

FARCO PRIME 502-N

INORGANIC ZINC SILICATE PRIMER

Grey

Flat

50-75 microns 3.05 ±0.1 gr/cm³

min3 hrs at 20°c

Refer to can label

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FARCO THINN 50

FARCO CLEAN 50

Brush or airless spray,

after full cure, min 5 days

12.2 m²/lit (at 50µ d.f.t)

10-15 min (at relative humidity 65%)

2 hrs (at relative humidity 65%)

5 days (at relative humidity 65%)

Product information

- 1-Outstanding resistance against weathering and abrasion.
- 2-Excellent chemical resistance with in PH range 5.5-9.5.
- 3-Offers cathodic protection of local mechanical damage.
- 4-Low voc.
- 5-Resist temperatures up to 400°c

Physical data

Colour: Finish: Flash point: resin:

> cure solvent:

Volume solids: D.f.t: Specific gravity(mixed):

Theoretical coverage: Drying time at 20°

touch dry: dry to handle : full cure:

Component:

Pot life: Mixing ratio(by volume):

> resin: powder:

Application methods:

Recoat intervals at 20°c *: (mild condition):

(at relative humidity 65%)

Recommended thinner

Recommended cleaner:

Curing mechanism:

By solvent release and reaction with atmospheric moisture

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

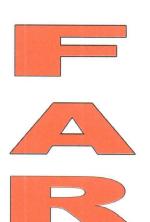
Prior to overcoating, verify a value of 4 via ASTM D4752 MEK rub test. Before overcoating with recommended topcoats ensure the FARCO PRIME 502-N

Is fully cured . at relative humidities below 65% curing will be retarded.

.Pls for more information look at the FARCO PRIME 502-N

application guidelines. If weathering has occurred all zinc salts should be removed from the







Surface by fresh water washing and if necessary scrubbing with bristle brushes. In some cases it may be necessary to apply a mist coat of suitable viscosity to minimize bubbling.

Typical uses

As a general purpose rust preventing primer in paint systems.

For long-life protection of steel exposed to moderately to severely corrosive environment.

Application information

This Rangan Far's product is a inorganic zinc silicate coating for industrial and marine use. It combines the proven corrosion control properties of an inorganic zinc silicate with environmental compatibility. 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 fine finish tip with a 0.48 mm to a 0.55 mm or larger.
- 2-Mixer:mixer must be powered by an air motor or an explosion proof electric motor.

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 applying paint

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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.

Application procedure

- 1-Flush equipment with recommended cleaner before use.
- 2-Stir resin to an even consistency with a power mixer.
- 3-Add zinc dust to resin little by little 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 3 hours at 20 $^{\circ}$ c.

- 4-Stir during application to maintain uniformity of material and apply a wet coat in even parallel passes.
- 5-Clean all equipment with cleaner immediately after use or at least at the end of each working day or shift.

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.

Surface preparation

All surfaces to be coated should be clean ,dry, and free from contamination. Oil or greases should be removed in accordance with SSPC SP1 solvent cleaning. Blasting to standard of Sa 2.5-Sa3, SIS $05\,5900$, ISO 8501-1. If oxidation Has occurred between blasting and application of FARCO PRIME 502-N,

The surface should be reblasted to the specified visual standard.

A surface profile of 70 ±5 microns is recommended.

-All damaged areas should ideally be blast clean to Sa $2.5\,$ (ISO 8501-1).

Repair of the damaged area can then be carried out using a recommended Zinc rich epoxy primer.

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