

Aquapoxy™ Primer

Water Based, Epoxy Primer

SPECIFICATIONS

DESCRIPTION:

Aquapoxy™ Primer provides excellent adhesion to previously painted surfaces, concrete, and various ferrous and nonferrous substrates where conventional primers may cause adhesion failures. This primer exhibits good flow and leveling characteristics. It is a two-part, water reducible, VOC compliant, epoxy.

Aquapoxy™ Primer is a high performance primer for:

- zinc
- galvanizing
- inorganic zinc rich
- copper
- brass
- aluminum
- fiberglass

USE:

Aquapoxy™ Primer uses include:

- exterior structures, ferrous and nonferrous
- bridges
- power line towers
- microwave towers
- metal buildings
- structural steel components
- large fabricated structures

COLOR AVAILABILITY:

Aquapoxy™ Primer 283PAJ60 is available in light green.

ORDER CODE: [Mix Ratio: 1 Part A :1 Part B, by volume]

Part A [light green] 283PAJ60
Part B [activator] 283B

Individual products are identified by the product series number, followed by an identifier and color number.

PACKAGING:

Part A:	Part B:
1 gallon cans	1 gallon cans
5 gallon pails	5 gallon pails
55 gallon drums	55 gallon drums

ADVANTAGES:

- Long term corrosion protection
- Excellent adhesion to properly prepared iron and steel substrates
- Very low VOC
- Contains no lead or chromate
- Low toxicity
- Water cleanup

LIMITATIONS:

- Not for use in submersion applications
- Must be topcoated and protected from UV exposure
- Not recommended for application below 50° F or above 100° F or within 5° F of the dew point
- Maximum RH at worksite: 75%

PROPERTIES

DRY SCHEDULE: [at 50% RH and 2.0 mil DFT]

	60° F	77° F	90° F
Dry to Touch	90 mins	60 mins	45 mins
Recoat	8 hrs	4 hrs	2 hrs
Dry to Handle	72 hrs	24 hrs	12 hrs
Full Cure	7 days	7 days	7 days

Critical Recoat Window: After four days mechanically abrade all surfaces and power wash.

VOC: [mixed, as supplied] 83 g/l (0.7 lbs/gal)

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FLASH POINT: [setaflash] > 220° F

WEIGHT PER GALLON: [mixed] 10.1 lbs

PACKAGE VISCOSITY: [as applied]

3 Zahn Seconds 35

SOLIDS: [average]

% By Weight 43.7 ± 2%

% By Volume 34.1 ± 2%

COVERAGE: [average]

Theoretical at 2.0 mil DFT 274 sq ft/gal

REQUIRED FILM THICKNESS:

ASTM D1005 Minimum Dried Film 2-3 mil (48-72µ)

ASTM D4414 Minimum Wet Film 6-9 mil (144-216µ)

ASTM D523 GLOSS:

@ 60° 15-20

@ 20° N/A

ASTM D3363 PENCIL HARDNESS:

H Pass

ASTM D5402 MEK RUBS:

40 Double Pass

ASTM D2794 IMPACT RESISTANCE:

60 inlb forward, 60 inlb reverse Pass

ASTM B117 SALT SPRAY RESISTANCE:

5% Salt Spray, 300 hours Pass

ASTM D5894UV CORROSION WEATHERING:

ASTM D610 Rusting 7 cycles, 300 hours N/A

ASTM D714 Blistering 7 cycles, 300 hours N/A

ASTM D4587/D523/D4214 QUV-UVA

500 hours @ 60° N/A

1000 hours @ 60° N/A

ASTM D2247/D714 HUMIDITY RESISTANCE:

600 hours [unscribed] Pass

ASTM D4585 MOISTURE CONDENSATION:

100° F, 400 hours Pass

ASTM D3359 ADHESION:

5B Pass

ASTM D4060 ABRASION RESISTANCE:

CS17 wheel, 140 cycles, 1 kg load Pass

ASTM D522 FLEXIBILITY:

180° bend, 1/8" mandrel Pass

ASTM D3170 CHIP RESISTANCE:

Rating N/A

ASTM D2485 DRY HEAT RESISTANCE:

275° F Pass

WET HEAT RESISTANCE:

200° F Non-immersion Pass

ASTM D2243 WATER-BORNE FREEZE THAW:

3 cycles Pass

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APPLICATION DATA

SURFACE PREPARATION:

All surfaces must be clean, dry, and free of contaminants. All dirt, grease, rust, mill scale, or loose chalky paint must be removed.

The retrieval and analysis of soluble salts on substrates shall be conducted in accordance with "SSPC: The Society for Protective Coatings," rule. The substrate must be cleaned so that the maximum level of soluble salts does not exceed 5 micrograms per square centimeter. Areas should be tested at the rate of 3 tests for the first 1000 square feet prepared per day, and one test for each additional 1000 square feet or portion thereof, at randomly selected locations.

When less than 1000 square feet of surface area is prepared in a shift, at least 2 tests should be performed. If levels of soluble salts exceed the maximum, the entire area represented by the test should be cleaned again and tested until soluble salt levels conform to this requirement.

Unpainted new structural steel: Blast clean near white with appropriate abrasive media. Limit blast profile to 0.5 - 1.0 mil maximum. All surfaces must be clean, dry, and free of contaminants. Apply appropriate primer to the recommended dry film thickness.

- SSPC-SP1S • SSPC-SP10

Previously painted structural steel: Steam clean or power wash to remove all dirt, grease, contaminants, and gloss from existing paint. Spot clean rusty areas to remove all rust and mill scale.

- SSPC-SP1 • SSPC-SP6
- SSPC-SP2 • SSPC-SP11
- SSPC-SP3

Galvanized steel: Steam clean or power wash to remove all dirt, grease, and contaminants. Spot clean to remove rust and mill scale. Roughen surface by whip blasting or light sanding. Do not remove intact galvanizing. Epoxy or urethane primer is required.

- SSPC-SP1 • SSPC-SP7
- SSPC-SP2 • SSPC-SP11
- SSPC-SP3

Concrete: Clean in accordance with:

- SSPC-SP13 / NACE6

Note: Blast cleaned surfaces must be primed the same day blast cleaning is done.

MIXING PARAMETERS:

Ratio: [Part A : Part B]
By Weight 1.00 : 0.75
By Volume 1.00 : 1.00

Sweat-in Time: 20 mins

ASTM D2196 Pot Life: [valid for qtys of 1 gallon or more]

50° F	65° F	77° F	85° F
4 hrs	4 hrs	4 hrs	3 hrs

APPLICATION:

Aquapoxy™ Primer can be applied by HVLP, air assist airless, brush or roller.

HVLP:

Fluid Tip and Needle:050"
Fluid Pressure: 8-10 psi
Air Cap Pressure: 60 psi

Air Assist Airless:

Fluid Tip:015"
Fluid Pressure: 800-900 psi
Air Cap Pressure 10-15 psi

Brush or Roller: yes

THINNING: Water

CLEANUP: Water
Clean tools with detergent and water while Aquapoxy™ is still wet.

HEALTH & SAFETY PRECAUTIONS

WARNING:

LIQUID CONTACT WITH EYE AND SKIN CAUSES IRRITATION. DO NOT INGEST. Avoid contact with eyes and skin. Wash hands thoroughly after using and before eating and smoking. Keep container closed when not in use. If spillage occurs, absorb and dispose of according to local regulations.

FIRST AID:

Should eye contact occur, flush with plenty of water for at least 15 minutes and get medical attention if vision is disturbed. For skin, wash thoroughly with soap and water. If swallowed, seek medical attention immediately. DO NOT induce vomiting.

THIS PRODUCT IS FOR PROFESSIONAL USE ONLY.

KEEP THIS PRODUCT OUT OF THE REACH OF CHILDREN.

SHIPPING & HANDLING

SHIPPING DESCRIPTION: [CFR 49]

Ground, Air, Vessel Not Regulated
Required Label & Marking Not Required

IMDG PACKAGING: Not Required

IMDG STOWAGE: Not Regulated

UNIFORM FIRE CODE: [CFR 29] CLASS III-B

STORAGE TEMPERATURE: 120° F max

SHELF LIFE: [warranted] 1 YEAR

HMIS RATINGS: H - 1; F - 1; R - 0; PP - B

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Product Data Sheets are periodically updated to reflect new information relating to the product. It is important to obtain the most recent Product Data Sheet for the product being used before application. IM283PAJ60-11/04-S03