



## ZINC PHOSPHATE EPOXY POLYAMINE PRIMER

### Product information

- 1-Poly amine epoxy primer.
- 2-excellent adhesion to steel structure.
- 3-Excellent rust inhibitive shop primer in corrosive environments.
- 4-excellent resistance to water,solvent and chemicals product.

### Physical data

Colour: White  
Finish: Flat  
Flash point:  
    resin: 34<sup>°</sup>C  
    cure: 36<sup>°</sup>C  
    solvent: 28<sup>°</sup>C

Volume solids: 65±5%  
D.f.t: 60 - 70 microns  
Specific gravity(mixed):: 1.43± 0.08gr/cm<sup>3</sup>  
Theoretical coverage: 10.83 m<sup>2</sup>/lit (at 60 µ d.f.t)

Drying time at 25<sup>°</sup>C:  
    touch dry: 6 hrs  
    dry to handle: 24hrs  
    full cure: 7 days

Component: 2

Pot life: 4 hrs at 25<sup>°</sup>C:

Mixing ratio(by volume):  
    resin: refer to can label  
    cure: refer to can label

Application methods: conventional spray or  
airless spray or roller

Recoat intervals*:	10 <sup>°</sup> C	25 <sup>°</sup> C	40 <sup>°</sup> C
(mild condition) : Min:	20 hrs	9 hrs	4 hrs
Max:	74 hrs	24 hrs	10 hrs

Recommended thinner: FARCO THINN 11  
Recommended cleaner: FARCO CLEAN 11

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 heavy duty epoxy systems according to specification.

Other uses are:

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 polyamine cured zinc phosphate 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 0.457 to 0.660 mm 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- 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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**RANGAN FAR CO.**  
MANUFACTURER OF INDUSTRIAL PAINTS

**FARCO PRIME 115**

## **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 temperatures, do not mix more material than will be used in 4 hours at 25 °C.
- 4- Thinning with FARCO THINN 11 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 standard of Sa 2.5 – Sa3 , SIS 05 5900 , ISO 8501-1.  
The surface profile must be min 50 -75 micron

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