

PRODUCT DESCRIPTION

Subaxy Shop Primer is a single component base on modified bisphenol A epoxy resin, fast dry, designed to curing at room temperature or under baking conditions, suitable for more types of substrates, providing excellent adhesion, and easy application.

INTENDED USE

As a pre-construction primer on blast cleaned steel surfaces in automatic shoppriming plants to protect steel during transport, storage and production.

Suitable as a holding primer for corrosion classes, ISO 12944

GENERAL PROPERTIES

Colour	: Grey, White
Gloss Level	: Matt
Volume Solids, %	: 23 ± 2 %
Specific Gravity	: 1.18 ± 0.05 kg/l
Flash point	: 27°C
VOC	: 700 g/l (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.

Subaxy Shop 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).

CONDITION DURING APPLICATION

Avoid paint application when the temperature is below 10°C or above 45°C and relative humidity is over 85%. The temperature of steel surface must be a minimum 3°C above dew point of surrounding air.

APPLICATION GUIDED

Mixing Ratio.

Mixing ratio with Subaxy Shop Primer	by weight
Subaxy Shop Primer	100 (wt)
Shop Primer Thinner	30-50 (wt)
Should be mixed thoroughly before use	

APPLICATION METHOD

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

APPLICATION DETAILS

Spraygun

Tip Size	: 0.015"	0.021"
Pressure at nozzle	: 100	150 kg/cm ²

Typical Thickness

Dry film thickness	: 15	25 µm
Wet film thickness	: 65	109 µm
Theoretical spreading rate	: 15.33	9.2 m ² /liter

Drying Time

Substrate Temperature	: 25°C	40°C
Surface Dry	: 10 min.	5 min.
Through Dry	: 1 hr	0.5 hr
Cured	: 7 days	3.5 days
Dry to recoat (min)	: 1hr	0.5hr
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 paint system is recommended for Subaxy Shop Primer:

On Sa 2½, 1 coat x 20µm dry film thickness.

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

PACKAGING

Unit	Volume	Container Size
4.5L	4.5L	5L
18L	18L	20L

STORAGE

Shelf life : 12 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.