



**ATIYEH PAYESH BARAK CHEMICAL COMPANY
(OXsos)**

Marine, Offshore, Industrial & Protective Coatings

Data sheet

OXSOPOXY SURFACE TOLERANT PRIMER 371

Product Description

A two-pack epoxy primer for an excellent protection of steel structures against corrosion in industrial and marine environments. This versatile primer can be used on steel and other metal substrates and is compatible with (ultra) high – pressure hydro blasting as surface preparation.

Physical Properties

<u>Color/Texture</u>	Gold Olive (RAL), Silver Brown (96) / Matt
<u>Volume Solids</u>	52%
<u>Specific gravity</u>	1.35 ± 0.05 gr/ml
<u>Flashpoint</u>	>25°C

	Dry film thickness per coat (μ)	Wet film thickness per coat (μ)	Theoretical spreading rate (m ² /l)
Range	60-100	115-195	8.7-5.2
Recommended	75	145	6.9

Note: Specific gravity of paint may vary slightly due to shade difference.

Application Data

<u>Mixing ratio</u>	by wt. base to hardener: 85 to 15
<u>Pot life</u>	10°C: 10 hours 23°C: 6 hours 30°C: 4 hours 40°C: 3 hours
<u>Induction time</u>	None
<u>Guiding data Airless spray</u>	Pressure at nozzle: 120 –200 bar. Nozzle size: 0.38 – 0.53 mm Spray angle: 40 – 80 degrees. Volume of thinner: 0 – 3 %.
<u>Guiding data Air spray</u>	Pressure: 4–6 bar. Nozzle size: 1.2 – 2.0 mm. Volume of thinner: 0 – 3 %
<u>Brush</u>	Suitable but in general recommended for touch – up of small areas. Multicoat are Required to achieve the specified dry film thickness. Volume of thinner: 0 – 5 %
<u>Thinner/ Cleaner</u>	OXSO epoxy Thinner T-63. If thinner is necessary, this should be added after mixing of the two Components. Avoid excessive thinning as it will result in lower sag resistance and slower cure.

Drying and Recoating Times¹

Substrate temperature	Touch dry	Dry to handle	Hard dry	Dry to recoat	Dry to recoat
				Minimum	Maximum ²
10° C	5 hours	14 hours	10 days	24 hours	8 days
23° C	4 hours	10 hours	8 days	16 hours	7 days
30° C	2 hours	8 hours	6 days	13 hours	5 days
40° C	1 hours	5 hours	4 days	10 hours	4 days

(¹): The given data must be considered as guidelines only. The actual drying time/times before recoating may be shorter or longer, depending on film thickness, ventilation, humidity, preceding paint system etc.

(²): The surface should be dry and free from contaminants prior to over coating. When the maximum recoating time is exceeded it may be necessary to roughen the surface to ensure intercept adhesion. When in doubt, consult your nearest OXSOS office.

Surface Preparation

Steel

Oil and grease should be removed by solvent cleaning according to SSPC-SP1. Remove Weld spatter and smooth weld seams and sharp edges as applicable. Abrasive blasting: Min. Sa 2.5 – ISO 8501:1 Apply **OXSPOXY SURFACE TOLERANT PRIMER 371** immediately after the steel has been blasted and the quality of preparation has been approved.

Aluminum

Solvent cleaning according to SSPC-SP1 followed by light blast cleaning with a fine grade abrasive or by chemical etching.

Galvanized/Zinc primed steel

Remove zinc salts by power- or hand tool cleaning. Solvent cleaning according to SSPC-SP1.

Repair

Corroded areas should be power tool cleaned to ISO-St3 or blast cleaned to ISO-Sa2 or better. Existing systems should be dry and free from loose paint, salt, grease and other contaminants prior to .

Application Conditions

The temperature of the substrate should be at least 10°C and at least 3°C above the dew point of the air. Temperature and relative humidity should be measured in the vicinity of the substrate. Humidity should be below 80% RH. The maximum recommended surface temperature is approx. 35°C. Higher steel temperature is acceptable provided dry-spray is avoided by proper spray application and extra thinning if required. In extreme cases it may be necessary to reduce film thickness in order to avoid sagging. When applying the paint in confined spaces, provide adequate ventilation during application and drying. The temperature of the mixed paint should be at least 10°C, otherwise extra solvent may be required to obtain a proper application viscosity. The maximum temperature of paint before application should be 40°C.

Storage and Shelf Life

This product has the shelf life of 12 months in storage temperature of 10 -30°C. The cans are to be kept in a dry, cool, well ventilated space and away from source of heat and ignition. Cans must be kept tightly closed.

Worldwide Availability

The product is part of the common OXSOS product range but local availability is subject to confirmation. Although we strive to supply the same product through the world, slight modifications of the product in some cases may be necessary in order to comply with local conditions and national regulations. In such cases an alternative datasheet will be issued.

Health and Safety

Observe the precautionary notices on the label of the container. A material safety data sheet is available upon request and national or local safety regulations should be followed. This product is intended for use by professional applicators. As a general rule, avoid skin- and eye contact by wearing overalls, gloves, goggles, mask, etc. Spraying should be carried out under well-ventilated conditions. THIS product contains flammable materials and should be kept away from sparks and open flames. Smoking in the area should not be permitted.

Disclaimer

The information in this data sheet is provided to the best of our knowledge. However, we have no control over either quality or condition of the substrate and other factors affecting the use and application of this product. Therefore, we cannot accept any liability whatsoever or howsoever arising from the performance of the product or for any loss or damage arising from the use of this product. We reserve the right to change the product without notice.

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