



TECHNICAL DATA

PRODUCT: OASIS 8400HS EPOXY ZINC PHOSPHATE PRIMER/BUILDCOAT

Description	:	OASIS 8400HS EPOXY ZINC PHOSPHATE PRIMER/BUILDCOAT.			
Material Type	:	High solid two pack epoxy zinc phosphate primer/buildcoat.			
Recommended Use	:	Corrosion protection of carbon steel surfaces prepared by abrasive blast cleaning. Can be applied between 72-250µm dry film thickness , to provide both primer and buildcoat in a single application. To prevent loss of colour and gloss, a UV light stable finish coat may be applied. It should be noted that even when applied as a single coat, the material will provide excellent anticorrosive protection. Tolerant to application over manually prepared surface. Oasis Epoxy 8400HS is not recommended for immersion.			
Volume Solids (%)	:	75 ± 3% (ASTM-D2697-91)			
Flash Point	:	Base: 24°C		Additive : 26°C	
Specific Gravity (Kg/Ltr)	:	1.60 (Mixed) may vary with shade			
V.O.C.	:	217 gms/litre			
Colours	:	Red oxide, light Grey, Off White, light and Dark Grey, MIO and Aluminium.			
Pack Size	:	5 Litre and 20 Litre units when mixed.			
Shelf Life	:	Minimum 2 years			
Mixing Ratio	:	4.7 parts base to 1 part additive by volume			
Theoretical Spread Rate (m ² /Ltr)	:	7.5 m ² /Litre			
		Airless Spray	Conventional Spray	Brush	Roller
@ Dry Film Thickness	:	100 µm	100 µm	50 µm	65 µm
@ Wet Film Thickness	:	133 µm	133 µm	67 µm	87 µm
		<i>Spreading rates are calculated and due allowance for loss and wastage should be made.</i>			
Drying Time @ temperature	:	15°C	25°C	35°C	
To Touch	:	2 hours	1 1/2 hours	1 hour	
To Overcoat (Minimum)	:	6 hours	4 hours	3 hours	
To Handle	:	16 hours	8 hours	5 hours	
		These figures are given as a guide only. Factors such as air movement and humidity must also be considered.			
Cleanser or Thinner	:	Oasis Thinner No: 5			
Pot Life	:	15°C 3 hours	23°C 2 hours	35°C 1 hour	
Recommended Top Coats	:	Indefinitely overcoatable with epoxy systems provided that the surfaces to be Coated have been suitably cleaned. Where High Degree of gloss and colour retention is required Oasis 8137 Acrylic Polyurethane, Oasis 8237 Undercoat Matt Finish. Topcoat should be applied at a minimum 50 micron. To achieve optimum adhesion, over coating should be undertaken within 7days at 23°C or within 4 days at 35°C.			
Application Notes	:	Dilution up to 5-10 % by volume may be required according to type of equipment and application method.			
Application Methods	:	Airless spray, Conventional Spray, Roller, Brush			

SAFETY, HEALTH & ENVIRONMENTAL INFORMATION (READ THIS SECTION BEFORE USE) SOLVENT BASED PAINT PRODUCT

- Flammable. Keep away from sources of ignition. Do not smoke.
- Work only in areas of good ventilation. When used indoors always keep doors and windows fully open during application and drying. When applying for short periods only, a suitable cartridge mask may be worn provided the filter is changed regularly. All respiratory equipment must be suitable for the purpose and meet an appropriate standard approved by the HSE. Refer to your COSSH Assessment.
- When applying paint it is advisable to wear suitable eye protection. In case of contact with eyes, rinse immediately with plenty of water and seek medical advice.
Remove splashes from skin : use soap and water or a recognised skin cleaner.
- Keep container tightly closed and keep out of reach of children. Do not use or store by hanging on a hook. Do not empty into wadis, drains or watercourses.
- Contains no added mercury.
*This data is subject to change without notice. Please ensure you have the latest copy by checking with our Customer Service Department.

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APPLICATION DATA

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SURFACE PREPARATION

For better performance we recommend blast clean to Sa 2 ½ BS 7079: Part A1: 1989 (ISO 8501-1: 1988). Average surface profile should be in the range 50-75µ. Manually prepared surfaces should be to a minimum standard of St 3 BS 7079: Part A1: 1989 at the time of coating. Ensure surfaces to be coated are dry and free from all traces of surface contaminants. Can be applied a wide range of prefabrication primers, including Inorganic Silicate, polyvinyl butyral and epoxy types.

APPLICATION EQUIPMENT

Airless Spray

For Wft application 75-125µm

For Wft application 125-350µm

Nozzle Size	0.33-0.38mm (13-15 thou)	0.38-0.43mm (13-17 thou)
Fan Angle	40°	40°
Operating Pressure	155kg/cm ² (2200psi)	155kg/cm ² (2200psi)

The airless spray details given above are intended as a guide only. Fluid hose length and diameter, paint temperature and project complexity all have an effect on the choice of spray tip and operating pressure. The operating pressure should be the lowest possible consistent with satisfactory atomization. As conditions vary, it is the applicators' responsibility to ensure that the equipment in use has been adjusted to give optimum performance. In case of any difficulties or queries, please contact Al Gurg Paints L.L.C.

Conventional Spray

Nozzle Size	1.27mm (50 thou)
Atomising Pressure	2.8 kg/cm ² (40 psi)
Fluid Pressure	0.4 kg/cm ² (6 psi)

The conventional spray details given above are intended as a guide only. It may be found that in some circumstances, slight variations in atomizing pressure, fluid pressure and alteration of tip arrangements may provide optimum atomization. For application by conventional spray, thinning with up to 10% Thinner No. 5 may be required. Adjustment for wet film thickness should be allowed. Thinning will affect VOC compliance.

Brush and Roller

The material is suitable for brush and roller application to small areas only. Application of more than one coat may be required to give the equivalent dry film thickness to one spray applied coat.

APPLICATION CONDITIONS AND OVERCOATING:

In conditions of high relative humidity, i.e. 80-85% good ventilation is essential. Substrate temperature should be at least 3°C above the dew point. At application temperatures below 10°C, drying times will be significantly extended and spraying characteristics may be impaired. Application at temperatures below 5°C is not recommended. In order to achieve optimum water and chemical resistance the temperature needs to be maintained above 10°C whilst curing. For application at elevated temperatures, please see the note below.

ADDITIONAL NOTES

Drying, curing times should be considered as a guide only. For spraying maximum 5 to 10% dilution is recommended, The curing reaction of epoxies commences immediately the two components are mixed.

Due to the reaction being temperature dependant, the curing and potlife will be approximately halved by a 10°C increase in temperature and doubled by a 10°C decrease in temperature.

Epoxy Coatings – Colour Stability:

Variable colour stability is a feature of all epoxy materials, which tend to yellow and darken with age particularly when used on internal areas. Owing to this colour change, areas subsequently touched up may be obvious.

When epoxy material are exposed to ultraviolet light, a surface chalking effect will develop. The phenomenon results in the formation of fine powder coating at the coating surface, which gives rise to a colour variation as well as a reduced gloss.

This effect is cosmetic only and in no way detracts from the performance of the product.

Should a full colour stable finish be required, Please follow recommendation in the recommended topcoat section.

Epoxy Coatings - Tropical Use

To ensure a satisfactory working pot life, the temperature of Oasis 8400HS Epoxy Primer/Buildcoat should not exceed 35°C at the time of mixing. Thinning the mixed product at any stage will not significantly extend the working pot life. Application outside the working pot life, even if the material appears to be fit for use, may result in inferior adhesion properties. The recommended maximum air and substrate temperature for the application of epoxies is 45°C, providing that the conditions allow for satisfactory application and film formation. If the air and substrate temperatures exceed 45°C during application, paint film defects such as dry spray, bubbling and pinholing etc. may occur. Numerical values quoted for physical data may vary slightly on individual batches.

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