

# SHARK EPOXY PRIMER



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## DESCRIPTION

**SHARK EPOXY PRIMER** is 2K epoxy primer produced from Epoxy – Polyamide and high-quality rust inhibitive pigment (zinc phosphate, ...), used to prevent rust for metal surfaces.

## TYPICAL USE

**SHARK EPOXY PRIMER** is rust prevention primer, specialized for metal surface like iron, steel, galvanized, aluminum, etc. This product is appropriate for application such as bridge, pipeline, iron and steel structures.

## PRODUCT DATA

- **Components** : Binders, pigments, additives and solvents
- **Color** : Grey
- **Paint film appearance:** Semi - gloss
- **Solid by volume** :  $64 \pm 2 \%$
- **Theoretical coverage** :  $6.4 - 8.5 \text{ m}^2/\text{liter}/\text{coat}$   
*Actual surface coverage will be depended on spreading ability of paint film, dry film thickness, surface irregularities, technique and wastage during painting.*
- **Volatile organic compounds (VOCs)** :  $\leq 380 \text{ g/L}$
- **Flash point** : appx.28°C
- **Drying time – Pot life (at relative humidity (RH) 50% & dry film thickness (DFT) 75µm - 100µm):**

○ <b>Surface temperature</b>	25°C	30°C	35°C
○ <b>Surface dry (touch dry)</b>	4h	3h	2h
○ <b>Hard dry</b>	10h	8h	6h
○ <b>Painting interval, minimum</b>	10h	8h	6h
○ <b>Pot life</b>	10h	8h	4h

*Actual drying time and painting interval time may be longer or shorter than provided data, depended on environmental temperature, dry film thickness, ventilation, humidity and number of coating applied, etc.*

## RECOMMENDED PAINT FILM SYSTEM:

SYSTEM	PRODUCT	COAT(S)	DRY FILM THICKNESS
<i>For metal surfaces</i>			
Primer	<b>Shark Epoxy Primer</b>	<b>1</b>	<b>100µm</b>
Topcoat	<b>Epoguard Enamel (for interior)</b>	<b>2</b>	<b>50µm</b>
	<b>Topguard (for exterior)</b>	<b>2</b>	<b>50µm</b>
	<b>TOA 2 trong 1 (for exterior &amp; interior)</b>	<b>2</b>	<b>35µm</b>

# Technical data sheet

## APPLICATION INSTRUCTION

### ▪ SURFACE PREPARATION

#### ➤ Construction structure:

- Free surface from grease, oil according to SSPC-SP1-Solvent cleaning.
- Surface should be blast cleaned in accordance with Sa2.0 – Sa2.5 (ISO 8501-1/2007). With areas cannot apply blast cleaning, use physical tools to clean surface at least achieved St2-St3 (ISO 8501-1:2007).
- Surface roughness achieved 35 – 50 microns (ISO 8503-2).
- Clean all dust remained on the surface before primer applied.

#### ➤ Galvanized, aluminum, stainless steel:

- Make sure the surface is dry and clean, free from grease, oil, waxy contamination, rust or mill scale which can affect to paint film adhesion.
- Totally free salt of zinc, aluminum... on the surface before paint applied.
- Clean all dust remained on the surface before primer applied.

#### ➤ Notice:

- In order to maximize service time, paint film must be applied on high-grade cleaned surface. Protective paint film should be applied within 4 hours after surface cleaning.

#### ➤ Before applying next layer:

- Surface must be dry, clean, free from dust and other contaminants. Grease and oil must be cleaned according to SSPC-SP1- Solvent cleaning.
- If primer / first topcoat layer was applied over last 7 days, gives surface cleaning by sand paper no. 320-400 then follow SSPC-SP1, Solvent Cleaning before next coat applied.

### ▪ MIXING RATIO

Mixing ratio	Part A	Part B
By volume	3	1
By weight	4	1

*Stir well Part A and Part B separately.*

*To ensure painting system achieves drying time and designed physical properties, recommended mixing ratio should be strictly followed.*

*Gradually pour Part B into Part A, stir well in 2 – 3 minutes with dedicated stirrer until homogeneous. Leave the mixture for stabilization in 5 minutes before applying.*

### ▪ APPLICATION

#### Equipment / methods:

Brush, roller, conventional spray, airless spray

For airless spray gun:

- Nozzle tip size : 0.013" – 0.021"
- Angle to the surface : 65° – 80°
- Pressure at nozzle : 140 – 190 Kg/cm<sup>2</sup> (2.000 – 2.600 Psi)

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## Paint film thickness:

	Min	Standard	Max
- <b>Dry film thickness (DFT):</b>	75µm	100µm	100µm
- <b>Wet film thickness (WFT):</b>	117µm	156µm	156µm

*Film thickness will vary and is calculated as average.*

## Dilution ratio:

Paint is ready to use after proper stirring until homogeneous.

Add in **maximum 5% TOA epoxy thinner #31 by volume** if thinning is necessary.

*Dilution percentage is depending on ambient temperature, relative humidity, paint film thickness, equipment and application method.*

## CERTIFICATION

*TCVN 9014:2011 – National technical regulation on Epoxy resin paints certified.*

*QCVN 08:2020/BCT – National technical regulation on the limits of lead content in paints certified.*



## HANDLING AND STORAGE

The product must be stored in accordance with national regulations.

Store in a dry, cool, good ventilation area; far from heat, open flame, flammable materials.

Tightly closed when not in use.

Keep out of reach of children.

Stir well before use, paint should be used up when lid opened.

Storage temperature is recommended at 25°C – 30°C.

Do not apply when temperature is lower than 15°C or higher than 40°C.

Do not apply when relative humidity exceeds 75%.

Surface temperature should be at least 3°C higher than the dew point of the air.

## HEALTH AND SAFETY

Please do not handle until all safety precautions have been read and understood.

Keep away from heat, sparks, open flame, hot surface. No smoking.

Wear protective gloves, respirator, eye protection, protective clothing.

Avoid contact with skin, eyes or ingestion. Go right to the nearest health center for help in case of ingesting paint or paint contacts with eyes.

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Avoid release to the environment. Treat discarded paint according to environmental law.

See more guidelines in the Safety Data Sheet.

### PACKAGING

	net volume (liter)	volume of can (liter)
<b>Shark Epoxy Part A</b>	0.75   12	1   17.5
<b>Shark Epoxy Part B</b>	0.25   4	0.25   4

### SHELF LIFE

24 months from manufacturing day when stored at 25°C – 30°C

### DISCLAIMER

The information in this data sheet is given to the best of TOA's knowledge based on laboratory testing and practical experience. However, as the product is often used under conditions beyond our control, TOA cannot guarantee anything only the quality of the product itself. TOA reserves the right to change given data without notice.

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