



# Epoxyprime P936

## Epoxy Anti-Rusting/Corrosion Primer

### 環氧基抗銹侵蝕底油

#### 1.0 Description

Epoxyprime P936 is a high performance, chemically cured, epoxy, rust inhibitive primer for interior or exterior steel, galvanized metal or aluminum surfaces. An excellent holding primer with superior aged recoatability. Also may be used on concrete, masonry, glazed brick or ceramic tile to assure adhesion of a protective or decorative finish. The color permits easy coverage with topcoats.

#### 2.0 Technical Data

Adhesion	ASTM D 4541	Excellent		
Abrasion Resistance	ASTM D 4060	Good		
Impact Resistance	ASTM D 2794	Excellent		
Humidity Resistance	ASTM D 2247	Excellent		
Color	Light Gray			
Finish	Flat			
Reduction Solvent	MP Thinner – see thinning			
Clean-up Solvent	MP Thinner			
Weight/Gallon	11.8 lbs./gal. (1.41 kg/L)			
VOC (EPA 24)	3.2 lbs./gal. (379 g/L)			
Solids By Volume (ASTM D 2697-7 days)	57%			
Recommended Film Thickness	2.0 – 3.0 mils (100-150 microns) dry – 4.0 – 6.0 mils (100 – 150 microns) wet. (Make allowances for loss due to overspray & irregular surface.)			
Service Temperature Limits	250°F (120°C) dry. Film may discolor above 140°F (60°C)			
Minimum Dry Time (ASTM D 1640)	At 3 mils (75 microns) DFT			
Curing Rate Per				
Substrate Temperature	30°F (-1°C)	50°F (10°C)	70°F (21°C)	80°F (27°C)
Minimum Recoat	8 Hours	3 Hours	1 Hours	1 Hours
Dry Hard	>60 Hours	10 Hours	6 Hours	5 Hours
Shelf Life	Over 24 months at 70°F (21°C) – unopened			
Hardness (ASTM D 3363, 7 day cure @ 77°F (25°C))	F			
Mix Ratio By Volume	9 (base) : 1 (converter) – see mixing instructions			
Pot Life	12 hours @ 77°F (25°C) & 50% R.H.			

#### 3.0 Typical Use

Provides excellent adhesion and corrosion resistance for metal substrates such as steel structural members, hollow metal doors & frames, cabinetry, machinery, equipment, piping and tanks in all industrial environments. May be used for both interior and exterior applications in chemical, fertilizer & power paints, petroleum refineries, pulp and paper mills, water and sewage treatment plants and mining operations. Also an excellent prime coat in the hard service area of public and paper mills, water and sewage treatment plants and commercial buildings, transportation equipment and difficult substrates such as galvanized metal, fiberglass, glazed brick, ceramic tile, brass, terne metal, or aluminum.

Special Qualifications – Performance alternate for Mil-P-24441B-Formula 150 – Type 1 and TT-C-535B-type II, Suitable for use on structural surfaces or surfaces where there is a possibility of incidental food contact in commercial food preparation establishments, food processing plants and federally inspected meat and poultry plants, USDA no longer requires or tarnishes product certification letters.

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#### **4.0 Application**

##### **4.1 Mixing**

This product is supplied in two parts. Mix base component thoroughly. To 9 parts of base add 1 part of Converter by volume. (Both components are provided in partially filled cans which, when mixed, provide a full one gallon mix at the proper ratio.) Stir thoroughly and scrape sides of can to ensure thorough blending. Power mix at low speed continuously for 15 minutes. Mixed material is usable for twelve hours: if it thickens, do not add thinner, but discard and mix fresh material. Thin only if necessary with appropriate mineral spirit up to one half pint per gallon. Pot life at 60-80°F (16-27°C) is twelve hours.

##### **4.2 Surface Preparation**

Surfaces must be sound, dry, clean, free of oil, grease, dirt, mildew, form release agents, curing compounds, loose and flaking paint and other foreign substances.

New Surfaces : Steel – Best results are obtained over a surface abrasive blasted to a Near White Blast (SSPC-SP10, SSI-Sa2 1/2), Performance over hand or power-tool cleaned surface is dependent on the degree of cleaning. Concrete and Masonry – Cure at least 30 days before painting. PH must be 10.0 or lower. Roughen slick poured or precast concrete by acid etching or sand sweeping. Follow acid manufacturer's application and safety instructions. Rinse thoroughly and allow to dry. Remove loose aggregate. Prime with this product. Galvanized Steel – Allow to weather a minimum of six (6) months prior to coating. Solvent clean (recommended solvent is mineral spirits) followed by a thorough water rinsing, then primer with this product. When weathering is not possible at the surface has been treated with chromate or silicates, first clean by the method intended to be used on the job and apply a test patch of the coating system specified. Allow product(s) to dry and cure at least one week before testing adhesion per ASTM D 3359. If adhesion is poor, brush blast then prime with this product. Aluminum – Remove oils and dirt by solvent cleaning followed by a thorough water rinsing. Then prime with this product. Terne Metal – May be coated with an asphaltic varnish which must be removed prior to coating. Mineral spirits may normally be used to remove this varnish.

##### **4.3 Application**

Brush (natural bristle), roll (short nap) or spray. No thinning required. For airless spray. Use a 0.019-0.025 tip. Adjust pressure as needed. Spray is preferred for appearance and build. Use clean short nap synthetic roller. New rollers should be thoroughly wet with Thinner and spun vigorously to remove loose fibers brushing and rolling may require multiple coats to achieve correct film thickness and/or hiding.

Spreading Rate : Apply at 265-400 sq.ft. per gallon (6.5-9.8m<sup>2</sup>/L) or 4.0-6.0 mils (100-150 microns) wet. Make allowance for overspray loss and irregular surfaces.

Minimum application temperature is 32°F (0°C). At 77°F (25°C) & 50% R.H. dries to touch in 45 minutes; to recoat with epoxy or urethane, solution vinyl, or chlorinated rubber in approximately 1 hours; to recoat with conventional alkyd or acrylic latex coatings in approximately 1 hours. Achieves full cure in 7 days at 77°F (25°C). Low temperature, high humidity or poor ventilation will increase these times.

#### **5.0 Health and Safety**

Danger! Flammable liquid and vapor. Caused eye and skin burns. Harmful or fatal if swallowed. Aspiration hazard-canister lungs and cause damage. Harmful if inhaled. May cause central nervous system effects, including dizziness, Headache or nausea. Causes respiratory tract irritation. May cause allergic skin reaction. May be harmful if absorbed through skin. Overexposure may cause blood, liver, kidney damage. Contains crystalline silica which can cause lung cancer and other lung damage if inhaled. Contains mica which may cause pneumoconiosis. Potential cancer hazard. Contains formaldehyde which has been shown to cause upper respiratory tract cancer and allergic respiratory reaction. Use only with adequate ventilation. Keep out of the reach of children. Notice: This product contains solvents.