



RSI
INDUSTRIAL
PAINTS Inc.

ZINC PHOSPHATE EPOXY PRIMER REP-106

PRODUCT DESCRIPTION

REP-106 is designed for use as a high performance polyamide cured epoxy primer containing zinc phosphate as inhibitive pigment with an excellent anticorrosive efficiency in moderate to severe environment. This product is a fast drying primer with very good adhesion to substrate.

Typical use: This product is used as an anti-corrosive primer on sandblast steel substrates.

GENERAL PROPERTIES

Adhesion	Excellent on correctly prepared steel surfaces.
Corrosion Resistance	Excellent on correctly prepared steel surfaces .

PHYSICAL PROPERTIES

Color	RAL No
Gloss level	matt
Volume Solid	55±3%
Theoretical spreading rate	9.2 m ² /liter at 60 Mic. Dft.
Flash point	29 °C
Specific gravity	1.5 ±0.05 kg/liter
VOC	Max. 250 gr/liter
Shelf life	1 year (25°C) from time of production. Depending on storage condition, mechanical stirring may be necessary before usage. Storage environment should be ventilated and away from sunlight and high temperature (above 30 ° C).

MIXING

mixing ratio (by volume)	Component A:100	Component B: 15
Pot life	8 h at 23°C	

APPLICATION

Conditions	Do not apply when the relative humidity exceeds 85% or when the surface to be coated is less than 3°C above the dew point. Do not apply at temperature below 7°C. If not, drying and overcoating times will be considerably extended. During application of the paint, naked flame, welding operations and smoking should not be allowed and good ventilation is necessary.	
Method	Air less spray	Brush (touch-up): Recommended for stripe coating and small areas. Care must be taken to achieve the specified dry film thickness.
Thinner (max. vol.)	RTH-104 (5%)	RTH-104(5%)
Pump ratio minimum	30:1	
Tip size	0.015" – 0.017"	
Tip pressure	150 bar / 2100 Psi	
Cleaning of tools	RTH-104	
Indicated film thickness, dry	60-70 microns	
Indicated film thickness, wet	100-130 microns	

DRYING AND CURING TIMES

Condition	Drying times are generally related to air circulation, temperature, film thickness and number of coats, and will be affected correspondingly. The figures given in the table are typical with: * Good ventilation (Outdoor exposure or free circulation of air) * Typical film thickness * One coat on top of inert substrate
Surface temperature	25 °C
Surface drying	30 min
Deep drying	3-4 h
Complete curing	7 d
Recoat interval, min	2 h
Recoat interval, max	4 days

APPLICATION CONDITIONS

Surface Preparation The surface to be painted shall be power tool cleaned to minimum Sa 2.1/2 or Sa 2 according to ISO 8501- 1:2007. It must be dry and free from dirt, grease, oil and other contaminants before application of the paint.

Substrate	Surface preparation	
	Minimum	Recommended
Carbon steel	St 2 (ISO 8501-1) or SSPC SP-2	Sa 2½ (ISO 8501-1) or NACE No. 2 / SSPC SP-10
Shop primed steel	Dry, clean and intact shop primer.	Sweep blasted or alternatively blasted to Sa 2 (ISO 8501-1) or SP 6 / NACE No. 3 (SSPC-VIS 1) of at least 70 % of the surface.
Coated surfaces	Clean, dry and undamaged compatible coating	Clean, dry and undamaged compatible coating

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

REMARKS

Subsequent coat	Epoxy Intermediate or top coat such as REP-201 or REP-302.
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 60-70 microns.
Thinning	The type and amount of thinner depend on application conditions, application method, temperature, ventilation, and substrate. RTH-104 is recommended in general. <i>(i) 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.</i> <i>(ii) 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.</i>

SAFETY

This product is intended for use of professional applicators. Applicators and operators shall use appropriate protection equipment when using this product. Use it in well ventilated environment and prevent direct contact with skin. Spillage on the skin should immediately be removed with suitable cleaner. Eye should be well flushed with water and medical cleaner.

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Product data sheet REP-106
July 2022

