

## 12850 KANEPOX ALUGAL PRIMER

### PRODUCT DESCRIPTION

**12850 KANEPOX ALUGAL PRIMER** is an epoxy-polyamide based, two component primer containing zinc phosphate. It is specifically formulated for superior adhesion to a range of different substrates. It exhibits fast drying even at low temperatures. It has excellent durability and elasticity in corrosive atmospheres.

### RECOMMENDED USE

Primer coat (tiecoat) of the paint systems to be applied on;

- Galvanized steel.
- Aluminium.
- Stainless steel.
- Other steel surfaces.

### PRODUCT CHARACTERISTICS

<b>Finish:</b> Matt	<b>Density (g/ml)</b> 1,48±0,10
<b>Colour:</b> Grey, Oxide Red, Beige	<b>Spreading Rate (m<sup>2</sup>/l)</b> 11,20 (50 mikrons DFT)
<b>Thinner:</b> Kanat Thinner 0620 (Low Temp.) Kanat Thinner 0625 (High Temp.)	<b>Flash Point</b> 26°C
<b>Mixing Ratio (By Volume)</b> 15 Parts A Comp. + 5 Parts B Comp	<b>VOC ( Volatile Organic Content)</b> 414 gr/l
<b>Mixed Product; Volume Solids (%)</b> 56±2	<b>Application Methods</b> Airless Spray, Roller, Conventional Spray
	<b>Pot Life (20°C)</b> 8 hours

### DRYING SCHEDULE(\*)

(50 microns/2 mils film thickness)

	Dry to Touch	Hard Dry	Dry to Over Coat Minimum
5°C	6 hours	10 hours	10 hours
15°C	3,5 hours	6 hours	6 hours
25°C	2 hours	4 hours	4 hours
35°C	1,5 hours	3 hours	3 hours

Fully Cured: 7 days (20°C)

(\*) Drying time depends on temperature, humidity and film thickness. Drying values are valid for defined dry film thickness and below 85% relative humidity.

### PACKAGING

One kit of **12850 KANEPOX ALUGAL PRIMER** is 20 l.

One pail of **12850 KANEPOX ALUGAL PRIMER** component A is 15 l.

One can of **KANEPOX HARDENER 0311** component B is 5 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.

**Galvanized and Aluminium Surfaces:** Remove all the oil, grease and other foreign material by means of solvent, detergent or steam. Salts and contaminants shall be removed by pressurized fresh water. The primer is immediately applied to completely dry surface.

**Stainless Steel Surfaces:** Remove all the oil, grease and other foreign material by means of solvent, detergent or steam. Surface shall be roughened for better adhesion properties.

**Touch-up:** Remove all dust, dirt and other foreign material and keep dry. Clean the surface mechanically without damaging galvanization and complete the touch-up application as soon as possible. **12850 KANEPOX ALUGAL PRIMER** 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 5 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 12850 : Curing Agent 0311  
3 : 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

Stripe coat all crevices, welds and sharp angles. Apply paint at the recommended film thickness and spreading rate.

Application of coating above maximum or below minimum recommended spreading rate may adversely affect coating performance. Maximum coating interval is 3 months. Do not apply more than 150 microns (6 mils) WFT to prevent sagging. 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. 40-50 microns DFT on galvanized, aluminum and stainless steel surfaces is recommended to ensure good adhesion.

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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	Roller
Thinner maximum	%5	%15	—
Pressure minimum (bar)	175	2,5	—
Nozzle(inch) / Diameter (mm)	0,013-0,019	1,6-2,2	—

### PRECAUTIONS

- Exposure of galvanized surfaces to weathering may lead to corrosion products (white rust). Remove white rust with proper means.
- Metalized surfaces shall be coated as soon as possible.
- Condensation forming on the coating during early times of curing may result in longer cure times, solvent entrapment, premature failure, discoloration or a surface haze or blush that must be removed before recoating.
- Do not apply heavy coats beyond the specification otherwise, solvent popping may occur

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