

# TECHNICAL DATA SHEET

**Grauer & Weil (India) Limited**  
**Paints**



## Pentadur HB 8531

**EIL:P-6**

### PRODUCT DESCRIPTION

**Pentadur HB 8531** Two pack Poly amine cured, epoxy resin rich anticorrosive High Build primer containing zinc phosphate pigment. This is designed to provide high thickness and high over coating interval due to presence of reinforced resin system. Contains only food grade pigments and resin system.

### INTENDED USES

The primer gives excellent adhesion to steel. It is compatible with a wide range of topcoats and thus forms highly efficient protective schemes for corrosive, coastal and chemical environments. It is specially designed for application inside Water & petroleum product tanks as primer under the epoxy top coats.

### PRACTICAL INFORMATION FOR Pentadur HB 8531

<b>Color</b>	Grey/Red oxide
<b>Gloss Level</b>	Matt
<b>Volume Solids</b>	60% ± 2%
<b>Typical Thickness</b>	40-75 microns Per Coat
<b>Theoretical Coverage</b>	8-15 m <sup>2</sup> /liter Per Coat at 40-75 microns thickness
<b>Practical Coverage</b>	Allow appropriate loss factors
<b>Method of Application</b>	Airless spray. Brush for smaller area.

### Drying Time & Over Coating Intervals.

Temperature	Over coating Interval of <b>Pentadur HB 8531</b>			
	Surface Dry	Hard Dry	Minimum	Maximum
35°C (95°F)	30 Min	8hours	8 hours	7 Days

### REGULATORY DATA

Flash Point	Base (Part A)	C/A (Part B)	Mixed
	36°C (97°F)	31°C (88° F)	35°C (95°F)

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### SYSTEMS COMPATABILITY

Can be over coated by- Pentadur MIO Series  
Pentadur Epoxy Top Coat  
Pentathane Topcoats series  
Pentaline Series of Top Coats

### SURFACE PREPARATION

The performance of this product will depend upon the degree of surface preparation. The surface to be coated must be clean, dry and free from contamination. Prior to paint application all surfaces should be assessed and treated in accordance with ISO 8504:1992. Accumulated dirt and soluble salts must be removed.

#### Abrasive Blast Cleaning

For atmospheric exposure performance will be achieved when **Pentadur HB 8531 Primer** is applied to surfaces prepared to a minimum of Sa2½ (ISO 8501-1:1988) or SSPC-SP 10. Surface defects revealed by the blast cleaning process, should be ground, filled or treated in the appropriate manner. A surface profile of 50-65 microns (2- 3 mils) is recommended.

### APPLICATION

<b>Mixing</b>	Material is supplied in two containers as a unit. Always mix a complete unit in the proportions supplied. Once the unit has been mixed it must be used within the working pot life specified. (1) Agitate Base (Part A) with a power agitator. (2) Combine entire contents of Curing Agent (Part B) with Base (Part A) and mix thoroughly with power agitator
<b>Mix Ratio</b>	05 (Part A): 01(Parts B) by volume
<b>Working Pot Life</b>	30° C (86° F) 8 hours
<b>Airless Spray</b>	Recommended - Tip range 15-23 thou) - Total output fluid pressure at spray tip not Less than 176 kg/cm2 (2,500 p.s.i)
<b>Brush</b>	Recommended Typically 40-75 microns
<b>Thinner</b>	Thinner 145 Do not thin more than allowed by local Environmental legislation.
<b>Clean Up</b>	Clean up all equipment immediately after use with Thinner 145. 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. All surplus materials and empty containers should be diagnosed of in accordance with appropriate regional regulations / legislation.

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### **SAFETY PRECAUTIONS**

This product is intended for use only by professional applicators in industrial situations in accordance with the advice given on this sheet, the Material Safety Data Sheet and the container(s), and should not be used without reference to the Material Safety Data sheets (MSDS) which Grauer & Weil India Ltd has provided to its customers.

All work involving the application and use of this product should be performed in compliance with all relevant national, Health, Safety and Environmental standards and regulations.

In the event 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.

If in doubt regarding the suitability of use of this product, consult Grauer & Weil India Ltd for further advice.

### **PACK SIZE**

20 litres unit                      **Pentadur HB 8531**

### **STORAGE**

Shelf Life 12 months minimum at 25 deg C (77 deg F). Store in cool & Dry place

#### **Disclaimer**

*The data provided in this sheet is not intended to be exhaustive and any person using the product for any purpose other than that specifically recommended in this sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. While we endeavour to ensure that all advice we give about the product either in this sheet or otherwise is correct we have no control over either the quality or condition of the substrate or the many factors affecting the use and application of the product.*

*Therefore, unless we specifically agree in writing to do so, we do not accept any liability whatsoever or howsoever arising for the performance of the product or for any loss or damage arising out of the use of the product. The information contained in this sheet is liable to Change from time to time in the light of experience and our policy of continuous product development.*

*It is the user's responsibility to check that this sheet is current prior to using the product. Issue date : April 2011*