

PLASCOGUARD 40 UNIVERSAL EPOXY PRIMER

PRODUCT CODE: PEX 40 (Base) & PEH 40 (Curing Agent)

TECHNICAL DATA SHEET

Product Description	A low polyamide cured epoxy primer.																					
Intended Uses	<ul style="list-style-type: none"> Can be applied to mild steel, galvanised iron, aluminium and non-ferrous metal surfaces. For use on both new construction and maintenance. 																					
Features & Benefits	<ul style="list-style-type: none"> Can be used as a tie coat on zinc silicate primers. Suitable for use as a blast holding primer when applied at 20 µm. Quick drying. 																					
Product Information	Colour	Red oxide.																				
	Appearance	Matt.																				
	Volume solids	46% Mixed																				
	Recommended DFT	40 – 75 µm per coat																				
	Recommended WFT	87 – 162 µm per coat																				
	Theoretical Spreading rate	11.5 m ² /L at 40 µm DFT. at stated volume solids																				
	VOC	394 g/L																				
	Flash point	27 °C for both components & mixed paint																				
Application Details	Mixing	4 parts PEX 40 Base to 1 part PEH 40 Curing Agent 40 by volume. Stir both components separately with a power mixer until homogeneous. Add the hardener to the base and mix thoroughly together. Mix only in proportions shown above																				
	Method	<u>Airless spray</u> : Recommended tip Size: 0.016” – 0.021” Nozzle pressure: Min 141 bar (2000 psi.) <u>Conventional Spray (pressure pot)</u> : Suitable Gun : DeVilbiss MBC or JGA , Air Cap 704 OR 765 Fluid Tip : E <u>Brush</u> : Min: 40 - 50 µm DFT can be achieved <u>Roller</u> : Min: 40 - 50 µm DFT can be achieved																				
	Thinner	Not normally required for higher DFT. Can be thinned with EPOXY REDUCER (EPT 2) if necessary.																				
	Cleaner	EPOXY REDUCER (EPT 2)																				
	Pot life	23 °C - 6 hours																				
	Application Environment	<table border="1"> <thead> <tr> <th>Surface Temperature</th> <th>Ambient Temperature</th> <th>Relative Humidity</th> </tr> </thead> <tbody> <tr> <td>Min: 10 °C</td> <td>Min: 10 °C</td> <td>Min: 10%</td> </tr> <tr> <td>Max: 40°C</td> <td>Max: 40°C</td> <td>Max: 85%</td> </tr> </tbody> </table> <p>Or 3 °C above dew point</p>	Surface Temperature	Ambient Temperature	Relative Humidity	Min: 10 °C	Min: 10 °C	Min: 10%	Max: 40°C	Max: 40°C	Max: 85%											
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Storage and Packaging	Store away from direct sun, heat, open flames, sparks or severe cold. Shelf life: 12 months Dual Packs: 20L unit: 16L in a 20L container Base (PEX 40), 4L in a 5L container Curing Agent (PEH 40)) 5L unit: 4L in a 5L container Base (PEX 40), 1L in a 1L container Curing Agent (PEH 40))																					

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Surface Preparation	<p>MILD STEEL:</p> <ul style="list-style-type: none"> The surfaces to be over coated must be clean, dry, sound and free from contamination. Oil and grease should be removed using PLASCON AQUASOLV DEGREASER (GR 1) followed by clean water rinses. Soluble chloride content may not exceed 75mg per m². Dust and debris not to exceed 0,3% when tested in accordance with SANS test method 769. Areas of breakdown, damage or weld seams should be prepared to the specified standard and patch primed with PLASCOGUARD 40. Preferred surface preparation is abrasive blast cleaned to SA 2½ of the International standard ISO 8501-1:2007 to achieve a blast profile of 40 – 60 µm or mechanically abrade to Grade ST 3 ISO 8501-1:12007. The primer must be applied before oxidation of the steel occurs. If oxidation does occur the entire oxidised area should be re-blasted to the standard specified above. <p>GALVANISED STEEL:</p> <ul style="list-style-type: none"> Preferred surface preparation: Sweep blast using Garnet Mica reduced pressure to achieve a blast profile of 20 – 30 µm. or if sweep blasting is not possible, clean surface area using METALCARE GALVANISED IRON CLEANER (GIC 1) and rinse until a water break free surface is achieved. <p>ALUMINIUM/NON FERROUS METAL:</p> <ul style="list-style-type: none"> Using AQUASOLV DEGREASER (GR 1) scrub the surface with bristle brushes – “Scotch Brite” scouring Pads and rinse thoroughly with water. Polished aluminium must be abraded to a matt finish
Application	<ul style="list-style-type: none"> Apply one coat of PLASCOGUARD 40 at the recommended DFT
Caution	<ul style="list-style-type: none"> Will not cure adequately below 10 °C .For maximum performance curing temperature should be above 10°C In common with all epoxies, this product will chalk on exterior exposure. Rate of chalking will depend on climatic conditions.
Safety Precautions	<ul style="list-style-type: none"> Always keep paint out of reach of children. Ensure good ventilation during application and drying. If accidental contact with skin should occur, wash immediately with soap and water or a recognised skin cleaner. Take care to avoid contact with the eyes. In case of contact, immediately rinse the eyes with plenty of water and seek medical attention. Harmful if swallowed. Seek medical attention and do not induce vomiting. Do not smoke while painting. Flammable. Store in a cool dry place away from heat and sparks. Refer to Safety Data Sheet for complete information.
Shipping Weight	<p>UN Shipping No: 1263</p> <p>Dual pack 20L - 26,49kg Base (PEX 40), 5L - 4,116kg Curing Agent (PEH 40)</p> <p>Dual pack 5L - 6,716kg Base (PEX 40), 1L - 1,08kg Curing Agent (PEH 40)</p>

DISCLAIMER:

The recommendations contained herein are given in good faith and are meant to guide the specifier or the user. They are based on results gained from our tests and experiences and are believed to be reliable. No guarantee is implied by the recommendations contained herein since conditions of use, method of application and cleanliness of the substrate prior to painting are beyond our control.

NB: Technology may change with time necessitating changes to this Technical Data Sheet (TDS). It is the responsibility of the user to ensure that the latest TDS is being used.

NB: TO ORDER: Quote product name, product code number, packaging and colour.

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