

## Description

**Archo-Rigidon 300E PRIMER RED** is a two-pack Epoxy Zinc Phosphate Primer with a high resin content designed to achieve maximum adhesion to grit blasted steel.

## Principal Characteristics

- \* High bond strength
- \* High anti-corrosive properties
- \* Quick drying
- \* Easy application properties
- \* Long pot life

## Application Instructions

### Surface Preparation

Blast-Cleaning to Sa 2½ (ISO 850 1-1:1988/SS 05 5900). Minimum profile 50µ (angular). Galvanized areas must be undamaged, degreased and dry.

### Application

Mix the epoxy and activator in the proportions given. Mechanical slow mixing is preferable. Apply by brush airless spray or conventional spray.

### Cleaning Equipment

Clean all equipment with Archco E Thinners or Archco Water Soluble Cleaner.

### Toxicity

Although Archco Epoxy Resins are relatively non-toxic, it is recommended that the normal precautions in dealing with conventional Epoxy systems are adhered to.

PRIMER TYPE	EPOXY
Colour	Red
Catalyst Type	Polyamide
Volume Solids	40%
Specific Gravity	1.3
Dry Film Thickness per coat	30-40µ
Theoretical Spreading Rate	10m <sup>2</sup> /L
Practical Spreading Rate	8m <sup>2</sup> /L
Max. Humidity During Application	90%
Min. Substrate Temperature	5°C
Min. Dewpoint/Substrate Differential	+3°C
Flashpoint	26°C
Application Method	Airless Spray, Brush
Airless Spray Tip Size	(0.46-0.69mm)
Pressure at Tip	15Mpa
Pot Life	5 hrs @ 25°C
Overcoating Times	Min. 2hrs Max. 21 days
Dilution	5% maximum
Tool Cleaning Solvent	E. Thinners
Storage Temperature Limits	5°C - 35°C
Shelf Life	12 months
Ventilation	Do not use in confined spaces without adequate ventilation or breathing equipments.
Lighting – Heating in an enclosed environment	Use only BASEFA Zone 1 EEx d IIA T1 or better