

PROTEGASHIELD EPY372 & 373

DESCRIPTION

A two component, epoxy zinc phosphate/MIO, fast curing primer/finish.

PRODUCT FEATURES AND RECOMMENDED USES

- ◆ Designed as a primer/finish where an MIO finish is required, or can be overcoated with a coloured finish where necessary.
- ◆ Formulated for speed of application and handling in workshop conditions.
- ◆ Suitable for 'blast, fabricate, prime' methods in controlled workshop conditions.
- ◆ Good resistance to undercutting from damaged areas.
- ◆ Ideal works coat to be overcoated by most generic top coats including alkyd, chlorinated rubber, vinyl, epoxy, and polyurethane.
- ◆ Excellent build and hold up on edges.
- ◆ Suitable as a base under most intumescent coatings – consult Protega for full details.
- ◆ Use on internal and external steel work in chemical, petrochemical environments.
- ◆ EPA compliant when applied as a blast primer or finish coat.

TECHNICAL DATA

Volume solids 54 ± 2% mixed (ISO 3233).

Weight solids 75 ± 2% mixed.

Specific gravity 1.54 – 1.56 (mixed).

Product code

Paint	5 parts by volume	3345 105 (EPY372), 3345 104 (EPY373).
Activator	1 parts by volume	4050 063
Composite		4860 105 (EPY372), 4860 104 (EPY373).

Pot life 6 hours @ 23°C.

Recommended film thicknesses and theoretical coverage

Recommended film thicknesses		Theoretical coverage
dry	wet	
100 µm	185 µm	5.4 m ² /l
200 µm	370 µm	2.7 m ² /l

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

Drying time

DFT 100 µm		+10°C	+23°C	+35°C
Dust Free		40 mins	15 – 20 mins	10 mins
Hard Dry		4 h	2½ h	1 h
Overcoating	min	See Product Notes		
	max	Depends on conditions		

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

Finish Matt.

Colours Natural Grey (EPY372), Silver Grey (EPY373).

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APPLICATION DETAILS

Surface preparation Degrease steel where necessary to SSPC-SP1 solvent cleaning to remove weld flux and general contamination prior to blasting.
All sharp edges should be ground and weld spatter removed.
Blast clean to Swedish Standard SIS 05 5900 Sa 2½ or British Standard 7079 equivalent.
Maximum profile 75 microns.
Surfaces should be clean and dry and free from oil, grease, salts, dirt and general contamination.

Application conditions Only apply in conditions of good ventilation which should 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.

Mixing Mix only in the proportions stated, mixing each component individually then together using a mechanical agitator. Ensure complete homogeneity before use.

Application

Method	Airless Spray	Automatic Spray	Conventional Spray	Brush	Roller
Output Fluid Pressure	2500 – 3000 p.s.i.	No	Any suitable equipment thinning may be necessary	Yes	Yes
Tip Size	19 – 20 thou				

Refer to Protega Epoxy Application/Curing notes.

19 thou tip, 40 degree angle is preferred.

Brush/roller application will result in a reduced dft. This method will provide approximately 60 microns dry.

Avoid exceeding the maximum stated dry film thickness.

Thinner 1031 Thinner.

Cleaning of equipment Remove remaining paint from equipment, flush thoroughly with 950 Thinner until solvent appears uncontaminated.

FLASH POINT Below 21°C

STORAGE Store in dry, cool conditions and protect from frost.

VOC Volatile Organic Compound content: 387 ± 20 gm/lit, varies with colour.

HEALTH AND SAFETY 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.

PRODUCT NOTES

Overcoating:

- with ProtegaCoat GPL and itself – min 2 hours @25°C.

- with ProtegaThane PLV, PLS(HS) or ProtegaSeal EA80 or EA90 – minimum 12 hours @25°C.

Do not apply or cure below 10°C.

Product will chalk, the degree to which is subject to atmospheric conditions.

As MIO coatings have a finely profiled finish, thin finish coats may require double coating to provide full obliteration and a cosmetically sound finish.

Low flash material – ventilate to keep solvent vapour levels below minimum explosive limit.

Observe low flash regulations.