



**RANGAN FAR CO.**  
MANUFACTURER OF INDUSTRIAL PAINTS

FARCO PRIME 107- 5

## RED IRON OXIDE ZINC PHOSPHATE EPOXY PRIMER

### Product information

- 1-Poly amide epoxy primer.
- 2-Excellent rust inhibitive shop primer in corrosive environments.
- 3-High chemical and water resistance.

### Physical data

Colour:	red - brown		
Finish:	Flat		
Flash point:			
resin:	34 °C		
cure:	36 °C		
solvent:	28 °C		
Volume solids:	60±5%		
D.F.T:	60 -70   microns		
Specific gravity(mixed):	1.68± 0.08gr/cm <sup>3</sup>		
Theoretical coverage:	10 m <sup>2</sup> /lit (at 60 µ D.F.T)		
Drying time at 25°C:			
touch dry:	2 hrs		
dry to handle:	6-8hrs		
full cure:	7days		
Component:	2		
Pot life:	8 hrs at 25 °C;		
Mixing ratio(by volume):			
resin:	refer to can label		
cure:	refer to can liable		
Application methods:	conventional spray or brush or airless spray or roller		
Recoat intervals*:	10 °C	25 °C	40 °C
(mild condition) : Min:	25 hrs	12 hrs	5 hrs
Max:	70 hrs	36 hrs	18 hrs
Recommended thinner:	FARCO THINN 10		
Recommended cleaner:	FARCO CLEAN 10		
Curing mechanism:	by solvent release and reaction by curing agent and resin		
Substrate:	steel		

\*: For recoating the surface should be free of dust ,grease and contamination .

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## Typical uses

As a blast primer for epoxy systems According to specification.  
Structural steel,machinery,pipes and tank exteriors  
decks,hulls,bottoms and super structures  
of ships,barges and work boats,offshore platforms and related structures.

## Application information

This Rangan Far's product is a red iron oxide epoxy primer for industrial and marine use.

To obtain the maximum performance for which this product is formulated,strict adherence to all application,instructions, precautions,conditions and limitations is necessary.

## Application equipment

The following equipment is listed as a guide and suitable equipment from other manufactures may be used.

adjustments of pressure and change of tip size may be

Needed to obtain the proper spray characteristics.

1-Airless spray:standard airless spray equipment having  
a 28:1 or higher pump ratio and a fluid tip with a 0.017 to 0.019 inch orifice.

2-Conventional spray:Industrial equipment with suitable  
aircap having a fluid tip with a 1.8-2 mm orifice .

3 -Mixer: mixer must be powered by an air motor or an explosion proof electric motor.

4-Brush or roller.

## Caution

1-Handle with care.

2-Avoid inhalation of possible solvent vapours or  
paint mist, as well as paint contact with skin and eyes.

3-Apply only in well ventilated areas and ensure that  
adequate forced ventilation exists when paint applies is  
in confined spaces or when the air is stagnant.

4-Always take precautions against the risks of fire and explosions.

5-Harmful or fatal if swallowed,immediately seek medical assistance.

6-Use fresh air masks and explosion proof equipment.

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## **Application procedures**

- 1-Flush equipment with cleaner before use.
- 2-Stir resin to an even consistency with a power mixer.
- 3-Add cure to resin and continue stirring for 5 minutes.  
Note: since the pot life is limited and shortened by high
- 4- Thinning with FARCO THINN 10 as needed for workability.
- 5-Stir during application to maintain uniformity of material  
and apply a wet coat in even parallel passes after 20 minutes.
- 6-Clean all equipment with cleaner immediately after use .

## **Environmental condition**

Environmental temperature must be 10-40°C.  
Surface temperature must be at least 3°C above dew point  
to prevent condensation. At freezing temperature surface  
must be free of ice and relative humidity below 80 %.

## **Surface preparation**

Blasting to a standard  
Sa 2.5 – Sa3 , SIS 05 5900 , ISO 8501-1.  
The surface profile must be min 50 -75 micron.

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