Chem Coats (Pvt) Ltd.

ChemCoat 384

Epoxy zinc phosphate primer

DESCRIPTION

Two-component, solvent-borne polyamide cured epoxy with corrosion inhibitive pigments.

Uses

As a primer coat on steel prior to application of epoxy or polyurethane coatings or single-pack anti-corrosive coatings.

Benefits

- Exhibits excellent corrosion protection of steel.
- Contains corrosion inhibitive pigments.
- Easily over coated with decorative epoxy or polyurethane twin-packs.
- Good pot life allows for flexibility during application.

SURFACE PREPARATION

Steel should preferably be abrasive blast cleaned to a minimum standard of SA 2.5 of Swedish Code of Practice SIS 055900. The anchor pattern should be approximately 40 – 60 microns. If hand cleaning is used, nothing less than a SA 3 finish is acceptable. However, this method of cleaning will significantly reduce the life of the system.
All metal to be coated must be clean, mechanically sound and dry.

BONDING / PRIMING

The product is a primer.

MIXING

Stir contents of each container, particularly the base, very well. Add the activator to base and stir together for at least five minutes using a flat paddle. It has been found that mechanical mixing gives better dispersion than manual mixing. A suitable mixing method would be a slow speed electric drill (approximately 200 r/min) fitted with a paddle. If only part of a kit is to be used, add one volume of activator to 4 volumes of base. Measuring must be accurate and separate stirrers used for proportioning each component.
The mixed material must be left to stand in a cool place for 20 minutes prior to application.

COVERAGE

8m^2/l.

APPLICATION

By brush or airless spray. In the latter case, a tip of approximately 250 µm size may be used. **ChemCoats 384** should not be applied if the ambient temperature is below 10°C. The curing reaction will not proceed at low temperature. If surfaces are not at least 2° C above dew point, there is every chance that a film of condensed moisture may be present. This will interfere with the

PROPERTIES DURING APPLICATION	
Application by	Brush or airless spray.
Pot life	8 hours/5l
Induction period	Allow to stand for 30 minutes in shade after mixing
Volume solids (typical)	50 %
Recommended average DFT per coat	40 µm
Theoretical coverage for above dft	12 m^2/l on smooth surface
Wet film thickness at above	80 µm
Practical coverage for estimating purposes	8 – 10 m^2/l
Salt spray resistance	Good with no blistering, wrinkling or loss of adhesion and no corrosion of test panel (visible or under the film, i.e. creep)
Recommended no of coats	2 – 3 coats, depending on anchor pattern and use, e.g. Constant submersion
Dry time @ 25º C	Touch dry – 1 - 2 hours Hard dry - 12 hrs Full cure - 7 days
Over coating time @ 25º C	Min : 8 hrs Max : 48 hrs
Application temp. Range	10º C – 40º C
Fire resistance of wet film	Flammable
Do not apply	If humidity is in excess of 85 %
Do not apply	If surface is less than 2º C above dew point

CHEM COATS PRIVATE LIMITED Monnoo Chowk, Defence Road, Off Raiwind Road, Near Nobel TV, Lahore, Pakistan. Tel: +92 42 35322201-03 Fax: +92 42 35322204
www.chemcoats.com.pk, Email: info@chemcoats.com.pk

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PROPERTIES OF WET MATERIAL	
Mixing ratio	4 base : 1 activator by volume
Density (typical)	1.40 g/cm^3
Flash point	25º C
Dilution	ChemCoat Thinners no 3 but not normally needed
Consistency	Low viscosity liquid
Toxicity	Uncured material is toxic
Storage conditions	Store under cover in cool conditions

adhesion of the coating. Wet film thickness as per recommendation should not be exceeded as this can result in solvent entrapment, as can too early over coating. Solvent entrapment in the film can lead to disastrous performance. Stir frequently during use.

CLEANING

Tools can be cleaned with **ChemCoats super brush cleaner** before material has cured.

PROTECTION ON COMPLETION

Against traffic and spillage until cured.

TEMPERATURE AND RELATIVE HUMIDITY

See “Application” and “properties during application”.

MODEL SPECIFICATION

Two component epoxy zinc phosphate primer for metal surfaces. The coating shall be **ChemCoats 384,** a two component epoxy zinc phosphate primer applied to prepared metal surfaces in accordance with the manufacturers recommendations, **Chem Coats Construction Chemicals.**

PACKAGING

ChemCoats 384 is supplied in 5l kits.

HANDLING & STORAGE

This product has a shelf life of 12 months if kept in a dry cool place under cover in the original packaging. In more extreme conditions this period might be shortened.

HEALTH & SAFETY

Wet **ChemCoats 384** is toxic and flammable. Always ventilate the working area well during application and drying. Avoid flames in vicinity. Always wear gloves and eye protection when working with the material and avoid excessive inhalation and skin contact.
If material is splashed in the eye, wash with copious quantities of clean water and seek medical attention.
When transporting liquids and semi liquids by aircraft, ask for material safety datasheet.
Cured **ChemCoats 384** is inert and harmless.

IMPORTANT NOTE

The information given in this data sheet is based on current development work and many years of field experience. Whilst every effort is made to ensure that the information is reliable, we cannot accept responsibility for any work carried out with our materials as we have no controls over methods of applications, site conditions etc. In view of the continuing research and development being undertaken in our laboratories we advise customers in their own interest to ensure that this data sheet has not been superseded by a more up-to-date publication. All products are sold subject to our standard conditions of sale which are available on request. Field services, where provided, does not constitute supervisory responsibility. For additional information, please contact your local **Chem Coat's** representative.

RANGE OF PRODUCTS

WATERPROOFING SYSTEMS INDUSTRIAL FLOOR SURFACES PROTECTIVE COATINGS	PREPACKED REPAIR MORTARS CEMENTITIOUS & EPOXY GROUTS CONCRETE ADMIXTURES	SEALANTS CRACK INJECTION CONCRETE ADHESIVE

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