

## NOBLE ZINC PHOSPHATE EPOXY PRIMER

<b>PRODUCT DESCRIPTION</b>	Noble Zinc Phosphate Epoxy Primer is a two pack polyamide epoxy resin based primer for protective coating system for steel. It has excellent anti-corrosive properties for atmospheric and immersed exposure conditions. Fully cured coating is resistant to abrasion, water and splash of mild chemicals.
<b>RECOMMENDED USES</b>	Anti-corrosive primer for structural steel, petrochemical plants, tanks and equipments. It can be overcoated with Noble Polyurethane coatings for exterior applications.

### TECHNICAL DATA

COLOUR, DRY FILM	Gray
FINISH, DRY FILM	Smooth / Matt
VOLUME SOLIDS (ASTM D2697)	52 ± 2%
SPECIFIC GRAVITY	1.55 ± 0.05 (of mix)
THEORETICAL SPREADING RANGE	13.0 – 8.6 M <sup>2</sup> /LTR
RECOMMENDED DFT RANGE (DRY FILM THICKNESS)	40 – 60 Microns/Coat
RECOMMENDED WFT RANGE (WET FILM THICKNESS)	75 – 115 Microns/Coat
FLASH POINT	25°C
FLEXIBILITY	Good
CHEMICAL RESISTANCE	Excellent
ABRASION RESISTANCE	Good
WATER RESISTANCE	Good

### DRYING TIME

Drying time @ 30°C (Temperature, humidity, air movement, 1m thickness and number of coats all affect the drying time.)

TOUCH DRY	2 – 3 hours
DRY TO RECOAT / OVERCOAT	8 – 10 hours
FULLY CURED	3 days



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### ADVANTAGES

#### NOBLE ZINC PHOSPHATE EPOXY PRIMER

Excellent anti-corrosive properties. The fully cured dry film is resistant to abrasion, splash and various mild chemicals, resistant to water.

### APPLICATION INSTRUCTION

#### SURFACE PREPARATION

Oil and grease should be removed by solvent cleaning. Sand blast to Sa2.5, then clean & dry. Apply immediately Noble Epoxy Red Oxide Primer after the steel has been blasted.

#### REPAIR

Corroded areas should be power tool cleaned to St3 or blast cleaned to Sa2 or better. Existing system should be dry and free from loose paint, salt, grease and other contaminants prior to overcoating.

### APPLICATION DATA

APPLICATION METHOD	Airless Spray	Conventional Spray	Brush
CLEANING/THINNING	Noble Epoxy Thinner		
THINNER (VOLUME)	5 - 10%	10 - 15%	5- 10%
CONV. SPRAY REQUIREMENTS	Atomizing Pressure : 40 psi		
AIRLESS SPRAY REQUIREMENTS	2200 psi		
NOZZLE SIZE	0.018" - 0.020"		
MIXING RATIO (BY VOLUME)	Base : Hardener 4 : 1 (Mix thoroughly, keep for 10 - 15 minutes)		
POT LIFE @ 30°C (100 ml)	8 hours (reduced at higher temperature) Note: Material may gel at elevated temperature.		

### SYSTEM

#### RECOMMENDED SYSTEM

To be applied on prepared surface.

#### No. of Coats x DFT (Microns)

Noble Zinc Phosphate Epoxy Primer	: 1 x 50
Noble Undercoat H.B.	: 1 x 125
Noble Polyurethane Topcoat	: 1 x 40



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### NOBLE/INTERNATIONAL TEST CERTIFICATES

Sr. No.	Test Description	Test Reference	Compliance
1	VOC	ISO 11890 – 2 GC – FID	Local Regulatory Requirements
2	VOC	USEPA 24	
3	Adhesion Strength	ASTM D 4541:02	
4	Corrosion resistance (Salt Spray test)	ASTM B117	

### ADDITIONAL DATA

<b>SHELF LIFE @ 30°C</b>	18 months, in original sealed container, with proper storage conditions.
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### HEALTH & SAFETY

<b>SAFETY PRECAUTIONS</b>	<p>As a general rule, avoid skin and eye contact by wearing overalls, gloves, goggles, and airmask etc. Spillage on skin should immediately be removed by thorough washing with water and soap or suitable cleaner. Eye should be flushed with fresh water. Avoid inhalation of vapours and paint mist by wearing suitable airmask. In the event of ingestion and eye contact, seek medical attention immediately. Painting must be carried out in well-ventilated area.</p> <p>This as industrial product, contains flammable materials and should be kept away from the sparks and open flames, smoking in the area should not be permitted. Local safety regulations should be followed.</p>
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### STORAGE & HANDLING

<b>STORAGE</b>	<p>Store the paint in proper storage conditions as per the local regulations. Keep the paint container in sealed condition under shed, away from direct sunlight and extreme temperatures. Do not stock paint material near to any ignition sources. Do not put back the half or unused material back in original container, containing the supplied paint, to avoid contamination. Handle with care. Stir well before use.</p>
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**NOTE :** We warranty only the quality of our product and this data sheet is based on results obtained from experience and tests.  
We reserve the right to change data without prior notice. For surface preparation, safety details refer specifier and safety data.

This data sheet supersedes all previous issued.  
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