



# CL 9430 ZINC RICH EPOXY PRIMER

## Recommended Use

CL 9430 Zinc Rich Epoxy Primer is a two component zinc rich epoxy anti-corrosive primer. CL 9430 is designed to be an anti-corrosive protection of steel structures surfaces prepared by abrasive blast cleaning.

## Performance

- Excellent anti-corrosive performance
- Good resistance to moisture
- Excellent resistance to weather

## Physical Properties

Volume Solids	47%
Theoretical Coverage	6.25m <sup>2</sup> /litre @ 75 microns DFT
Type	Two components
Packing Ratio	3.75 litres Base : 1.25 litre Hardener
Colour Availability	Grey
Flash point	21°C (mixed)
Recommended Thickness	75 microns DFT

## Surface Preparation

### Steel

Abrasive blast clean to a minimum standard of Sa2.5 (ISO8501-1:1988) or SSPC-SP10.

Average surface profile of 30-75 microns is required.

The surface to be coated must be clean and dry and free from all visible traces of surface contaminants.

For repairing of galvanizing for small area, abrade the surface to a minimum standard of St3 (ISO8501-1:1988).

Feathering off the edges of intact galvanizing surrounding such area and brush apply the primer. For large areas, it is recommended that the surface is flash blasted and the prime applied by the desired method

## Average Drying Time

Ambient Temperature	Touch Dry	Hard Dry	Overcoating Interval		PotLife
			Minimum	Maximum	
15°C	10 mins.	4 hours	16 hours	Indefinite	10 hours
25°C	5 mins.	4 hours	16 hours	Indefinite	8 hours
35°C	5 mins.	4 hours	16 hours	Indefinite	3 hours

## Application Data

Application Methods      Brush and Airless Spray.  
 Mixing ratio (by volume)      3 parts Base to 1 part Hardener

Airless Spray      Nozzle Size : 0.46-0.53mm (18-21 thou)  
                                  Fan Angle : 80°  
                                  Operating Pressure : 155 kg/cm<sup>2</sup>(2200 psi)

Brush / Roller      This product is suitable for brush application. Application of more than one coat may be necessary to give equivalent dry film thickness to a single spray applied coat.



## Application Conditions and Overcoating

This product should preferably be applied at temperature in excess of 10°C. In conditions of high relative humidity i.e. 80-85%, good ventilation conditions are essential. Substrate temperature should be at least 3°C above the dew point.

At application temperature below 10°C, drying and curing time will be significantly impaired.

### Application at temperature below 5°C is not recommended.

The maximum air and substrate temperature for application is 40°C providing conditions allow satisfactory application and film formation. If the air and substrate temperature exceed 40°C and epoxy coatings are applied under this condition results paint film defects such as dry spray, bubbling and pinholing etc. can occur within the coating.

In order to achieve optimum water and chemical resistance, temperature needs to be maintained above 10°C during curing.

## HEALTH AND SAFETY

Consult Chemical Safety Data Sheet for information on safe handling and application of this product.



Keep seal tight



Secure upright



Wear proper  
protection



Practice proper  
disposal