



DESCRIPTION

- a two pack polyamide cured epoxy high build zinc phosphate primer suitable for sanding
- approved to APAS-2919, APAS-2971
- conforms to AS/NZS 3750.13

PRINCIPAL CHARACTERISTICS

- general purpose anticorrosive primer for atmospheric use on steel
- excellent adhesion to steel
- excellent flow and wetting properties
- excellent corrosion resistance
- excellent sanding properties
- excellent impact and abrasion resistance
- cures at temperatures down to +5°C
- suitable for touching up of weld seams and damages of epoxy coatings during construction
- long recoating intervals are possible when overcoating with epoxy and polyurethane coatings
- can be overcoated with most alkyd, chlorinated rubber, epoxy, two component polyurethane and catalysed acrylic coatings
- not suitable for use on non ferrous substrates e.g. aluminium, galvanised steel, ZINCALUME®
- not suitable for immersion

COLOURS AND GLOSS

- Grey, Red - flat

BASIC DATA AT 25°C

- solids contentapprox. 54% by volume
- mix ratio4A:1B by volume
- typical film thickness (per coat).....75 microns(dry), 140 microns(wet)
- theoretical spreading rate7.2 m²/l for 75 microns(dry)
- touch dry after1 - 2 hours
- overcoatingrefer to overcoating table for details
- full cure after4 days
- shelf life (cool and dry place)at least 12 months

RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURE

- all surfaces to be coated must be clean, dry and free from chalking and contamination
- oil and grease should be removed from all surfaces in accordance with AS 1627.1 solvent cleaning
- mild steel; blast clean in accordance with AS 1627.4 to Sa 2 ½ minimum (AS 1627.9), surface profile 40-70 microns
- if oxidation occurs between blasting and application, the surface should be reblasted to the specified visual standard
- surface defects revealed by the blast cleaning process should be ground, filled or treated in the appropriate manner
- mild steel; power tool clean in accordance with AS 1627.2 to St 2 minimum (AS 1627.9)
- steel, wet blast clean to achieve a surface similar to Sa 2 ½ (AS 1627.9), profile 35-50 um
- previous suitable coat; dry and free from any contamination and sufficiently roughened if necessary
- substrate temperature must be at least 5°C during surface preparation, application and curing and at least 3°C above dew point
- relative humidity should not exceed 85%.



INSTRUCTIONS FOR USE

- mixing ratio by volume 4A:1B
- mix with Epinamel EH90 Part B only
- induction time - 20 mins at 15 °C, 10 mins at 25 °C
- stir thoroughly after the induction time before using
- pot life at 25 °C - 4 hours. Do not use after this time even if the mix is still liquid
- stir the components and mixed product well using a mechanical mixer
- the temperature of the mixed product must be above 15°C, otherwise extra thinner may be required to obtain application viscosity
- too much thinner will result in lower sag resistance and slower cure
- thinner should only be added after mixing the components
- freshly catalysed material should not be added to product that has been mixed for some time
- for recommendations outside those contained in this data sheet, refer to Wattyl

APPLICATION

- **AIRLESS SPRAY**
 - recommended thinner Thinner L760
 - volume of thinner..... up to 5%
 - nozzle orifice approx 0.46 mm (0.018inch)
 - nozzle pressure 15 MPa (2100 psi)
- **AIR SPRAY**
 - recommended thinner Thinner L760
 - volume of thinner..... up to 10%
 - nozzle orifice 1.5-2mm
 - nozzle pressure 0.3-0.4 MPa (50-60 psi)
- **BRUSH/ROLLER**
 - recommended thinner Thinner L760
 - volume of thinner up to 5%

The maximum dry film thickness that can be achieved when brushing/rolling is 50 microns
Multiple coats may be required to achieve the recommended dry film thickness
- **CLEANING SOLVENT** Thinner L760

SAFETY PRECAUTIONS

- flammable. Avoid contact with heat and naked flame
- avoid contact with skin and eyes
- use gloves, mask and goggles during application
- provide adequate ventilation when using in confined spaces
- this product is intended for use in industrial situations by professional applicators in accordance with the advice given on this sheet. All work involving the use and application of this product should be carried out in compliance with all relevant Health, Safety & Environmental standards and regulations and must not be used without reference to the Material Safety Data Sheet (MSDS)



EPINAMEL PR240ZPS

P30.05

ADDITIONAL DATA

Overcoating table

Substrate temperature	5 °C	15 °C	25 °C	35 °C
Minimum interval for epoxies	8 hrs	4 hrs	2 hrs	1 hr
Minimum interval for coatings other than epoxies	16 hrs	10 hrs	4 hrs	2 hrs
Maximum interval	14 days	10 days	5 days	3 days

- surface must be dry and free from chalking and contamination

Curing table

Substrate temperature	Touch dry	Dry to handle	Full cure
5 °C	4 hrs	8 hrs	14 days
15 °C	2 hrs	4 hrs	7 days
25 °C	1 hr	2½ hrs	4 days
35 °C	30 min	2 hrs	3 days

- adequate ventilation must be continuously maintained during application and curing

Potlife (at application viscosity)

Paint temperature	Potlife
15 °C	6 hrs
25 °C	4 hrs
35 °C	2 hrs

- adequate ventilation must be continuously maintained during application and curing

CUSTOMER SERVICE HOTLINE 132101 (Aust), 0800 735 551 (NZ)

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