

## PRODUCT CHARACTERISTICS

**Solvent-free** high temperature epoxy Novolac primer with exceptional surface tolerant properties. Outstanding adhesion to less prepared substrates, ideal for application in confined spaces, tanks, pipes, floors and structures.  
Innovative single coat maintenance system.  
Zero VOC.  
Recommended to be used as a primer for RW 500 series Novolac glassflake topcoat or RU 500 Ceramic system.

## PRODUCT DESCRIPTION

Two pack **solvent-free** epoxy Novolac primer.  
Outstanding high gloss finish.  
As in all epoxies, the product can change colour or fade when exposed to UV. Colour changes are not detrimental to performance of the system.  
In cold and wet condition, amine blooming can occur.  
**For all colour decorative finish, apply one of Chemco's UV resistant topcoats.**

## PRODUCT INFORMATION

Colour:	Standard khaki grey (RAL 7008) (other colours at customers request).	
Volume solids:	100%	
Typical density:	1.3 ± 0.1	
Mix ratio:	Mix part A (resin RE 500P) and part B (hardener HE 500P) in proportionate weights as supplied.	
Cure:	Catalyst induced cross-linking polymerisation.	
Typical thickness range:	50 - 250µ per coat.	
Theoretical coverage:	7.7m <sup>2</sup> /kgs @ 100µ (Allow for application losses, surface irregularities, etc).	
Temperature resistance:	150°C	
Pack sizes:	5 and 20 kgs	

## APPLICATION DATA

Method:	Airless spray, roller, brush or trowel.	
Thinner:	T5 (max 5% if required). Use 2.5 - 5% for spray application in cold conditions and/or long hoses over 50m.	
Cleaner:	S11A	
Recoating interval @ 20°C:	Min:	4 - 8 hrs (touch dry).
	Max:	24 hrs
Pot life:	45 mins @ 20°C	
Cure:	36 hrs - 7 days (depending on temperature and other environmental conditions).	

## APPLICATION

Constituents:	Two pack epoxy system consisting of base resin and hardener.	
Mixing:	Part <b>A</b> (resin) and part <b>B</b> (hardener) are supplied in separate containers. Always mix part <b>A</b> prior to addition of part <b>B</b> . Part mixing is <b>not</b> recommended unless accurate scales are available.	
Airless spray:	Pump:	Minimum 45:1 ratio (preferably 63:1), large volume delivery is essential.
	Tip size:	(17 - 19 thou.) 60°angle, heavy duty reversible.
	Tip pressure:	3,000psi minimum. Use as shorter line as possible.
Brush or roller:	Remove all filters from the gun and pump. For inaccessible or awkward areas or when spray application is not required or feasible.	

## LIMITATIONS

Pot life:	Dependant on ambient and material temperature, the hotter the material the shorter the pot life. Vigilant care and attention to pot life is required during application. If gelling has started, do not apply.
Airless spraying:	Preferably keep the material at room temperature when airless spraying.
Environmental conditions:	Minimum steel/ambient temperature of 5°C is required for effective cure. At cold temperatures and/or wet conditions (during application) amine blooming may occur; the discolouration does not affect the performance of the coating.

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## ENVIRONMENTAL CONDITIONS

Blasting or application should **NOT** be carried out when :-

Relative humidity is > 90%  
Air temperature < 5°C  
Substrate temperature < 3°C above dew point of surrounding air.

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## SAFETY PRECAUTIONS

It is the policy of CHEMCO INTERNATIONAL to ensure that its products are handled and applied by professionally approved and skilled applicators.

Application shall be carried out in accordance with instructions contained in this data sheet and referenced to CHEMCO INTERNATIONAL TECHNICAL SPECIFICATION MANUAL.

CHEMCO INTERNATIONAL management are intent on ensuring all work is carried out in accordance with company HEALTH & SAFETY procedures and all materials are handled with due care to COSHH regulations and instructions.

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## STORAGE

Store in cool, dry conditions (not less than 4°C or above 20°C).  
Keep away from direct heat source and sunlight.  
When not using the material, always replace the lid on the container.

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## SHELF LIFE

At least 24 months when stored in sealed containers at temperatures of not less than 4°C or above 20°C.  
At temperatures above, refer to manufacturer for advice.

DISCLAIMER: The information contained herein is, to the best of our knowledge, accurate and current and is given in good faith without warranty. Users are deemed to have satisfied themselves independently as to the suitability of our products for their particular purpose. In no event shall Chemco International be liable for consequent or incidental damages.

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