

PRODUCT DATA SHEET

Product Code 5053

MARIPOXY 650

HIGH SOLID EPOXY ZINC PHOSPHATE PRIMER

Description	Maripoxy HS Epoxy ZP Primer is a 2 K high build anticorrosive epoxy primer. It contains zinc phosphate pigment to further improve its corrosion resistance property.
Uses	This is a multipurpose Epoxy primer which can be used on Steel substrate to get good Anticorrosive Property. It can be applied by spray and by Flow which makes it suitable for Painting of wide range of objects. Besides the general steel structure, it is suitable for painting of Transformer radiators too.

PHYSICAL PROPERTIES

Colour	Grey
Finish	Matt , Smooth and Free from any surface defects
Density	1.7 Kg/Liter
Volume Solid %	68±2
Theoretical Coverage	About 14 Sq. Meter / Liter at 50 Micron DFT(without loss factor)
Flash Point	32 °C
Touch Dry	2 Hours
Hard Dry	Overnight
Full Cure	7 days
VOC	302 ± 3 Grams /Liter
Service Temperature	125° C.

APPLICATION DETAILS

Mixing Ratio - Base: Hardener	5:1 by Volume
Application Method	Airless Spray, Conventional Spray, Brush and by Flow/Flooding
Pot Life	3.0 Hours at 30°C (Pot Life will decrease with increase in room temperature and vice versa)
Nozzle Size	0.017"-0.021"
Pressure by Airless Spray	160-180 Bar
Dry Film Thickness (DFT)	40- 80 Microns (viscosity can be adjusted to achieve required DFT but thinning not to exceed more than 15% of thinner no 055)
Wet Film Thickness (WFT)	75- 110 Microns
Over coating Interval	Minimum – 2.5 Hours and Maximum 3 Weeks

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SURFACE PREPARATION	<p>New steel: Surface should be free from all dust, dirt, oil and grease etc. Salts and other contaminants can be removed by high pressure fresh water wash. Substrate to be blasted to Sa 2 ½ or ST 2-3.</p> <p>Mild Steel components, Zinc Phosphate pretreatment can be applied but components need to be dried and moisture removed before application of Maripoxy HB ZP primer.</p> <p>Temporary Protection of steel before application of primer - It is recommended to use zinc shop primer for temporary protection however it needs to be cleaned thoroughly before application of HB Primer.</p> <p>Maintenance of old painted structure: Clean already painted surface with detergent to remove dust, dirt, oil and grease etc. Salts and other contaminants can be removed by high pressure fresh water wash. Remove all rust and loose material preferably by dry abrasive blasting. Minor areas may be power tool cleaned.</p>
APPLICATION CONDITIONS	Avoid use of paint when atmospheric temperature is below 10 Deg. C. Temperature of Paint to be sprayed need to be maintained above 15 degree centigrade.
PREVIOUS COAT	None (Direct on Metal)
SUBSEQUENT COAT	Maripoxy MIO/ Maripoxy MASTIC or Marithane PU Topcoat
CAUTION	Epoxy Paints are prone to Chalking and Fading on direct exposure to Sunlight. It is recommended to overcoat Epoxy primer/Mid Coat with PU Paint to get good outdoor durability and maintain aesthetics.
SAFETY	Maripoxy Epoxy Paints are solvent based products, user need to take safety precaution which are applicable to all the petroleum based inflammable products. Painting should be done in open and ventilated place. Use Foam based fire extinguishers in case of fire. Keep it away from direct fire/ flame and store the product under the shade below 35 degree Centigrade.

Issued By Marigold Paints Private Limited,

The Product is for Industrial use only. Product data given here *is correct to the best of our knowledge but their accuracy may vary depending upon the quality of the substrate, application parameters and atmospheric conditions affecting the performance of the product. Therefore the users* are advised to make their own tests to determine the suitability of products for their own purposes under present conditions.

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