



we protect life with colours

RELIPOXY P 304

EPOXY BASED ZINC PHOSPHATE UNIVERSAL PRIMER

PRODUCT DATA

PRODUCT DESCRIPTION:	Two component air drying Polyamide cured Epoxy universal primer containing zinc phosphate as anti corrosive pigment.
RECOMMENDED USE	Recommended as a primer for suitably cleaned MS, GI, Aluminium & Stainless steel surfaces, in OEM equipment painting as well as an anti corrosive primer in Process industries like fertilizer plants, Refineries, Petrochemical complexes for protection of steel pipelines and structures from corrosion.

PHYSICAL DATA

COLOUR	Assorted shades
FINISH	Matt
SOLIDS BY VOLUME	52±3%
THEORETICAL COVERAGE	13 sq.mt/ltr at recommended DFT of 40µ
FLASH POINT	Base: 23 ⁰ C; Hardener: 23 ⁰ C; Mixed: 23 ⁰ C
DRYING CHARACTERISTICS	Surface dry: 20-30 Minutes; Hard dry: 24 Hours; Full cure: 7 Days (At 30 ⁰ C and 65% Relative humidity)
SHELF LIFE	Base: 9 months; Hardener: 9 Months At 25 ⁰ C

APPLICATION DATA

MIXING RATIO	Base: Hardener – As per our recommendation
MATURATION TIME	5 – 10 minutes
POT LIFE	6 hours at 30 ⁰ C
APPLICATION	By Brush / By Air spray / By Airless spray
THINNER	REP T 03
RECOMMENDED DFT	40-45 µ per coat
CORRESPONDING WFT	77-86 µ per coat
OVERCOATING INTERVAL	MIN: 8 hours; MAX: 24 hours If exceeds, the surface should be roughened by emery scuffing.
COMPATIBILITY	Can be applied over recommended Epoxy and Polyurethane primers, Intermediate coats.

Resistance Guide

Chemical Resistance

Exposure	Splash and Spillages	Mild Fumes/outdoor Resistance
Acids	Good	Good
Alkalis	Good	Good
Solvents	Very Good	Very Good
Salt	Very Good	Very Good
Water	Very Good	Very Good

Temperature Resistance

Continuous: 93⁰ C
Intermittent: 120⁰ C

Weatherability: Very good with suitable top coat

Flexibility: Good

SURFACE PREPARATION

Remove grease, oil and other contaminants preferably using Degreasing solvent. Blast clean to a minimum of Sa 2^{1/2} Swedish Standard SIS 05 5900 with a surface profile not exceeding 65 microns. If Blasting is not possible, make full use of mechanical devices along with manual chipping and wire brushing to remove loose rust and scale to St. 2 Swedish Standard SIS 05 5900. Excessive burnishing of steel is to be avoided. Thoroughly dust down all surfaces.

HEALTH & SAFETY

All work involving the application and use of this product should be performed in compliance with all relevant National Health, Safety & Environmental standards and regulations. Prior to use, obtain, consult and follow the Material Safety Data Sheet for this product concerning health and safety information. Read and follow all precautionary notices on the Material Safety Data Sheet and container labels. If you do not fully understand these warnings and instructions or if you can not strictly comply with them, do not use this product. Proper ventilation and protective measures must be provided during applying and drying to keep solvent vapour concentrations within safe limits and to protect against toxic or oxygen deficient hazards. Take precautions to avoid skin and eye contact (i.e wear gloves, goggles, face masks, barrier creams etc.) Actual safety measures are dependant on application methods and work environment. This is a solvent based paint and care should be taken to avoid inhalation of spray mist or vapor as well as contact between the wet paint and exposed skin or eyes.

APPLICATION METHOD

Stir the Base part thoroughly. Mix the base and hardener as per our recommended ratio, by volume. Stir & mix thoroughly to attain homogeneity. Add REP T 03 into the mix, if required, depending on application method, and stir thoroughly for few minutes. Allow the mixture to stand still (maturation) for about 10-15 minutes to initiate the reaction. Strain the paint through Nylon filter cloth of 400 mesh size and apply uniformly over the surface. The temperature of the substrate should be minimum 3°C above the dew point of the air, temperature and relative humidity measured in the vicinity of the substrate. Good ventilation is usually required in confined areas to ensure correct drying. All equipments used for above should be properly cleaned.

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Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with recommended thinner. Once units of paint have been mixed they should not be resealed and it is advised that after prolonged stoppages work recommences with freshly mixed units. Clean all equipments immediately after use with recommended thinner. It is good working practice to periodically flush out spray equipment during the course of the working day. Frequency of cleaning will depend upon amount sprayed, temperature and elapsed time, including any delays. Do not exceed pot life limitations. All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.

In the event where welding or flame cutting is performed on metal coated with this product, dust and fumes will be emitted which will require the use of appropriate personal protective equipment and adequate local exhaust ventilation.

Application: By Brush/ByAirSpray/ByAirless Spray

For Brush application, a maximum of 5% thinner, if required, is to be added. Apply uniformly in criss-cross manner and ensure there are no misses. Use quality brushes for paint application.

For Air spray application:

Thinner: REP T 03

Addition: 10-15%

Nozzle Orifice: 1 .2 -1 .4 mm

Nozzle Pressure: 40-70 p.s.i

For Airless spray application:

Thinner: REP T 03

Addition: Max 5%

Nozzle Orifice: 0.28 mm

Nozzle Pressure: 1400-1800 psi.

ADDITIONAL INFORMATION

Further information regarding industry standards, terms and abbreviations used in this data sheet can be found in Reliable Paints Data manual.

NOTES

1. Do not apply paint when temperature falls below 10°C or rises above 50°C and when Relative Humidity is above 85%, Do not apply during rain, fog, or mist.
2. Brushes and spray equipment should be cleaned with recommended thinner otherwise equipment is liable to damage.
3. Volume Solids will vary depending on shades. Products with different volume solids are also available on request.
4. DFT variation can be obtained by change in application method/thinning ratio. Contact Reliable Paints' representative for further assistance.
5. Shelf life indicated is minimum for this Product and it is subjected to re-inspection thereafter. Individual component is required to be store in cool, dry and covered condition, away from heat and ignition.

DISCLAIMER

The information contained within this data sheet is based on information believed to be reliable at the time of its preparation. The company will not be liable for loss or damage howsoever caused including liability for negligence which may be suffered by the user of the data contained herein. It is the users' responsibility to conduct all necessary tests to confirm the suitability of any product or system for their intended use. No guarantee of results is implied since conditions of use are beyond our control.



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