

## Marten Zinc Phosphate EP Primer 615

**Description** Good quality two pack steel primer based on epoxy – polyamide resins pigmented with Zinc phosphate and other inert pigments.

### Principal uses

- For interior and exterior use.
- Good flow and drying properties
- Good corrosion preventing properties
- Good adhesion to properly cleaned steel
- Easy to apply – quick drying
- Lead free

**Substrate** Specially designed for use as base coat metal primer on steel surfaces which could not be immediately top coated.

### Characteristics

**Color** : brown – yellow – Grey or any color  
**Finish** : Flat  
**Specific gravity** : Approx. 1.40 g /cm<sup>3</sup>  
**Volume solids (%)** : Approx. 45 - 47 %  
**Theoretical coverage** : Approx. 9 m<sup>2</sup> / lt.( on 50 µm DFT )  
Depend upon substrate condition and method of application .  
**Dry film thickness** : from 30 – 50 µm .  
**Drying time** : Approx. 2 hours  
**Overcoat interval** : Min. 8 hours  
**Shelf life** : 12 months from the date of production  
( stored in a dry and cool place )

### Surface preparation and condition

- Surfaces should be dry and free from all loose old paints, dirt, grease, and similar contamination, and prepare according to ISO-st2
- Weld seams , cut , burnt , or corroded areas. Remove weld spatters round off sharp edge , remove all contamination and prepare according to ISO – st3.
- Bare steel – partly corroded – remove all contamination by means of blast cleaning according to ISO-sa2½
- Bare steel with little corrosion – remove all contamination and prepares by power tool cleaning according to ISO-St3
- To be used as primer base coat . A repeated coat will provide better anticorrosive properties. Topcoat epoxy gloss or epoxy matt enamels can follow it.

### Application guideline

#### Instrument for use

#### (Brush and Roller)

Volume of thinner : approx.5-10 %  
Recommended thinner : Epoxy reducer (TN – 05)

#### ( Air spray )

volume of thinner : approx. 20 – 25 %  
Recommended thinner : Epoxy reducer (TN – 05 )  
Nozzle orifice : 1.8 mm  
Nozzle pressure : approx. 2-3 at 28-42 psi

#### ( Airless spray )

Volume of thinner : approx. 0 – 5 %  
Recommended thinner : Epoxy reducer (TN – 05 )  
Nozzle orifice : approx. 0.43 – 0.48 mm  
Nozzle pressure : approx. 120 – 150 at 1700 – 2100 psi

**Cleaning Solvent** : Epoxy reducer (TN – 05 )