

11080 KANEPOX SHOP PRIMER RC

PRODUCT DESCRIPTION

11080 KANEPOX SHOP PRIMER RC is an epoxy based, two component zinc phosphate containing primer with a very fast drying speed. It has good surface appearance and does not affect weld quality. It is suitable for use in automated painting equipment.

RECOMMENDED USE

It is used as a protective shop primer in the following areas for corrosion protection of abrasive blast cleaned steel during production, transportation and stacking;

- Ship structures
- Structural steels
- Chemical plant tanks, pipes and heat exchangers.

It can be applied as shop primer in paint systems demanded from C2 to C5 corrosion categories according to ISO 12944-5 Standard.

CERTIFICATES

Certificates which shows that the products do not affect the welding quality and that the welding fumes are not toxic;

- Weldability Certificate (Türk Loydu)

PRODUCT CHARACTERISTICS

| | |
|---|--|
| Finish: Matt | Density (g/ml) 1,19±0,10 |
| Colour: Oxide Red, Grey | Spreading Rate (m ² /l) 15,50 (20 microns DFT) |
| Thinner: Kanat Thinner 0620 (Low Temp.) Kanat Thinner 0625 (High Temp.) | Flash Point 18°C |
| Mixing Ratio (by volume) 15 Parts A Comp. + 3 Parts B Comp. | VOC (Volatile Organic Content) 580 g/l |
| Mixed Product; Volume Solids (%) 31±2 | Application Methods Airless Spray, Conventional spray |
| | Pot Life (20°C) 8 hours |

DRYING SCHEDULE(*)

(20 microns/1 mil film thickness)

| | Dry to Touch | Hard Dry | Dry to Over Coat Minimum |
|------|--------------|------------|--------------------------|
| 5°C | 15 minutes | 20 minutes | 18 hours |
| 15°C | 7-8 minutes | 12 minutes | 10 hours |
| 25°C | 1-3 minutes | 4 minutes | 6 hours |
| 35°C | 1 minute | 2 minutes | 4 hours |

Drying values are valid for defined dry film thickness and below 85% relative humidity.

Fully Cured: 7 days (20°C)

(*) Drying time depends on temperature, humidity and film thickness.

PACKAGING

One kit of **11080 KANEPOX SHOP PRIMER RC** is 18 l.
One pail of **11080 KANEPOX SHOP PRIMER RC** component A is 15 l.
One can of **KANEPOX HARDENER 0355** component B is 3 l.

SHELF LIFE

Part A–1 year, Part B–1 year when the material is stored in a cool and dry place in unopened original containers.

HEALTH/SAFETY PRECAUTIONS

Refer to the MSDS sheet prepared according to EU directives before use.

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SURFACE PREPARATION

Surfaces must be dry, clean, free of oil, grease and other foreign material.

New Surfaces: Surfaces should be blasted to near-white metal surface cleanliness according to SSPC-SP10 or ISO 8501-1 Sa 2 1/2. Depending on ambient conditions, blasted surfaces must be primed in maximum 5 hours with **11080 KANEPOX SHOP PRIMER RC**.

Touch up: Remove all dust, dirt and other foreign material and keep dry. Clean the surface to St 2-St 3 level mechanically according to ISO 8501-1 and complete the touch-up application as soon as possible. **11080 KANEPOX SHOP PRIMER RC** can be safely used for touch-up.

APPLICATION PROCEDURES (Mixing Procedure)

This is a two-component paint. Do not mix more material than you plan to use within the listed pot life. Complete containers must be mixed at one time. **DO NOT MIX PARTIAL QUANTITIES FROM CONTAINERS OR PROPER COMPONENT RATIOS MAY NOT BE OBTAINED.** Prior to mixing, components A Base and B Hardener should be at room temperature. Combine 3 parts by volume of Part B Hardener with 15 parts by volume of Part A Base. Homogenize the mixture with a power mixer, add thinner if necessary before use. Mixed product must be used within 8 hours (20°C).

MIXING RATIO

Base 11080 : Curing Agent 0355
5 : 1 by volume

APPLICATION CONDITIONS

For the best results;

Temperature must be more than 5°C during the application and/or the curing process.

Surface temperature: At least 3°C above dew point.

Relative humidity: 85% maximum.

Good ventilation is required during application.

APPLICATION

Apply paint at the recommended film thickness and spreading rate. Avoid spray dust and high film thicknesses. Recommended film thickness is 15-20 microns measured on unblasted steel panel. There is no limitation for maximum recoating interval but touch-up shall be made for production faults and surface shall be free of oil, grease and other foreign material. When using spray application, use a 50% overlap with each pass of the gun to avoid holidays, bare areas and pinholes. If necessary, cross spray at a right angle.

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CLEAN UP

KANAT THINNER 0644, KANAT THINNER 0620,
KANAT THINNER 0625

APPLICATION EQUIPMENT

(The table is a guide for 20°C)

| Application Equipment | Airless Spray | Conventional Spray |
|------------------------|---------------|--------------------|
| Thinner maximum | 30% | 30% |
| Pressure minimum (bar) | 80 | 2,5 |
| Nozzle(inch) | 0,009-0,015 | 1,4-1,8 |

PRECAUTIONS

- Thinner amount shall be adjusted according to paint equipment adjustment. Surface appearance can be controlled on a glass panel. Recommended thinner ratio is 10-30% .
- Contact KANAT PAINTS & COATINGS Project Group in case surface preparation is not applicable either by blasting or mechanical.
- 2-3% Retarder shall be added to avoid dry spraying in case temperature is over 35°C, especially for conventional spray application. Retarder addition increases drying time.

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