

## 15401 KANEPOX TOL PRIMER-401

## PRODUCT DESCRIPTION

**15401 KANEPOX TOL PRIMER-401** is an epoxy-polyamide based, two component primer/midcoat containing zinc phosphate. It is specially designed as a surface tolerant, elastic primer with excellent adhesion on marginally prepared steel surfaces and a wide range of existing coatings. It has excellent durability against moisture and chemicals with a long overcoating window.

## RECOMMENDED USE

Surface tolerant primer coat of the paint systems on mechanically cleaned steel surfaces without blasting or surfaces with existing coating for;

- Structural steel.
- Industrial and marine structures, below or above water (including concrete surfaces).
- Ship building and maintenance industry.

## PRODUCT CHARACTERISTICS

Finish: Semi-Matt	Density (g/ml) 1,64±0,10
Colour: Oxide Red, Grey, Beige	Spreading Rate (m <sup>2</sup> /l) 14,20 (50 microns DFT)
Thinner: Kanat Thinner 0620 (Low Temp.) Kanat Thinner 0625 (High Temp.)	Flash Point 39°C
Mixing Ratio (by volume) 15 Parts A Comp. + 3 Parts B Comp.	VOC ( Volatile Organic Content) 263 g/l
Mixed Product; Volume Solids (%) 71±2	Application Methods Airless Spray, Roller
	Pot Life (20°C) 6 hours

## DRYING SCHEDULE(\*)

50 microns/2 mils film thickness)

	Dry to Touch	Hard Dry	Dry to Over Coat Minimum
5°C	8 hours	14 hours	14 hours
15°C	5 hours	9 hours	9 hours
25°C	3 hours	6 hours	6 hours
35°C	2,5 hours	5 hours	5 hours

Drying values are valid for defined dry film thickness and below 85% preferably below 60% relative humidity.

Fully Cured: 7 days (20°C)

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

## PACKAGING

One kit of **15401 KANEPOX TOL PRIMER-401** is 18 l.

One pail of **15401 KANEPOX TOL PRIMER-401** component A is 15 l.

One can of **KANEPOX HARDENER 0313** 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 Steel Surfaces:** Surfaces should be blasted to near-white metal surface cleanliness according to SSPC-SP6 or ISO 8501-1 Sa 2. Blast profile on steel should be 40-70 microns in depth. Surface cleanliness of St 2-St 3 according to ISO 8501-1 is sometimes allowed depending upon the conditions. Depending on ambient conditions, blasted surfaces must be primed in maximum 5 hours with **15401 KANEPOX TOL PRIMER-401**.

**Previously Painted Surfaces:** If the aged coating is in a good condition, it is slightly sanded and cleaned by pressurized fresh water cleaning to remove the dust and other contaminations. Otherwise remove all the cracked and peeling paint by using hand tools to a cleanliness of St 2-St 3 according to ISO 8501-1. If applicable blast cleaning to Sa 2-Sa 2½ according to ISO 8501-1 level to get better results. Water jetting is also applicable as an alternative to abrasive blasting.

**Primed/Midcoated Surfaces:** Be sure that overcoating period is not exceeded. Otherwise the surfaces must be blasted to have a surface profile.

**The Surfaces Other Than Steel:** Contact KANAT PAINTS & COATINGS Project Group for the galvanized, aluminium, plastic surfaces.

**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. **15401 KANEPOX TOL PRIMER-401** 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 3,33 parts by volume of Part B Hardener with 16,67 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 6 hours (20°C).

### MIXING RATIO

Base 15401 : Curing Agent 0313  
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

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.

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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	Roller
Thinner maximum	10%	10%
Pressure minimum (bar)	175	–
Nozzle(inch)	0,015-0,021	–

### PRECAUTIONS

- Contact KANAT PAINTS & COATINGS Project Group in case surface preparation is not applicable either by blasting or mechanical.
- Recoating period is minimum 3-5 hours and maximum 3 months (20°C). Recoating interval depends on temperature, humidity and film thickness. If maximum recoating time is exceeded abrade surface, if the surface is highly contaminated apply pressurized fresh water cleaning before recoating.
- 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.
- Use only KANAT THINNER 0625 for thinning paint to be applied on previously painted surfaces.

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