FEIDOPOX PRIMER ZG64-A6

2C epoxy primer

FEIDOPOX PRIMER ZG64-A6 is a high-quality 2C primer based on epoxy resin, containing solvents and active anticorrosive pigments such as zinc phosphate.

It is characterized by fast drying, very good levelling, and excellent corrosion protection. The product is suitable for a wide range of industrial applications.
Suitable for various types of structural steel, and in case of adequate surface preparation also for galvanized steel components. Typical fields of application include crane construction, equipment in the chemical and petrochemical industries, steel structures for hydraulic engineering, shipbuilding, and mining.

TECHNICAL DATA

Fields of application	Machinery, Ship, Steel constructions, Submerged constructions, Subterranean constructions, Storage tank
Recommended substrate	Steel, Zinc
Binder	Epoxy
Solids	47 ± 2% by volume (depending on the colour shade)
Volatile organic compound (VOC)	Approx. 448 g/l (DIRECTIVE 2010/75/EU) The VOC value provided is the average value for factory produced products, and consequently it will be subject to variations between individual products covered by this Technical Data Sheet.
Theoretical spreading rate	

Dry film (µm)	Wet film (µm)	Theoretical spreading rate (m^2/l)
60	125	7.8
80	170	5.9

Practical spreading rate	The values depend on the application technique, surface conditions, overspray, etc.
Colours	Grey, sandyellow, light grey, oxide red. Other colours by agreement.
Gloss (60°)	Matt, Semi-matt
Hardener	Comp. B: FEIDOPOX HARDENER ZH40
Mixing ratio (A:B)	6:1 parts by weight
Pot life	Approx. 8 h (+20°C)
Thinner	FEIDOSOLV VK14
Density	Approx. 1.5 g/ml (depending on the colour shade)

Storage	Storage stability is 1 year in unopened package. Store in a cool place and in tightly closed containers. Most suitable storage temperature is +5°C - +25°C. Protect from heat and freeze!

DIRECTION FOR USE

Surface preparation	Remove from the surfaces any contaminants that might be detrimental to surface preparation and application. Remove also water-soluble salts by using appropriate methods. STEEL SURFACES: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1). Residues that may weaken adhesion, such as oil, grease, dust must always be carefully removed before application. ZINC SURFACES: Hot-dip-galvanized steel structures that are exposed to atmospheric corrosion can be painted if the surfaces are sweep blast-cleaned (SaS) till matt all over. Suitable cleaning agents are, e.g. aluminium oxide and natural sand. It is not recommended according to standard ISO 12944-5 to paint hot-dip-galvanized objects that are subjected to immersion strain. Painting of hot-dip-galvanized objects that are subjected to immersion strain must be discussed separately with Teknos. The place and time of the preparation are to be chosen so that the prepared surface will not get dirty or damp before the subsequent treatment. Additional instructive information for surface preparation can be found in standards EN ISO 12944-4 and ISO 8501-2.
Application method	Airless spraying, Air-assisted airless spraying, Conventional spraying, Brush, Roller

Application

Take into consideration the pot life of the mixture when estimating the amount to be mixed at a time. Before application the base and hardener are mixed in right proportion. Stir thoroughly down to the bottom of the vessel. Mixing by machine is recommended, for example a slow-rotating hand-drill equipped with a mixer. Inadequate stirring or incorrect mixing ratio results in imperfect curing and impaired film properties.

Stir thoroughly before use.

	Airless spray	Air-assisted airless spray	Conventional spray
Thinner	0 – 10 % FEIDOSOLV VK14	0 – 10 % FEIDOSOLV VK14	0 – 10 % FEIDOSOLV VK14
Application viscosity	as delivered	as delivered	25 – 35 s DIN 4
Nozzle	0.015 – 0.019"	0.015 – 0.019"	1.5 – 1.8 mm
Paint pressure	120 bar	120 bar	–
Air pressure	–	2.5 – 3.0 bar	3.0 – 4.0 bar

Application conditions

The surface to be treated must be dry. During the application and drying period the temperature of the ambient air, the surface and the product shall be above +15 °C and below +35 °C and the relative air humidity below 85%. The temperature of the surface to be treated must be at least +3 °C above the dew point of the ambient air. During application good ventilation is recommended.

Drying time

- dust free

+20 °C / 65% RH (dry film 60 µm)
approx. 50-60 min

- touch dry

approx. 3-4 h

Overcoatable

Surface temperature	By itself or by topcoats of the FEIDOPOX, FEIDOPUR or FEIDOPLAST series	
	Min.	Max.
+20 °C	4 h	-

Given indications relates to the recommended coating thickness, drying in good ventilation conditions. Overcoating times may be different with a change of temperature, ventilation, number of layers and the thickness of the coating.

Cleaning

FEIDOSOLV VK14

HEALTH AND SAFETY

Safety and precaution measures

See safety data sheet.

Teknos Group Oy Takkatie 3, P.O.Box 107 FI-00371 Helsinki, Finland Tel. +358 9 506 091