



**Product description:** P2520 is a two-component primer based on epoxy poly-amide resin. This coating has high resistance to weather and wear, and with a suitable final coating, it is also resistant to water, solvents, chemicals and petroleum derivatives. It should be noted that this coating alone is not suitable for immersion in acidic and alkaline solutions.

**Application:** This coating creates a cathodic protective film with high capability to protect metal structures, machines, external surfaces of tanks and pipes, oil refineries, various parts of ships such as decks, ship hulls and water intake platforms.

### Technical data:

Specification	Details	EN Standard	ASTM Standard
Color / Shade	White and colored	Visual / EN ISO 3668	D1535
Solids by Volume %	58 ± 3	EN ISO 3251	D2697
Solids by Weight %	90 ± 2	EN ISO 3251	D2369
Density / Specific Gravity	2.4 - 2.8 kg/lit	EN ISO 2811	D1475
Zinc(%) in dry film according:	to SSPC standard		
Shelf life	9 months		
Dry Film Thickness (DFT) μm	50 - 60 μ	EN ISO 2808	D7091
Wet Film Thickness (WFT) μm	85 - 100 μ	EN ISO 2808	D4414
Spreading Rate (Theoretical Coverage) m2/L	9.6 - 11.5 m2/lit	EN ISO 6504	D2697
Hardening mechanism	Solvent evaporation and two-component chemical reactions	Technical Description	Technical Description
Flash Point	28° C	EN ISO 1523	D93

Temperature C° °F	Surface drying time (Clock)	Full Cure	Recoating time (hours)	Pot life (Clock)
59 ( 15)	90 min	minimum 7	24	16
77 ( 25)	30 min	5-7	7-15	8
104 ( 40)	10 min	5-7	12	4

### Equipment Used:

#### AIRLESS SPRAY

Nozzle diameter: 0.017-0.021 inches

Output pressure: minimum 141 times

#### AIR SPRAY

Nozzle diameter: 1.8-2.2 mm - Nozzle pressure: 3-5 times

Brush: 20-30 μm (for staining) - Roller: 20-30 μm (for staining)

### PRIMER PAINTS- ZINC RICH EPOXY PRIMER (P-2520)

**Environmental Conditions:** The temperature of the surface should be at least 3 degrees higher than the dew point. In hot weather, the temperature of the materials before mixing should be 20-25C<sup>0</sup>, Otherwise the pot life will be very short. To ensure the hardening of the coating, the temperature of the air and the surface should be above 10. This cover should not be implemented in areas where the weather changes or the wind speed exceeds 7 m/s.

### Surface Preparation:

- The target surface should be well clean, dry and free of any pollution and prepared in accordance with ISO 8504: 1992. Places that need to remove welding waste, smooth joints and sharp edges. Oil or grease should be washed according to SSPC-SP1 standard.
- Surface sandblasting should be done at least Sa21/2 for submerged surfaces, and at least Sa21/2 or Sa2 for surfaces exposed to atmospheric conditions. If the time between sandblasting and the application of the coating is prolonged and surface rust occurs, the surface should be sandblasted again.
- It is recommended for systems with low profile thick-ness (40-50 μ) and for systems with high profile thick-ness (50-70 μ).

### Method of Applying:

- All equipment should be cleaned with recommended thinner before use.
- Part A should be mixed with a strong mixer.
- Add component B to component A and continue mixing for 5 minutes.  
**Note:** Due to the fact that the storage time of the mixture (Pot life) is limited, avoid mixing more than the required amount.  
**Note:** The best application time is 20-30 minutes after mixing the two components.
- For application with air spray, 5% thinner is recommended from 10-10% and for airless spray, 5% thinner is recommended.
- Each painting pulse must be applied in parallel so that each pulse covers 50% of the painted surface with a right angle.
- To ensure the desired thickness, angles, sharp edges, rivets and uneven parts should be covered again.
- If the application of the cycle exceeds the minimum interval time of this coating, the hardness of the surface must be taken into account for the adhesion of the next layers. (If the adhesion decreases, a layer of epoxy sealer or mist coat is recommended as the next coating.)

### Safety Tips:

This coating is flammable and must be away from flame and heat, and the operator is obliged to read and comply with the MSDS of this product, use a special mask and safety gloves during use, and operate in environments with proper ventilation.

**Storage Conditions:** This product should be stored in a closed space away from direct rays at a temperature of 5-35 degrees.

**Considerations:** The drying time depends on the film thickness applied, all the data in this catalog are based on the thickness of the dry film in vitro conditions.



**LEGAL NOTES :** The information contained in this Technical Data Sheet is based on laboratory testing and practical experience. Actual performance may vary depending on substrate condition, application method, and environmental conditions. Users should test suitability before large-scale application.

**Head Office :** Building No.15 , Qasimlu Street 40, Shahidan Zargata Quarter 24, Zone 1, Sulaymaniyah 46001, Iraq

**Factory :** Tanjaro Industrial Area – Sulaymaniyah – Iraq