



TECHNICAL DATA SHEET

STOKES EPOXY ZINC PHOSPHATE TWIN PACK PRIMER

Reference	Revision No	Revision Date	Printed	Page 1 of 2
EPZPTP	2	10 March 2008	10 March 2008	

WWW.RJSTOKES.CO.UK MANUFACTURERS OF INDUSTRIAL, DECORATIVE & POWDER COATINGS Est 1899
Little London Road | Sheffield | S8 0UH | Tel: 0114 258 9595 | Fax: 0114 250 9836 | Email: sales@rjstokes.co.uk

Properties and Uses	<p>PROPERTIES Quick Drying Anti-Corrosive Twin Pack Epoxy Primer, ready for use when Base and Activator are thoroughly mixed together. It gives good resistance to salt spray and possesses excellent adhesion and flexibility. This primer is capable of being applied at a wet film thickness of 200 microns without sagging occurring.</p> <p>USES. Primer for structural steel, industrial machinery and plant also with a wide range of engineered articles and castings etc.</p>
Technical Data	<p>TYPE. Epoxy / Polyamide resin system with Zinc Phosphate and carefully selected inert pigments and extenders. This material is free from chromate pigments.</p> <p>DRYING TIME. Touch dry within one hour to BS 3900 Part C2 under normal conditions of temperature and humidity. Handleable after four hours. Recoatable within one hour.</p> <p>MIXING RATIO Thoroughly mix 3 parts of Base with 1 part of Activator (by volume).</p> <p>POT LIFE. After mixing Base & Activator in the recommended proportions the paint will remain usable for between 6 - 8 hours at ambient temperatures.</p> <p>THEORETICAL SPREADING CAPACITY. Approximately 7.5 - 9.5 sq. metres per litre to achieve a dry film thickness 40 - 50 microns on smooth non-porous surfaces.</p> <p>FLASH POINT. Below 21°C. HIGHLY FLAMMABLE LIQUID.</p> <p>NON VOLATILE CONTENT. By volume 38% (nominal) when Base is mixed with Activator. By weight 58% (nominal) when Base is mixed with Activator.</p> <p>THINNERS AND CLEANING SOLVENT. Stokes Thinner Ref. TH042 The use of other thinners is not recommended.</p> <p>HEAT RESISTANCE. Up to 150°C.</p> <p>OIL RESISTANCE. Good resistance to most hot and cold lubrication and cutting oils. Tests for suitability with any particular oil should be made before large scale application.</p> <p>CHEMICAL RESISTANCE. Good resistance to most common dilute acid and alkalis. Tests should be made for resistance to any particular reagent before large scale application.</p> <p>LEAD CONTENT. Below 0.15%</p> <p>COLOUR RANGE Light Grey Ref. EP305 Other colours available by special arrangement.</p>
Stock Container Sizes	Composite pack size 20 litre.

STOKES EPOXY ZINC PHOSPHATE TWIN PACK PRIMER

Reference	Revision No	Revision Date	Printed	Page 2 of 2
EPZPTP	2	10 March 2008	10 March 2008	

WWW.RJSTOKES.CO.UK MANUFACTURERS OF INDUSTRIAL, DECORATIVE & POWDER COATINGS Est 1899
Little London Road | Sheffield | S8 0UH | Tel: 0114 258 9595 | Fax: 0114 250 9836 | Email: sales@rjstokes.co.uk

Processes	<p>PREPARATION. The surface to be painted must be clean, dry and free from grease, dust, dirt, rust, peeling or loose material or any other contamination. Do not apply at temperatures below 5øC or when dew point conditions prevail.</p> <p>FINISHING. Overcoat with most types of paint including Epoxy finishing coats. For optimum intercoat adhesion it is recommended that the primer is re-coated within three days with an Epoxy finishing point. If the primer is allowed to dry for longer than three days it will be necessary to abrade it in order to achieve good intercoat adhesion. Similarly if overcoating the primer with finishing coats based on `mild ' solvents (i.e. White Spirit) it will also be necessary to abrade the primer. When re-coating with paints other than Epoxy types it is recommended that trials are first carried out to prove its suitability before large scale application.</p>
Application	<p>BRUSH. Not satisfactory other than for Touch up work.</p> <p>CONVENTIONAL SPRAY. After mixing Base and Activator in correct ratio thin with approx. 10 - 15% of Stokes Thinner Ref. TH042.</p> <p>AIRLESS SPRAY. After mixing Base and Activator in correct ratio thin with approx. 5 - 10% of Stokes Thinner Ref. TH042. Recommended Spraying Conditions. Spray Gun Tip size 15 thou. Pump pressure 1500 - 2000 p.s.i. Pump Ratio 20 - 30 : 1</p>
Storage	<p>"Use within 12 months of delivery. Keep in original containers until required for use. Partly used containers should be re-sealed securely and stored according to the recommended manner. (See section 7 of Stokes Material Safety Data Sheet Ref. EP/XM018).</p>
Health and Safety	<p>THIS MATERIAL IS HIGHLY FLAMMABLE. REFER TO STOKES MATERIAL SAFETY DATA SHEET REF. EP/XM018 FOR FULL DETAILS OF FIRST AID, FIRE FIGHTING, ACCIDENTAL RELEASE, HANDLING, EXPOSURE CONTROLS / PERSONAL PROTECTION AND DISPOSAL.</p>
Disclaimer	<p>The above information is for guidance only. It is given in good faith but without warranty. Users should first carry out their own trials to ascertain the suitability of the product for their intended purpose.</p> <p>This Data Sheet supercedes all previous Data Sheets supplied to you relating to this product. It contains important information which must be communicated to the user. The user must satisfy himself of the suitability of the product for the intended application and surface, as surface and application conditions are beyond the control of R.J.Stokes & Co Ltd. The user must also satisfy himself of the suitability of the product in circumstances other than those set out in this data sheet. The user should also maintain appropriate control procedures. Should further information be required, please contact our Technical Department.</p> <p>R.J.Stokes & Co. Ltd. employ a policy of continuous development and the technical data could be revised as a result of experience or new information becoming available.</p>