

Pentadur HB 8530 Primer

Epoxy based Zinc Phosphate Primer

PRODUCT DESCRIPTION

Pentadur HB 8530 Two pack polyamide cured, epoxy resin rich anticorrosive High Build primer containing zinc phosphate pigment. This is designed to provide high over coating interval due to presence of reinforced resin system

INTENDED USES

The primer gives excellent adhesion to blast cleaned 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 also recommended for structures under fuming contact of acid & Alkali in bleaching and pickling plants in paper and pulp /electrolytic battery plants. Due fast curing & drying properties it can be recoated in less time than the other conventional primers.

PRACTICAL INFORMATION FOR Pentadur HB 8530 Primer

Color	Red Oxide
Gloss Level	Matt
Volume Solids	60% ± 2%
Typical Thickness	75-100 microns Per Coat
Theoretical Coverage	8 m ² /liter Per Coat at 75 microns thickness
Practical Coverage	Allow appropriate loss factors
Method of Application	Airless spray, Brush

Drying Time & Over Coating Intervals.

Temperature	Surface Dry		Over coating Interval of Pentadur HB 8530 Primer	
	Hard Dry	Hard Dry	Minimum	Maximum
25°C (77°F)	45 Min	4 hours	6 hours	6-8 Months
35°C (95°F)	30 Min	3 hours	5 hours	6-8 Months

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 overcoated by- Pentadur MIO Series
Pentadur Epoxy Topcoat
Pentathane Topcoats series

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 8530 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

Mixing 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

Working Pot Life	15° C (59° F) 5 hours	25°C (77°F) 4 hours	40° C (104° F) 2 hour
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Airless Spray	Recommended	- Tip range 15-23 thou) - Total output fluid pressure at spray tip not Less than 176 kg/cm2 (2,500 p.s.i)
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Brush	Recommended	Typically 50-75 microns
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Thinner	Thinner 145	Do not thin more than allowed by local Environmental legislation.
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Clean Up 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 material 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

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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 2010