

## PROTEGACOAT HSP

### DESCRIPTION

Compliant two pack epoxy solvent borne primer, specially designed for use with ProtegaDur HS topcoat.

### PRODUCT FEATURES AND RECOMMENDED USES

- ◆ Compliant to UK regulations at application viscosity, but with smooth lay down properties (below 250 gm/lt).
- ◆ No top coat shrinkage.
- ◆ Good salt spray resistance.
- ◆ Suitable for application by conventional and airless spray.
- ◆ Excellent adhesion to thoroughly degreased mild steel, shot blasted steel or phosphated steel (preferred).
- ◆ Suitable for agricultural and earth moving equipment.

### TECHNICAL DATA

#### Volume solids

69 ± 5% (ISO 3233) depending on colour.

#### Weight solids

82 ± 5% depending on colour.

#### Viscosity

3.0 – 6.0 poise @ 25°C unmixed, depending on colour.

#### Specific gravity

1.5 – 1.6 unmixed, depending on colour.

#### Product code

Base 3381 series  
 Hardener 4065 018 or 4065 022  
 (mix ratio varies depending on the colour from 3:1 to 6:1)

#### Pot life

With 4065 018 - 45 minutes @25°C and 1 bar pressure to double in viscosity.  
 With 4065 022 - material is only suitable for application with 2K equipment.  
 Note: Gel time is 100 minutes @25°C.

#### Recommended film thicknesses and theoretical coverage

Recommended film thicknesses		Theoretical coverage
dry	wet	
25 µm	35 µm	27.6 m <sup>2</sup> /l
45 µm	65 µm	15.3 m <sup>2</sup> /l

Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated.

#### Drying time

DFT 45 µm	+ 23 °C
Flash off time	10 – 15 mins
Air dry	1 – 2 hours touch dry, hard overnight
Force dry	20 – 30 mins @ 60 – 80°C
Overcoating	Wet-on-wet after 15 – 20 mins

Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation.

#### Finish

Semi-matt.

#### Colours

Buff, Black, Grey and shades to order.

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### APPLICATION DETAILS

<b>Surface preparation</b>	Surfaces should be clean and dry and free from oil, grease, salts, dirt and general contamination. Preliminary cleaning: remove oil grease with a suitable detergent. Remove salt and other contaminants by fresh water cleaning and allow to dry (ISO 12944-4). Pre-treatment improves adhesion and reduces corrosion under the paint film. The type of pre-treatment depends on the requirements for corrosion protection e.g. <ol style="list-style-type: none"><li>1. Zinc phosphate with Cr-VI passivation.</li><li>2. Iron phosphate with demineralised water rinsing (insufficient rinsing can lead to the osmotic formation of bubbles).</li><li>3. Alkaline or neutral degreasing.</li><li>4. Clean steel.</li></ol>
<b>Application conditions</b>	Only apply in conditions of good ventilation which must be maintained during drying. Do not apply when rain, mist, sleet or snow are imminent. During application and drying time of the paint coating, the surface should be dry, the Relative Humidity should not exceed 85% and the steel temperature should remain at least 3°C above the dew point.
<b>Mixing</b>	Mix only in the proportions stated, mixing each component individually then together using a mechanical agitator.
<b>Application</b>	Refer to Protega Epoxy Application & Curing Notes. Ensure the correct catalyst (4065 018 or 4065 022) and ratio are used and mix the paint thoroughly before use. Note: the ratio varies depending on the colour from 3:1 to 6:1. Airless spray application viscosity 4.5 – 5.5 poise @25°C mixed. Typical tip sizes employed are 11 – 13 thou. Suitable for spraying by conventional air spray when thinned to 30 – 45 seconds BSB4 @ 25°C (non compliant).
<b>Thinner</b>	1728 Thinner.
<b>Cleaning of equipment</b>	Remove remaining paint from equipment, flush thoroughly with 1728 Thinner until solvent appears uncontaminated.
<b>FLASH POINT</b>	Below 21°C
<b>STORAGE</b>	Store in dry, cool conditions and protect from frost.
<b>VOC</b>	Volatile Organic Compound content: 299 ± 20 gm/lt, varies considerably with colour.
<b>HEALTH AND SAFETY</b>	Containers are provided with safety labels, which should be observed. Further information about hazardous influences and protection are detailed in individual health and safety data sheets. A health and safety data sheet is available on request from Protega Coatings Ltd.
<b>PRODUCT NOTES</b>	Do not apply or cure below 7°C, temperatures above 10°C recommended. Product will chalk on prolonged exterior exposure, the degree to which is subject to atmospheric conditions. Low flash material – ventilate to keep solvent vapour levels below minimum explosive limit. Observe low flash regulations.

This information is given in good faith for the guidance of users but without warranty or liability. Any queries should be referred to our Technical Department. The above information, based on laboratory tests and practical experience, has been proved valid at the date marked on the product data sheet. When necessary verify the validity of the product data sheet. The quality of the product is ensured by our operational system, based on the requirements of the standards ISO 9001. As a manufacturer we cannot be responsible for any damages caused by using the product against our instructions or for inappropriate purposes. For professional use only.