

## Two-component Classical PDA Epoxy Primer

Conventional two-component polyamide epoxy primer. Quick drying product, excellent anti-corrosion protection, free of heavy metals, high hardness and good flexibility.

This product complies with ABNT NBR 11702 type 4.1.1.9

### USE RECOMMENDATIONS

Indicated as an anticorrosive primer in the preparation of metallic surfaces in general, which will be exposed to humidity, chemical and physical attacks of low to medium aggressiveness. The product can be applied in tanks, metallic structures in general, machines, equipment, among others. The product offers good moisture resistance.

### BASIC PROPERTIES

<b>Colors</b>	Light Gray
<b>Finish</b>	Matte
<b>Solids per Mass</b>	60% ± 2
<b>Solids per Volume</b>	46% ± 2
<b>VOC</b>	377.45 g/L
<b>Specific Weight at 25°C</b>	1.29 g/cm <sup>3</sup> (approximate value)
<b>Flash Point</b>	38°C
<b>Storage time</b>	Component A 36 months Component B 12 months
<b>Toxicity</b>	Consult MSDS
<b>Type of packaging</b>	Component A 2.7 L Component B 900 mL
<b>Shelf life of the mixture</b>	Up to 4 hours after mixing components

This information represents the best of our knowledge when this document was published. We remind you that optimal final results when applying the products depend on factors that exceed our control and that concern the surface preparation and the technical knowledge of the applicator. The company reserves the right to change these specifications without prior notice.

## APPLICATION DATA

### Mix ratio

Ratio of three parts of component A to one part of component B, diluting 15 to 20% as needed.

Example: 2.7L of Component A + 900 mL of Component B.

Add component A to component B while stirring and dilute. Wait 30 minutes for reaction induction and after starting the application.

### Recommended number of coats

Apply 1 cross-coat, or as needed, respecting an interval of 16 to 24 hours between coats.

### Thickness per coat:

Wet film thickness – 75 to 100  $\mu\text{m}$

Dry film thickness – 30 to 40  $\mu\text{m}$

### Theoretical spreading rate:

23 to 29  $\text{m}^2/\text{gallon}/\text{coat}$  catalyzed

Comments: Spreading rate values may vary according to application method, dilution, environmental conditions, and surface, and are calculated at the recommended dry coat thickness.

### Dilution:

15% to 20% by volume. Reducer Anjo Thinner 4000

## DRYING

### Temperature

**25°C**

To Touch

1 hour

Handling

5 hours

Repainting

8 – 48 hours

Full cure

7 days

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**Considerations:** If the maximum limit indicated for repainting is exceeded, it will be necessary to sand the surface. Relative Air Humidity Condition: 55 to 80%. The useful life time of the mixture varies with the temperature (high temperatures – low pot-life, low temperatures high pot-life), so we recommend keeping the catalyzed material indoors, avoiding direct sunlight on the product. When this is not possible, pay attention to the catalyzed amount, reducing the prepared volume as much as possible. As it is a chemical reaction curing product, curing may be delayed at low temperatures. A minimum temperature of 15°C must be ensured during curing.

### **SURFACE PREPARATION - ABNT NBR 13.245 Standard**

The surface must be dry, firm and dust free, free of contaminants such as: oils, salts, grease, fat, dust, etc.

Loose or poorly adhered parts must be scraped and/or brushed.

On aged paint, sand superficially, leaving the surface free from shine and removing loose particles. Before starting painting, observe the following instructions:

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TYPE OF SURFACE	TREATMENT
Metal structures in general	Sand the surface eliminating rust or loose parts. Eliminate oily contaminants or dust with a cloth dampened with Anjo Degreaser solution. Apply the Anjo Classical PDA Epoxy Primer and wait for a 16 to 24 hour interval between coats to apply the finish paint.
Wood	Sand the surface, eliminating splinters and/or loose parts. Eliminate the dust. Apply the Anjo Classical PDA Epoxy Primer and wait for a 16 to 24 hour interval between coats to apply the finish paint. Green wood should not be painted
Concrete floor	Plaster and concrete surfaces: wait for curing for at least 28 days until the appearance is very firm and free of lime. Previously wash with a 10% muriatic acid solution. Rinse with plenty of water and allow to dry completely. Apply a coat of epoxy floor sealer using a brush, roller or conventional spray gun. Do not apply with temperatures below 10°C and relative humidity above 80%. Apply the Anjo Classical PDA Epoxy Primer and wait for a 16 to 24 hour interval between coats to apply the finish paint.
Masonry Walls	Wait for the cement to cure for at least 28 days. If you wish to apply putty, it is mandatory to apply Anjo Acrylic Putty and a coat of Classical PDA Epoxy Prime.
Fat or grease stains	Wash with water and detergent, rinse and wait for drying.

## APPLICATION METHOD

### Airless pistol:

Using Airless.....60:1  
 Fluid pressure..... 1500 - 2000 psi  
 Hose.....1/4" diameter  
 Internal Nozzle.....0.013" -0.15"  
 Filter..... Mesh 60

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Dilution..... Max. 5%

**Conventional spray gun:**

Spray gun..... JGA 502/3 Devilbiss

Fluid nozzle ..... FX

Air cap .....704

Atomization pressure ..... 60 to 65

psi Pressure in the tank ..... 10 to 20 psi

Dilution.....Max. 20%

**Brush:**

Recommended only for touch-ups of small areas or “stripe coat” (bolts, nuts, weld beads, sharp corners and touch-ups).

**Roll:**

Use sheepskin or synthetic wool rollers for low-pile epoxy paints (5.0mm).

**Note:**

- 1- For application by brush or roller, it may be necessary to apply in two or more passes to obtain an even coat according to the recommended film thickness per coat.
- 2- Do not apply with relative humidity above 85%.
- 3- Only apply if the substrate temperature is at least 3°C above the dew point.
- 4- Do not let the catalyzed product remain in contact with the hoses, spray guns and equipment used in the application; for temperatures above those described in the pot-life table, the paint will present variation in its fluidity and will harden, which will hinder cleaning.
- 5- Thoroughly wash all equipment used.

**APPLICATION INSTRUCTIONS**

The following data serves as a guide, similar equipment may be used. Changes in pressures and nozzle sizes may be required to improve spray characteristics. Before application, make sure that the equipment and its components are clean and in the best condition.

Purge the compressed air line to prevent paint contamination. After mixing the two-component products, if there are interruptions in the application, and their pot-life has

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been exceeded (paint shows variation in fluidity), the product may not be diluted again for later application.

Reinforce all sharp corners, cracks and weld beads with a brush to prevent premature failure in these areas. When applying by spraying, make a 50% overlap of each pass of the spray gun to avoid uncovered and unprotected areas, ending with a cross-pass.

Before starting any painting, always pay attention to the following procedure:

**Sand:** sand the surface, removing loose parts and promoting greater adhesion to the product that will be subsequently applied.

**Clean:** Clean with a cloth or broom to remove dust from the surface and ensure adherence of the product that will be applied to the surface.

**Seal:** The use of sealer evens out surface absorption, in addition to significantly improving the spreading rate of the product to be applied.

**Homogenize:** Homogenization is required for the complete mixing of all paint components, as well as the dispersion of pigments. As the product will be kept in stock, this operation is indispensable for the characteristics to remain unchanged.

**Dilute:** dilution must observe the recommended instructions, so that the product can offer excellent performance such as coverage, spreading rate, leveling and application.

**Apply:** always pay attention to loose or badly adhered parts of the substrate, in these cases, the surface preparation recommendations must be observed. In the case of cuts, always make the cut first with a brush and then apply with a roller. Application with a roller must be carried out following the procedure: apply in an M shape, turning the application in W direction.

The product is supplied in two packages. Component A and Component B. Homogenize the content of each component by means of mechanical or pneumatic agitation (A and B separately). Ensure that no sediment is trapped at the bottom of each package.

**Mixture:** add component B to component A, in the proportions (volume) indicated, while stirring, until complete homogenization, respecting the mixture ratio.

Mixture ratio 3 parts of Comp. A for 1 part of Comp. B in volume

Recommended Thinner – Epoxy Thinner – Thinner 4000

Dilution: depending on the application method, dilute up to 20% by volume.

Only add the Diluent after completing the mixture of components A + B.

Do not dilute with solvents that are not allowed by local legislation and do not exceed the indicated dilution percentage. Excessive dilution of the paint may affect film formation, appearance and make it difficult to obtain the specified thickness.

Induction time: wait 30 minutes before application when room temperature is low.

## SAFETY RECOMMENDATION

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Before handling this product, it is essential to carefully read all the information contained in its material safety data sheet (MSDS), available on our website or request it directly from our Customer Service (0800487777).

Surface preparation, handling and use of paint during painting and drying, since these are flammable products, must be carried out in ventilated spaces, away from flames, sparks or excessive heat, using the personal protective equipment (PPE) appropriate for the step to be performed. Contact with the skin can cause irritation.

If ingested, do not induce vomiting. In case of contact with eyes, rinse thoroughly with water. In either case, seek medical attention immediately. Do not smoke in the work area. Make sure that the electrical installations are perfect and do not produce sparks.

Do not use thinner to clean the skin, hands or other parts of the body. To clean hands use alcohol, then wash with water and appropriate cleaning pastes. In case of fire, use CO<sub>2</sub> or chemical powder extinguishers. It is not recommended to use water to extinguish the fire produced by burning paint. The storage of paints and thinners must be done in ventilated places and protected from weathering. The temperature can range from 10 to 40°C. If symptoms of intoxication occur due to the inhaling of chemical vapors, the intoxicated person must be immediately removed from the workplace to ventilated areas.

In case of fainting, call a doctor immediately. Product intended for use and handling by professionals connected to the painting industry. The application and use of this product must be carried out in accordance with all National Health, Safety and Environmental standards and regulations. If it is necessary to remove the already applied and hardened paint from the substrate, the operator and individuals in the same environment must use the appropriate personal protective equipment (PPE) as indicated in the material safety data sheet (MSDS). Store the product in sheltered, ventilated environments with a maximum temperature of 40°C. In situations where there is a need to weld metal parts painted with this product, dust and gases (smoke) will be released, which will require the use of appropriate personal protective equipment (masks with activated carbon filters and even air supply equipment) according to each environment. Applications in confined areas require adequate ventilation and specific methods and procedures. For these situations, contact your company's safety area.

## **COMMENTS**

In order to provide and ensure the quality of the products, it is essential to use our complete Anjo painting system (bases, putties, thinners and finishes) observing the instructions contained on the packaging or in the technical report.

Do not store the diluted product. The spreading rate of this product will vary according to the type of surface and the painting system to be used, the thickness applied,

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method and application technique, the type and roughness of the substrate and environmental conditions, etc.

The values found for the specific weight and drying tests (with the specified thickness) were obtained in the laboratory at a temperature of 25°C. With temperatures other than those mentioned, the values established above tend to be different from those specified.

The instructions contained in these specifications are based on our experience and technical knowledge; however, some factors are beyond our control as a manufacturer, such as: surface preparation, application, working conditions, etc.

The use of solvents other than those specified without prior approval from Anjo may affect product performance and void product warranty.

We take no responsibility for material and personal damage caused by the misuse of the information contained in these specifications and of the products mentioned.

These specifications are subject to change without prior notice.

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