MONOPOX® RP primer

epoxy

Two components fast drying modified epoxy primer / coating.

- High-grade anti-corrosive, free from lead and chrome.
- Curing at low temperatures down to -5°C.
- Application and hardening is possible at high relative humidity up to 90%.
- After hardening excellent mechanical resistance and elasticity.

Application as quick drying primer/intermediate coat for especially fast recoatable in-shop applications, for coating systems in- and outdoor exposure on steel constructions.

- When exposed direct to sunlight, coating will chalk.

Product information

Finish	Flatt
Colour	Limited
Mass density	approx. 1.5 kg/L (mixed product)
Solids content by volume	approx. 62 volume % (mixed product)
VOC	approx. 310 gr./L (volatile organic compound)
Recommended film thickness	70-100 µm d.f.t. per layer 115-160 µm w.f.t. per layer (undiluted)
Theoretical spreading rate	At 70 µm d.f.t. 8.9 m²/L At 100 µm d.f.t. 6.2 m²/L
Practical spreading rate	Depending on several factors like shape of object, profile of surface, method of application, application circumstances and experience. A few guiding principles are: Brush/roller :85-90% of the theoretical spreading rate Spraying :50-70% of the theoretical spreading rate
Flashpoint ISO 1523	Base 23°C Hardener 2V16 30°C Thinner FGM 631 26°C Thinner WTD 107 14°C
Dry temperature resistance	120°C
Durability	At least 12 months, provided that it has been stored in closed original packing at a dry and cool spot.

Drying times

For d.f.t. up to 100 µm

	30°C	20°C	10°C	5°C	0°C
Dust dry	¼ hour	½ hour	1½ hours	2½ hours	6 hours
Transportable	5 hours	10 hours	16 hours	24 hours	3 days
Complete hardening	3 days	4 days	6 days	10 days	20 days
Recoatable:					
Minimum interval	1½ hours	2 hours	5 hours	10 hours	36 hours
Maximum interval	4 days	7 days	14 days	1 month	1 month

Film thickness, ventilation, temperature and relative humidity are of great influence on the drying times.

Application instructions

Mixing ratio	Volume:	Base – hardener 2V16	84:16
	Weight:	Base – hardener 2V16	90:10

Mixing instructions

Base and hardener should be mixed and applied at temperatures above 10°C.
At lower temperatures extra thinner is needed, which gives a slighter resistance against sagging and which will delay hardening.
The components should be mixed homogeneously,
with a mechanical blender. Pay attention to the side and bottom of the can.

Induction time

At 20°C not necessary
At 10°C at least 10 minutes

Pot life after mixing

20 litre packing:	approx.	8 hours at 10°C
	approx.	4 hours at 20°C
	approx.	2 hours at 30°C

Optimal application circumstances

Temperature : 15-25°C
Humidity : 40-75%

Technical and esthetical properties can change when the product has been applied under different conditions.

Usage information

	Airless-spray	Airspray	Brush/roller
Type of thinner	FGM 631 / WTD 107	FGM 631 / WTD 107	FGM 631 / WTD 107
Recommended thinner (depending on application and equipment)	5 – 15 vol. %	5 – 20 vol. %	0 – 5 vol. %
Nozzle orifice	0.41 – 0.46 mm 0.016 – 0.018 inch	2.0 – 2.5 mm	
Nozzle pressure	150 – 180 bar	3 – 5 bar	
Maximum attainable d.f.t.	150 µm	100 µm	80 µm
Cleaning of tools	Thinner FGM 631 / WTD 107		

Surface conditions

Steel

New steel:
Blasting according to the ISO standard 8501-1:1988 Sa 2½.
Roughness profile Ra 10-12 µm Rz 50-60 µm.
Surface must be clean and dry.
Repair and maintenance:
Clean the surface thoroughly with suitable cleaning preparation or by steam cleaning.
Remove salts and other water-soluble impurity by spraying with clean tap-water under high pressure.

Remove rust a.o. by (water)blasting Sa 2½ or derust mechanical until St. 2-3.
Apply the recommended paint system on a clean surface.

- Mechanical or hand derusting gives less quality than (water)blasting and will result in less protection of the applied paint system.

MONOPOX® RP primer

epoxy

Product Characteristics

No coating work shall be carried out when the temperature of the surface is less than 3°C above dewpoint and when the substrate temperature is below 5°C.

Due to the presence of solvents, applying this product in confined spaces, adequate ventilation has to be ensured.

At low temperature and under humid conditions, amine blushing can occur, which can effect the intercoat adhesion negatively. Prior to the application of the next layer, the previous layer must be checked for this phenomena.

Discoloration or loss of gloss or other surface defects, can occur during drying and curing by condensation and or early water spotting. In particular bright and ''full'' colours.

This coating product is based on epoxy technology. It is recommendable that it should be overcoated with a durable finish.

Maximum film build in one coat is best attained by airless spray. Application by other techniques, it may be necessary to apply multiple coats in order to achieve the total specified dry film thickness.

Safety description

See safety data sheet

Ventilation rules

Minimum required quantity of air to comply with:

	MAC	10 % LEL
Monopox RP primer	825 m³/L	42 m³/L
Thinner FGM 631	3995 m³/L	160 m³/L
Thinner WTD 107	4085 m³/L	168 m³/L

MAC = Maximum Accepted Concentration
LEL = Lower Explosion Limit
Also consult the safety information sheets

Pretreatment / Labeling / Technical Terms (downloadable from www.zandleven.com)

A 1 Labeling of paint products in the European Community
A 2 Physical data
A 3 Persistency list for Monopox HB systems
A 4 General guidelines for steelpreservation
A 5 General guidelines for the application of Acraton plastics
A 6 Pretreatment of construction steel

These data have been drawn up to the best of our knowledge and were correct at the date of issue. However we cannot accept full responsibility, because de choice of products and circumstances during elaboration of the systems fall outside our judgement.
This documentation sheet will not automatically be replaced in case of modification.
English language text is a translation. In case of doubt the Dutch language original text has to be consulted as the authoritative text.