

## Application Procedure of blast free epoxy

This primer is practicable for places that sand blast cannot be performed because of air pollution, noises and other problems.

**1. Cleaning surface :** in order to apply this coating, the surface must be clean and dry. All dirt, grease, mill scale and any other foreign materials should be removed by power tools cleaning shall be according to ST<sub>3</sub> (ISO 8501-1:1988)

1.1. If the amount of contamination is low, it must be cleaned by lint-free cloth which is soaked in the solvent.

1.2. If contamination to be severe, it must be washed by alkaline solution and then rinsed with water and dried with fresh air.

**2. Cleaning with power tools :** the surface must be cleaned by power tools such as power sanders, the hummer for removing oxides, and other tools so that metal shells and rust that have poor adhesion to the metal surface and the remaining paint are completely removed.

2.1. Clean the surface by vacuum or high pressure air until tape test is accepted.

2.1.1. Select 10 cm of masking tape and then paste 5 cm of it on the surface.

2.1.2. Press the masking tape on the surface by your thumb with adequate force.

2.1.3. Remove the tape at once.

2.1.4. Look at behind the tape. if the contamination not to be seen, the cleanliness of surface is accepted.

**3. Implementation of paint by conventional spray :**

3.1. Preparation of paint

3.1.1. Blast free epoxy coating has two basic compounds:

Compound A (base of paint) and compound B (hardener)

3.1.2. First stir both two compounds well.

**R  
A  
N  
G  
A  
N  
  
F  
A  
R**

3.1.3. Add compound B slowly to compound A while stirring it.

3.1.4. Dilute the paint with little amount of thinner and then, after 20 minutes, the paint is ready to apply.

“Attention”

3.2.1. Since the pot life is limited and shortened by high temperatures, do not mix more material than will be used in 4 hours at 25<sup>o</sup>C .

3.2.2. by conventional spray : industrial equipment with suitable air cap having a fluid tip with a 1.6-1.8 mm orifice

3.2.3. The pressure beyond the nozzle should be 50-70 PSI

3.2.4. The distance between conventional spray and surface should be 15-25 cm.

3.2.5. Put the spray perpendicularly to the surface, pull the trigger and move spray uniformly.

3.2.6. The next move must be performed by 50% overlapping.

3.2.7 Set the rate of hand moving so that the paint dose not sag.

3.2.8. If the thickness of paint was thin, the paint must be applied perpendicularly above layer.

3.2.9. Estimate the dry film thickness by measuring the wet film thickness gauge.

3.2.9.1. In case of insufficient DFT please wait until recoat time and then apply the primer coat

3.2.9.2. in case of insufficient DFT to run the intermediate layer you can wait until recoat time

At the end, clean all equipments with cleaner immediately after use.

**R  
A  
N  
G  
A  
N  
  
F  
A  
R**