



INORGANIC ZINC SILICATE PRIMER

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:	Grey
Finish:	Flat
Flash point:	
resin:	11°C
cure:	-
solvent:	-
Volume solids:	60 ±2%
D.f.t:	50-75 microns
Specific gravity(mixed A,C):	2.9 ±0.1 gr/cm ³
Theoretical coverage:	12 m ² /lit (at 50µ d.f.t)
Drying time at 20°C:	
touch dry:	10-15 min (at relative humidity 65%)
dry to handle :	2 hrs (at relative humidity 65%)
full cure:	5 days (at relative humidity 65%)
Component:	3(A,B,C)
Pot life:	min3 hrs at 20°C
Mixing ratio(by volume):	
resin:	Refer to can label
powder:	Refer to can label
Application methods:	Brush or airless spray
Recoat intervals at 20°C *:	after full cure , min 5 days
(mild condition) :	
(at relative humidity 56%)	
Recommended cleaner:	FARCO CLEAN 50
Curing mechanism:	By solvent release and reaction with atmospheric moisture
Substrate:	Steel

*: 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 502-3

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

.Pls for more information look at the FARCO PRIME 502-3

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

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*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 (component A) to an even consistency with a power mixer.
- 3-Add zinc dust(component C)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 °C.

- 4-Add (component B) to above mix and continue stirring for 5 minutes .
- 5-Stir during application to maintain uniformity of material and apply a wet coat in even parallel passes.
- 6-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 502-3 , 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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