

PRODUCT DESCRIPTION

Subaxy Primer is a two-pack epoxy primer designed for use as a high performance primer for many types of surfaces i.e. aluminium, galvanizing, steelwork, concrete.

INTENDED USE

As a primer for bridges, tanks external and other steel structures used in medium corrosive atmospheric environments, or pipelines, equipment, machinery and steel structures in chemical factory and power plant, and as a special primer which can be applied on the old film directly.

GENERAL PROPERTIES

Colour	: Reddish Brown and Light Grey
Gloss Level	: Matt
Volume Solids	: 58 ± 2 % (mixed)
Specific Gravity	: 1.28 ± 0.05 kg/l (mixed)
Flash point	: Base 24°C Hardener 24°C Mixed 24°C
VOC	: 396 g/l (mixed, by calculation)

SURFACE PREPARATION

All surfaces should be clean, dry and free from contamination. The surface should be assessed and treated in accordance with ISO 8504. Oil or grease should be removed in accordance with SSPC-SP1 solvent cleaning.

Abrasive Blast Cleaning

Abrasive blast cleaning to Sa 2^{1/2} (ISO 8501-1:2007). If oxidation has occurred between the blasting and application of this product, the surface should be reblasted to the specified visual standard. Surface defect revealed by the blast cleaning process should be ground, filled or treated in the appropriate manner.

Damaged Area

Damage area should be prepared with abrasive blast cleaning to Sa 2^{1/2} (ISO 8501-1:2007). When abrasive blasting is not possible, mechanical cleaning to St 3 (ISO 8501-1:2007) is acceptable. After the surface preparation the application of Subaxy Primer can be performed.

Subaxy Primer should be applied over a surface that is dry and free from all contamination and must be applied within the overcoating intervals specified (refer to application section for details).

Other Surfaces

The coating may be used on other substrates. Please contact your local Tsubasa Paint office for more information.

CONDITION DURING APPLICATION

Avoid paint application when the temperature is below 10°C or above 45°C and relative humidity is over 80%. The temperature of steel surface must be a minimum 3°C above dew point of surrounding air.

APPLICATION GUIDED

Mixing Ratio	: Base: hardener = 4 : 1 (by volume) Base and hardener should be mixed thoroughly before use.
Pot Life	: 5hrs/ 25°C
Theoretical Coverage	: 7.3 m ² /liter at 80µm DFT
Thinner	: Subaxy Thinner

APPLICATION METHOD

Brush and roll is suitable for stripe coating and very small areas. For best result, use airless spray. Care must be taken to achieve the specified dry film thickness.

APPLICATION DETAILS

Airless Spray	: Tip Size	: 0.017" – 0.031"
	: Pressure at nozzle	: 140-170 kg/cm ²
Typical Thickness	: 60 - 120 µm, dry film	
	: 103 - 207 µm, wet film	
Drying Time	: Substrate Temperature	: 25°C 40°C
	: Surface Dry	: 1hr 0.5hrs
	: Through Dry	: 4hrs 2hrs
	: Cured	: 7days 3.5days
	: Dry to recoat (min)	: 4hrs 2hrs
	: Dry to recoat (max)	: None

The given data must be considered as guidelines only. The actual drying time/times before recoating may be shorter or longer, depending on film thickness, ventilation, humidity, underlying paint system, requirement for early handling and mechanical strength etc. A complete system can be described on a system sheet, where all parameters and special conditions could be included.

RECOMMENDED PAINTING SYSTEM

The following Topcoat are recommended for Subaxy Primer:

Top coat

- Subaxy Top coat
- Subathane Top coat

For the choice of coating system for different application, refer to the product brochure or contact Tsubasa Paint for professional recommendation..

PACKAGING

Unit	Base		Hardener	
	Volume	Container Size	Volume	Container Size
4.5L	3.6L	5L	0.9L	1L
18L	14.4L	20L	3.6L	5L

STORAGE

Shelf life : Part A: 12 months (25°C)
Part B: 24 months (25°C)

Subject to re-inspection thereafter. Higher temperature during storage may reduce the shelf life and may lead to gelling in the tin.

Store in tightly closed container in a dry, cool and well ventilated space, keep away from sources of heat and ignition.

HEALTH AND SAFETY

Please observe the precautionary notices displayed on the container. Use under well ventilated conditions. Do not breathe or inhale mist. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water and medical attention sought immediately.

For detailed information on the health and safety hazards and precautions for use of this product, refer to the Material Safety Data Sheet.

DISCLAIMER

The information in this data sheet is given to the best of our knowledge based on laboratory testing and practical experience. However, as the product can be used under conditions beyond our control, we can only guarantee the quality of the product itself. We also reserve the right to change the given data without notice. Minor product variations may be implemented in order to comply with local requirements. If there is any inconsistency in the text the English (UK) version will prevail.