

**PRODUCT DESCRIPTION****TWO COMPONENT EPOXY PRIMER ZP 74253**

(CURING AGENT 24080)

RSI PRIMER ZP 74253 is designed for use as a high performance inhibitive primer base on epoxy and polyamide resins and Zinc phosphate as inhibitive pigments with an excellent anticorrosive efficiency in moderate to severe environment.

RSI PRIMER ZP 74253 can be applied as an inhibitive primer on blasted steel structure.

**Standard color availability** Manufactured only in light gray and off white color.

**GENERAL PROPERTIES**

<b>Adhesion</b>	Excellent to both grit blasted and manually prepared surfaces.
<b>Corrosion Resistance</b>	Excellent on correctly prepared surfaces.
<b>Temperature resistance</b>	Dry: Maximum 120 °C Wet: Maximum 50 °C

**PHYSICAL PROPERTIES:**

<b>Colors/Shade No</b>	Grey/RAL NO
<b>Finish</b>	Semi Flat
<b>Volume Solid</b>	55%
<b>Theoretical spreading rate</b>	11 m <sup>2</sup> /liter 50 Mic. Dft.
<b>Flash point</b>	27 °C
<b>Specific gravity</b>	1.45-1.55 kg/liter
<b>V.O.C.</b>	Max. 310 gr/liter
<b>Shelf life</b>	1 Years (25°C / 77°F) from time of production. Depending on storage condition, mechanical stirring may be necessary before usage.

**MIXING**

<b>Mixing ratio (by weight)</b>	Component A 74253 5	Component B 24080 1
<b>Pot life</b>	8 hours (20 °C/ 68 °F)	

**APPLICATION**

<b>Conditions</b>	Do not apply when relative humidity exceeds 80% or when the surface to be coated is less than 3 °C above the dew point.	
<b>Method</b>	Airless sprays	Brush (touch-up)
<b>Thinner (max. vol.)</b>	1051 (10-30%)	1051 (5%)
<b>Spray setting</b>		
<b>Pump ratio minimum</b>	30:1	
<b>Tip size</b>	0.019" - 0.021"	
<b>Tip pressure</b>	150 bar / 2200 Psi (Airless spray data are indicative and subject to adjustment)	
<b>Cleaning of tools</b>	Thinner 1051	
<b>Indicated film thickness, dry</b>	55 microns	
<b>Indicated film thickness, wet</b>	100 microns	

## DRYING AND CURING TIMES AT (20 °C)

Dry to touch	Max.1 hour
Hard dry	24 hours
Full curing	7 days
Recoat interval, min	8 hours
Recoat interval, max	7 days , see REMARKS

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## SURFACE PREPARATION

**New steel** Steel surface should ideally be abrasive blast cleaning to minimum Sa 2½. The surface must be completely clean and dry prior to application. And its temperature must be above the dew point to avoid condensation.

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## REMARKS

PRECEDING COAT: None.

SUBSEQUENT COAT: EPOXY INTER MEDIATE and Epoxy Top Coat.

Film thickness: May be specified in another film thickness than indicated depending on purpose and area of use.

This will alter spreading rate and may influence drying time and recoating intervals. Normal range is 50-75 microns/ 2-3 mils.

Thinning: The type and amount of thinner depend on application conditions, application method, temperature, ventilation, and substrate. Thinner 1051 is recommended in general.

Recoating  
And drying/curing  
Time

Physical data versus temperatures:					
Surface temperature		5°C/41°F	10°C/50°F	20°C/68°F	30°C/86°F
Dry to touch approx.		12 hours	8 hours	4 hours	3 hours
Resist condensing humidity/ light showers after		4 days	2 days	24 hours	12 hours
Fully cured		20 days	14 days	7 days	5 days
Recoating interval with epoxy intermediate	Min	24 hours	16 hours	8 hours	4 hours
	Max	15 days	12 days	7 days	5 days

**A completely clean surface is mandatory to ensure intercoat adhesion, especially at long recoating intervals. Any dirt, oil, and grease have to be removed, e.g. with suitable detergent. Salts to be removed by fresh water hosing. To check an adequate quality of the surface cleaning a test patch is recommended before actual recoating.**

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## SAFETY

Handle with care. Before and during use, observe all safety labels on packaging and paint containers, consult RSI material safety data sheets and follow all local and national safety regulations. Harmful or fatal if swallowed; immediately seek medical assistance. Avoid inhalations of possible solvent vapors or paint mist, as well as paint contact with skin and eyes. Apply only on well-ventilated areas and ensure that adequate forced ventilation exists when applying paint in confined spaces or when the air is stagnant. Always take precautions against the risks of fire and explosions.

Mar 2010

**RSI**  
**COATING**

Ranghay e Sanati e Iran Co.  
Product data sheet ZP 74253