

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) |
| 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 |

- 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.

Date: November '12
355-99999

Disclaimer

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