

# Technical Data

## PRIMASTIC



### Product description

Primastic is a two-pack, high solids modified epoxy coating. Available with two different hardeners for varying substrate temperatures, Standard (Std) and Cold Climate (CC).

### Recommended use

Anticorrosive primer for steel and concrete structures above water, also on steel where blastcleaning may not be possible.

### Film thickness and spreading rate

Standard comp. B	Minimum	Maximum	Typical
Film thickness, dry ( $\mu\text{m}$ )	100	250	125
Film thickness, wet ( $\mu\text{m}$ )	130	320	160
Theoretical spreading rate ( $\text{m}^2/\text{l}$ )	7.8	3.1	6.2

Cold climate comp. B	Minimum	Maximum	Typical
Film thickness, dry ( $\mu\text{m}$ )	100	250	125
Film thickness, wet ( $\mu\text{m}$ )	140	350	175
Theoretical spreading rate ( $\text{m}^2/\text{l}$ )	7.2	2.9	5.7

### Physical properties

Colour	Limited number
Solids (vol %)*	78 $\pm$ 2 Standard climate hardener 72 $\pm$ 2 Cold climate hardener
Flash point	35°C $\pm$ 2 Standard Comp. B (Setaflash) 31°C $\pm$ 2 Cold Climate Comp. B (Setaflash)
Gloss	Semigloss
Gloss retention	Fair
Water resistance	Good
Abrasion resistance	Very good
Solvent resistance	Good
Chemical resistance	Good
Flexibility	Good

\*Measured according to ISO 3233:1998 (E)

## Surface preparation

All surfaces should be clean, dry and free from contamination. The surface should be assessed and treated in accordance with ISO 8504.

### **Bare steel**

Cleanliness: Power tool cleaning to min. St 2, mill scale free (ISO 8501-1:1988). Improved surface treatment (blast cleaning to Sa 2½) will improve the performance.

### **Shopprimed steel**

Clean, dry and undamaged approved blast-primer.

### **Coated surfaces**

Clean, dry and undamaged compatible primer. Contact your local Jotun office for more information. For maintenance UHPWJ to WJ2 (NACE No.5/SSPC-SP 12) or Power tool cleaning to min. St 2 for rusted areas

### **Other surfaces**

The coating may be used on other substrates. Please contact your local Jotun office for more information.

## Condition during application

The temperature of the substrate should be minimum +10°C (Std) (-5°C in CC) and at least 3°C above the dew point of the air, temperature and relative humidity measured in the vicinity of the substrate. Good ventilation is required in confined areas to ensure proper drying.

## Application methods

- |               |  |
|---------------|--|
| <b>Spray</b>  | Use airless spray  |
| <b>Brush</b>  | Recommended for stripe coating and small areas, care must be taken to achieve the specified dry film thickness.  |
| <b>Roller</b> | May be used for small areas but not recommended for first primer coat, however when using roller application care must be taken to apply sufficient material in order to achieve the specified dry film thickness. |

## Application data

### Mixing ratio (volume)

7 parts by volume Comp. A (Base) to 1 part Standard Comp. B (hardener)

4 parts by volume Comp. A (Base) to 1 part Cold Climate Comp. B (hardener)

### Induction time

10 minutes.

### Pot life (23°C)

2 hours (standard Comp. B)

1 hour (cold climate Comp. B)

### Thinner/Cleaner

Jotun Thinner No. 17

### Guiding data airless spray

#### Pressure at nozzle

15 MPa (150 kp/cm<sup>2</sup>, 2100 psi.)

#### Nozzle tip

0.58 - 0.79 mm (0.023 - 0.031")

#### Spray angle

40 - 80°

#### Filter

Check to ensure that the filters are clean

#### Note

\* The temperature of the mixture of base and curing agent is recommended to be at least 15°C, otherwise extra solvent may be required to obtain correct viscosity.

\* Too much solvent results in lower sag resistance and slower cure.

\* If extra solvent is necessary, this should be added after mixing of the two components.

## Drying time

Drying times are generally related to air circulation, temperature, film thickness and number of coats, and will be affected correspondingly. The figures given in the table are typical with:

\* Good ventilation (Outdoor exposure or free circulation of air)

\* Typical film thickness

\* One coat on top of inert substrate

### Normal hardener

Substrate temperature	10°C	23°C	40°C
Surface dry	8 h	4 h	2 h
Through dry	24 h	10 h	4 h
Cured	14 d	7 d	2 d
Dry to recoat, minimum	24 h	10 h	4 h
Dry to recoat, maximum <sup>1</sup>			

### Cold temperature hardener

Substrate temperature	-5°C	0°C	5°C	10°C	23°C
Surface dry	24 h	18 h	12 h	6 h	2.5 h
Through dry	48 h	26 h	18 h	12 h	5 h
Cured	21 d	14 d	7 d	3 d	2 d
Dry to recoat, minimum	48 h	26 h	18 h	12 h	5 h
Dry to recoat, maximum	-	-	-	-	-

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, underlying paint system, requirement for early handling and mechanical strength etc. A complete system can be described on a system sheet, where all parameters and special conditions could be included.

## Typical paint system

Primastic 2 x 125 µm (Dry Film Thickness)  
Hardtop AS 1 x 50 µm (Dry Film Thickness)

Other systems may be specified, depending on area of use

## Storage

The product must be stored in accordance with national regulations. Storage conditions are to keep the containers in a dry, cool, well ventilated space and away from source of heat and ignition. Containers must be kept tightly closed.

## Handling

Handle with care. Stir well before use.

## Packing size

16 L. Comp. A and 2,3 L. Standard Comp. B or 4 L. Cold Climate Comp B.  
Packing may vary from country to country according to local requirements.

## Health and safety

Please observe the precautionary notices displayed on the container. Use under well ventilated conditions. Do not breathe or inhale mist. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water and medical attention sought immediately.

**For detailed information on the health and safety hazards and precautions for use of this product, we refer to the Material Safety Data Sheet.**

## DISCLAIMER

*The information in this data sheet is given to the best of our knowledge based on laboratory testing and practical experience. However, as the product is often used under conditions beyond our control, we cannot guarantee anything but the quality of the product itself. We reserve the right to change the given data without notice.*

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