions and type of substrate. The total necessary number of layers can be found in the paint system recommendation.

- Application of IJmopox HB coating by brush or roller

IJmopox ZF primer is a thixotropic primer enabling application at high filmthickness. When applied by brush or roller this may result in brush marks or orange peel. We recommend to add 5 to 10% IJmopox thinner to improve levelling.

IJmopox ZF coating may be applied best using felt rollers.

- Application of IJmopoxZF primer by airless spray

- IJmopox ZF primer can be applied without adding additional solvent using a Wagner Cobra 40/10.
- Use a material pressure of 5 Bar (200 Bar with a pump ratio of 40:1).
- Use a nozzle of 0,013 inch with angle 40 or 60°.

SAFETY INFORMATION

See the corresponding Material Safety Data Sheet for detailed instructions on safety, disposal and health.

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Disclaimer

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