

**PRODUCT NAME**

2PK Zinc Rich Epoxy Primer

**ORIGINALLY ISSUED**

12/12/2018

**VERSION**

1.0

**PRODUCT CODE**

PRIZR31104-3L

**VERSION DATE**

12/12/2018



**PRODUCT DESCRIPTION**

An Ultra Zinc Rich, high build 2K Epoxy Primer.

It offers very good anti-corrosive properties and can be overcoated quickly without aeration problems.

Product dries to a Matt Grey finish, which can be rubbed with wire wool to give a galvanised metallic effect, if required.



**IMPORTANT INSTRUCTIONS BEFORE USE**

- Read and follow SDS, TDS and label instructions
- Stir all paints thoroughly before use
- Always use the same batch number on the same job
- Check colour & sheen. HMG will not accept any discrepancies arising after use
- Filter the product immediately before use
- Reduce emissions and maintain quality by replacing tin lid after use
- If in any doubt speak HMG Technical Service Department on (0161) 205 7631



**MAXIMUM VOC CONTENT (RFU)**

0.460Kg/L

**REGULATIONS / COMPLIANCE**

- 2004/42 IIB (C) 540



**GENERAL INFORMATION**

Coverage 10 square metres per litre @ 55 microns dft  
Flashpoint 24°C  
Temp Resistance Over short periods 200°C  
Storage Store between 5°C - 25°C. When not in use, cans must be kept sealed  
Shelf Life 12 months from delivery date in original sealed containers



**CLEANING**

Ensure surfaces to be coated are dry and must be cleaned using the appropriate HMG product to remove all traces of contaminants.

HMG produce a full range of cleaners, silicone removers, degreasers and preparatory cleaners suitable for the cleaning process.

Please refer to our website for Knowledge Base article Prep-Cleaning Techniques (KNB0009) and Preparatory Cleaners from the Product Guide.



**SURFACE PREPARATION**

Please refer to Knowledge Base for details on Surface Preparation.

Under no circumstances use a pre-primer or rust conversion coating prior to application.



**HEALTH AND SAFETY**

- Refer to SDS and tin label prior to use.

**APPLICATION METHODS**



**MIXING RATIO**

	BRUSH		COMPLIANT SPRAY GUN		PRESSURE POT		AIRLESS/AIR-ASSISTED	
Base	6		Base	6	Base	6	Base	6
Hardener	1		Hardener	1	Hardener	1	Hardener	1



**HARDENER OPTIONS**

Hardener 9058 Standard	Hardener 9058 Standard	Hardener 9058 Standard	Hardener 9058 Standard
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**THINNER OPTIONS**

Thinner 2691	Thinner 2691	Thinner 2691	Thinner 2691
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**VISCOSITY**

		28-35	seconds B4 cup	28-35	seconds B4 cup	35-40	seconds B4 cup
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**SPRAY GUN SETUP**

	1.8-2.0	1.1-1.4	13-15 thou 40/50°
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**NUMBER OF COATS (GUIDE ONLY)**

1-2 Full Coats	1-2 Full Coats	1-2 Full Coats	1 Coat
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**FLASH OFF**

15 mins between coats	15 mins between coats	15 mins between coats	15 mins between coats
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**DRYING TIME**

Touch dry	30mins @20°C	Touch dry	30mins @20°C	Touch dry	30mins @20°C	Touch dry	30mins @20°C
Hard dry	8hrs @20°C	Hard dry	8hrs @20°C	Hard dry	8hrs @20°C	Hard dry	8hrs @20°C

	<b>POT LIFE</b>			
	8 hrs @ 20°C	8 hrs @ 20°C	8 hrs @ 20°C	8 hrs @ 20°C
	<b>WET FILM THICKNESS*</b>			
	100 microns	100 microns	100 microns	100 microns
	<b>DRY FILM THICKNESS*</b>			
	55 microns	55 microns	55 microns	55 microns
<p><small>* - HMG Technical Data Sheets indicate a Dry Film Thickness that will be achieved when applying a particular Wet Film Thickness. These values are a guide only and are not to be used as specifications. Film thickness will vary depending on actual use and specification. Great care should be taken to achieve the dft stated in the agreed specification and to avoid areas of excessively low or high thickness.</small></p>				

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