

COATING DATA

DESCRIPTION:

Perma-Clean II Epoxy Primer is a high solids, densely cross-linked, chemical and corrosion resistant, modified polyamidoamine epoxy primer formulated to provide excellent protection of steel, masonry and non-ferrous metals in corrosive environments. This epoxy uses a special modified polyamidoamine curing agent which imparts the best properties of both amines and conventional polyamides. This primer is to be used as part of the Perma-Clean II system, which also features Perma-Clean II Semi-Gloss product used as an intermediate or finish coat, and a Perma-Clean II High Gloss finish. Perma-Clean II Primer also will accept a variety of other Induron topcoats such as Indurethane, Aquanuat® Gloss Acrylic, and Induron epoxies. Perma-Clean II products meet the requirements of the Food Safety and Inspection Service of the U. S. Department of Agriculture as chemically acceptable for use in areas where there may be a possibility of incidental food contact. This product also meets the requirements of ANSI/AWWA D102-06 Outside System No. 5 for first coat.

Perma-Clean II Epoxy Primer

- High build primer that can be applied up to 6 dry mils per coat.
- Complies with U. S. EPA National Volatile Organic Compound (VOC) Emission Standards for industrial maintenance coatings effective September 13, 1999.
- Performs well in many corrosive environments including the following:
 - Structural steel in aggressive environments.
 - Immersion in neutral, alkaline, and salt solutions.
 - Immersion in water.
 - Immersion in concentrated caustic solutions.
 - Acid fume, splash, and spillage.
 - Immersion in aliphatic petroleum hydrocarbon solvents.

USE:

To protect steel, non-ferrous metals, concrete, masonry, wood or drywall substrates from chemicals and corrosion. Use in severe environments which include abrasion, moisture, corrosive fumes, chemical contact, and immersion. These include chemical processing plants, bio-pharmaceutical facilities, power plants, offshore oil and gas equipment, laboratories, pulp and paper mills, structural steel, water/wastewater plants and others. Use as a shop or field primer for Induron epoxies.

LIMITATIONS:

Do not use for immersion service above 120°F (49°C) or dry heat above 200°F (93°C). Not recommended for immersion in concentrated solutions of mineral or inorganic acids. Not for potable water.

SURFACE PREPARATION:

Steel (Water immersion)—SSPC-SP 10/NACE 2, Near-White Blast Cleaning. Other recommended immersion exposures - SSPC-SP 5/NACE 1 White Metal Blast Cleaning, vacuum after blasting and recoat all blasted area the same day.

Steel (Non-Immersion)—SSPC-SP 6/NACE 3, Commercial Blast Cleaning and remove all surface contaminants.

Ductile Iron—Remove all surface contaminants by blasting in accordance with NAPF 500-03-04. Do not coat surfaces previously coated with asphalt.

COATING DATA(Continued)

COVERAGE:

Theoretical—962 ft² per gallon at 1.0 mil dry film thickness.

DRY FILM THICKNESS: 3.0 to 6.0 mils per coat.

WET FILM THICKNESS: 5.0 to 10.0 mils.

APPLICATION DATA

BLEND RATIO:

One part Perma-Clean II Activator to four parts Perma-Clean II Primer Base. Power agitate until components are thoroughly mixed. Allow mixed components to stand fifteen minutes prior to application.

POT LIFE: 4 hours @90F, 8 hours @70F, 12 hours @50F, decreasing with higher temperature.

APPLICATION:

Airless Spray—Use .017-.021 tip; 60 mesh filter; 30:1 pump ratio at 60-100 psi operating air pressure.

Conventional Spray—Follow instructions of equipment manufacturer for the application of epoxy paints.

Roll—Use lambswool cover. Additional coats may be required to achieve desired film thickness. **Brush**—Use natural bristle brush. Additional coats may be required to achieve desired film thickness.

THINNING:

If required, thin up to 10% with K-1066 Reducer. Clean equipment with K-1066 Reducer.

CLIMATE:

Use this product only if the substrate temperature and ambient air temperature is above 40°F and is expected not to decrease for at least two hours after application. Also, the substrate temperature must be 5°F above the dew point for a period of at least two hours after application to avoid condensation occurring on wet paint.

DRY TIME:

TO HANDLE— 5 hours @90F, 10 hours @ 70F, 18 hours @50F.

TO RECOAT—50°F or higher, over-night; 40°F-50°F, second day.

Note: High film thickness, low temperature and/or poor ventilation will retard dry time.

Note: E-60 Accelerator may be used to increase the normal curing rate of reaction to provide a rapid low temperature cure. See E-60 Technical Data Sheet for more information.

For shop application only: Perma-Clean II Epoxy primer can be re-coated wet on wet in as little as 2.5 hours @ 77F, provided that the applied millage is maintained at 3-4 mils DFT, and that E-60 accelerator is used.

PHYSICAL DATA:

VOLUME SOLIDS: 60% ± 1%

SOLIDS BY WEIGHT: 75% ± 1%

WEIGHT PER GALLON: 11.3 ± .2 lbs per gallon

VOLATILE ORGANIC CONTENTS:

Mixed unthinned - < 2.8 lbs./gallon; < 330 grams/liter

Mixed thinned 10% - < 3.2 lbs./gallon; < 380 grams/liter

HAPS:

Mixed unthinned - 1.8 lbs./gallon solids

Mixed thinned 10% - 2.5 lbs./gallon solids

SAFETY DATA:

Note: This product is formulated without the use of lead, chromates, or other toxic pigments. See individual product label for safety and health data information. Individual Material Safety Data Sheets are available upon request.

PERFORMANCE DATA:

See Induron Perma-Clean II System Technical Data Sheet.