



tradition • innovation • quality

a.b.e.® Construction Chemicals

**abe.®cote 384**

**EPOXY ZINC PHOSPHATE PRIMER**

**DESCRIPTION**

Two-component, solvent-borne polyamide cured epoxy with corrosion inhibitive pigments.

**USES**

As a primer coat on steel prior to application of epoxy or polyurethane coatings or single-pack anti-corrosive coatings.

**ADVANTAGES**

- Exhibits excellent corrosion protection of steel.
- Contains corrosion inhibitive pigments.
- Easily overcoated with decorative epoxy or polyurethane twin-packs.
- Good pot life allows for flexibility during application.

**SURFACE PREPARATION**

Steel should preferably be abrasive blast cleaned to a minimum standard of SA 2,5 of Swedish Code of Practice SIS 055900. The anchor pattern should be approximately 40 – 60 microns. If hand cleaning is used, nothing less than a SA 3 finish is acceptable. However, this method of cleaning will significantly reduce the life of the system.

All metal to be coated must be clean, mechanically sound and dry.

**PROPERTIES DURING APPLICATION**

Application by	Brush or airless spray
Pot life	8 hours/5 L
Induction period	Allow to stand for 30 minutes in shade after mixing
Volume solids (typical)	50%
Recommended average dft per coat	40 µm
Theoretical coverage for above dft	12 m <sup>2</sup> /L on smooth surface
Wet film thickness at above	80 µm
Practical coverage for estimating purposes	8 - 10 m <sup>2</sup> /L
Salt spray resistance	Good with no blistering, wrinkling or loss of adhesion and no corrosion of test panel (visible or under the film, i.e. creep)
Recommended no of coats	2 - 3 coats, depending on anchor pattern and use, e.g. constant submersion
Dry time @ 25 °C	Touch dry: 1 - 2 hours Hard dry: 12 hrs Full cure: 7 days
Overcoating time @ 25 °C	Min: 8 hrs Max: 48 hrs
Application temp. range	10 °C to 40 °C
Fire resistance of wet film	Flammable
Do not apply	If humidity is in excess of 85%
Do not apply	If surface is less than 2 °C above dew point
Colour	Red sheen

**PROPERTIES OF WET MATERIAL**

Mixing ratio	4 base: 1 activator by volume
Density (typical)	1.40 g/cm <sup>3</sup>
<b>Colour:</b>	
Base	Red
Activator	Clear
Mixed	Red
Finish	Sheen
Flash point	25 °C
Dilution	<b>abe.®cote thinners no 3</b> if required
Consistency	Low viscosity liquid
Toxicity	Uncured material is toxic
Shelf life	2 years from date of manufacture
Storage conditions	Store under cover in cool conditions
Packaging	5 L kits

**BONDING/PRIMING**

The product is a primer.

**MIXING**

Stir contents of each container, particularly the base, very well. Add the activator to base and stir together for at least five minutes using a flat paddle. Mechanical mixing gives better dispersion than manual mixing. A suitable mixing method would be a slow speed electric drill (approximately 200 r/min) fitted with a paddle.

If only part of a kit is to be used, add one volume of activator to 4 volumes of base. Measuring must be accurate and separate stirrers used for proportioning each component. The mixed material must be left to stand in a cool place for 20 minutes prior to application.

**COVERAGE**

8 - 10m<sup>2</sup>/L.

**APPLICATION**

By brush or airless spray. In the latter case, a tip of approximately 250 µm size may be used. **abe.®cote 384** should not be applied if the ambient temperature is below 10 °C. The curing reaction will not occur at low temperature. If surfaces are not at least 2 °C above dew point, there is every chance that a film of condensed moisture may be present. This will interfere with the adhesion of the coating. Wet film thickness as per recommendation should not be exceeded as this can result in solvent entrapment, as can too early overcoating. Solvent entrapment in the film can lead to disastrous performance. Stir frequently during use.

**CLEANING**

Tools can be cleaned with **abe® super brush cleaner** before material has cured.

**PROTECTION ON COMPLETION**

Against traffic and spillage until cured.

**TEMPERATURE AND RELATIVE HUMIDITY**

See "Application" and "Properties During Application".

**MODEL SPECIFICATION**

Two component epoxy zinc phosphate primer for metal surfaces. The coating shall be **abe.®cote 384**, a two component epoxy zinc phosphate primer applied to prepared metal surfaces in accordance with the manufacturers recommendations, **a.b.e.® Construction Chemicals**.

**PACKAGING**

**abe.®cote 384** is supplied in 5 L kits.

**HANDLING & STORAGE**

This product has a shelf life of 12 months if kept in a dry cool place under cover in the original packaging. In more extreme conditions this period might be shortened.

**HEALTH & SAFETY**

Wet **abe.®cote 384** is toxic and flammable. Always ventilate the working area well during application and drying. Avoid flames in vicinity. Always wear gloves and eye protection when working with the material and avoid excessive inhalation and skin contact. If material is splashed in the eye, wash with copious quantities of clean water and seek medical attention.

**IMPORTANT NOTE**

This data sheet is issued as a guide to the use of the product(s) concerned.

Whilst **a.b.e.® Construction Chemicals** endeavors to ensure that any advice, recommendation, specification or information is accurate and correct, the company cannot – because **a.b.e.®** has no direct or continuous control over where and how **a.b.e.®** products are applied – accept any liability either directly or indirectly arising from the use of **a.b.e.®** products, whether or not in accordance with any advice, specification, recommendation, or information given by the company.

**FURTHER INFORMATION**

Where other products are to be used in conjunction with this material, the relevant technical data sheets should be consulted to determine total requirements. **a.b.e.® Construction Chemicals** has a wealth of technical and practical experience built up over years in the company's pursuit of excellence in building and construction technology.

