

Product Description: FEUPRIME 1000 is a two-component polyamide epoxy-based primer coating. It is specially designed to protect surface from rust in highly corrosive environment and conforms the requirement of NORSOK M-501. Suitable for properly prepared carbon steel, galvanized steel, stainless steel and a range of aged coating surfaces.

Intended Uses: It is formulated to protect structural steel, carbon steel, and galvanized steel from rust in commercial and industrial projects with better aesthetic appeal.

Technical Specification:

Descriptions	Values
Paint Type	Epoxy, Two Component
Finishing	Matt
Shades	Grey, Oxide Red
Category	C 5 as per ISO 12944 with complete painting system
Drying Time	Touch dry: 1 hours Hard dry: 3-5 hours Overcoat Interval: Minimum: 4 hours at 30 °C. Maximum: 8 hours at 30 °C.
Typical Thickness (DFT)	100-120 micron per coat
Theoretical Coverage	8 sqm/liter @ 80 micron
Pot life	4 hours @ 30 °C
Volume Solid	80 ± 2%
Mixing Ratio	4:1 by volume

VOC	380 g/l
Shelf Life	24 months when stored properly

Maintenance and Repair

Abrasive blasting to min. Sa 2½ (ISO 8501-1) / SP 10 (SSPC).

The surfaces to be coated shall be clean, undamaged and dry. The surfaces shall be free from mud, oil and grease.

In case of oil and grease on substrate, the suitable solvent can be used for cleaning.

Water cleaning process can be adopted to remove zinc salts & white rusts.

Application Conditions

FEUPRIME 1000 is recommended for application and use on dry protected substrate only.

FEUPRIME 1000 should only be applied when the air and substrate temperature are above 5 °C and below 55 °C. Relative humidity should be below 85% for successful application.

Steel surface temperature should be a minimum of 3 °C above the dew point. Ensure the substrate is dry and free from contact with rain or condensation during the application and drying of FEUPRIME 300.

Please note that rain may cause surface patterning if the material has not formed a skin. Heavy rain or water running over the surface can damage recently applied (6 - 8 hours) coating and hence it should be protected if this is a potential risk.

System Compatibility

Based on the actual exposure of the coating system, various subsequent coats can be used in combination with this product.

FEUPRIME 1000 is compatible with coatings systems such as Epoxy and Polyurethane coatings.

Care must be taken to provide recommended timings for the complete dry of previous coat for next

coat.

Application Method

Tools	Thinning Max Vol.	Application Parameters
Airless Spray	5 %	Nozzle Pressure: 200-250 bar Nozzle Size: 0.4-0.5 mm
Spray Gun	5 %	Nozzle Pressure: 200-250 bar Nozzle Size: 0.4-0.5 mm
Brush/Roller	-	-

Curing Time

Temperature	10 Deg Cel	25 Deg Cel	40 Deg Cel
Surface dry	2 h	1 h	30 min
Walk on dry	14 h	6.5 h	3 h
Dry to over coat	8 h	4 h	3 h
Cured for handle	14 h	7 h	3 h

All drying times have been measured at a wet film thickness of 50 µm under controlled temperature

and relative humidity below 80 %, wind speed 6 km/hr and pressure 1011 hpa.

Packing

Two Component	Part A	16 L
	Part B	4 L

Mixing Ratio

Part A (4): Part B (1)

Safety Precautions

This product is for professional use only. The applicators and operators shall be trained, experienced and have the capability and equipment to mix/stir and apply the coatings correctly and according to FEUKEM technical documentation.

Applicators and operators shall use appropriate personal protection equipment when using this product. This guideline is given based on the current knowledge of the product.

All work involving the application and use of this product should be performed in compliance with all relevant national, Health, Safety & Environmental standards and regulations.

For further details, please refer FEUPRIME 1000 MSDC.

Storage

Keep the containers in a dry, cool, well-ventilated space and away from sources of heat and ignition. Containers must be kept tightly closed. Handle with care.

When storing and transporting, the temperature must be between 3 °C and 40 °C. Outside of this, it is advisable to use climatic control. Protect from freezing at all times during storage and transport.

Shelf Life

24 months from date of manufacturing, subjected it is stored as per FEUKEM recommendations.

Color Variation

When applicable, products primarily meant for use as primer or antifouling may have slight color variations from batch to batch. Such products may fade and chalk when exposed to sunlight and weathering. Color and gloss retention on topcoats/finish coats may vary depending on type of color, exposure environment such as temperature, UV intensity etc., and application quality.

Disclaimer

All information is given in good faith on the result gained from experience and test. However, all recommendation or suggestions are made without guarantee since supplier does not have any control on site conditions and its uses. Color variation may be possible on surface.
