

## P01-4A84 DYPOX SHOP PRIMER

### DESCRIPTION

Two component epoxy primer. It's designed for both manual and automatic applications.

- Contains zinc phosphate
- Short curing periods
- Suitable for welding application

### RECOMENDED USE

Protection of blasted surfaces during the storage and production period. Primer in a coating system for corrosion protection of steel.

- Steel structures
- Tank and pipeline coating
- Industrial structures
- Petrochemical plants

### CERTIFICATES/APPROVALS

Approved as a welding primer by GL. Certificate no:WF 1390002 HH

### PRODUCT PROPERTIES

Color / Finish: Red, gray / matt  
Specific gravity: 1,35 – 1,455 gr/ml  
Volume solids: %33-37  
Theoretical coverage: 16,9 m<sup>2</sup>/lt (20µ DFT)  
V.O.C: 580 gr/lt  
Flash point: <21°C

Mixing ratio: 15 parts Dyopox Shop Primer  
(by weight) 1 parts H03 Dyopox Hardener  
3-5 parts Dyopox Thinner  
The temperature of the paint should be above 15°C, otherwise paint containers should be heated. Stir well before use.

Induction time: 20 minutes at temperatures below 15°C.

Pot life: 10-12 hours/20°C

Recommended thickness: DFT: 20µ WFT: 55µ

\*Drying times: Dry to touch : ~ 2-5 minutes /20°C  
(20µ DFT) Full cured : ~7 days/20°C  
\* Change according to DFT and temperature.

Overcoat: Min. Interval: ~5 hours /20°C  
Max. Interval: none



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### APPLICATION

Additional data: Substrate temperature should be above 0°C during application and curing. Substrate temperature should be at least 3°C above dew point.  
Adequate ventilation must be maintained during application and drying .

Equipments:

Equipment	Airless	Airspray
Pressure	~100 bar	~4 bar
Nozzle orifice	0,43 - 0,53 mm 0,017 - 0,021 inch	1,8- 2,2 mm 0,070 - 0,085 inch

### SURFACE PREPARATION

New Steel: Blast cleaned to Sa½ (ISO 8501-1). Surface should be cleaned from any contamination. (Oil, grease, salt etc.) The surface should be assessed and treated in accordance with ISO 8504.

### STORAGE

Keep in cool and dry place;  
Dyopox Shop Primer: One year at room temperature  
Dyopox Hardener: Six months at room temperature

### SAFETY

This product is flammable. Keep away from heat and open flame. Keep container closed. Read safety precautions on MSDS forms. Avoid contact with skin and eyes. Avoid inhalation. Take precautions to protect the environment.



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