

Epoxy

PRODUCT DESCRIPTION A high performance, two component, chemically-cured, water borne epoxy rust inhibitive primer.

INTENDED USES For interior or exterior steel, aluminum and certain galvanized metal surfaces. Also used over concrete, masonry, glazed brick or ceramic tile

PRACTICAL INFORMATION FOR TRU-GLAZE-WB 4030

Colour	Light Grey
Gloss Level	Matt
Volume Solids	47%± 2%
Typical Thickness	50-100 microns (2-4 mils) dry equivalent to 106-213 microns (4.2-8.5 mils) wet
Theoretical Coverage	6.30 m ² /litre at 75 microns d.f.t and stated volume solids 251 sq.ft/US gallon at 3 mils d.f.t and stated volume solids
Practical Coverage	Allow appropriate loss factors
Method of Application	Airless Spray, Roller, Brush

Drying Time

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			<i>Minimum</i>	<i>Maximum</i>
25°C (77°F)	*1	24 hours	16 hours	7 days

¹ Not applicable

REGULATORY DATA

Flash Point (Typical)	Part A 93°C (199°F); Part B 93°C (199°F); Mixed 93°C (199°F)		
Product Weight	1.37 kg/l (11.4 lb/gal)		
VOC	193 g/l	Calculated	

See Product Characteristics section for further details

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SURFACE PREPARATION

All surfaces must be sound, dry, clean, free of oil, grease, dirt, mildew, curing compounds, loose and flaking paint and other foreign substances.

New Surfaces:

Steel

Best results are obtained over a surface abrasive blasted to commercial blast cleanliness (SSPC-SP6) or ISO 8501-1:2007 Sa2. Performance over hand or power tool cleaned surfaces is dependent on the degree of cleaning. Self prime with Tru-Glaze-WB 4030. If rust staining occurs, apply a second coat of Tru-Glaze-WB 4030.

Aluminium:

Remove oils and dirt by solvent cleaning or with Devprep 88 or other suitable cleaner followed by a thorough water rinsing and then prime with this product.

Galvanised Steel:

Degrease to SSPC-SP1 and remove any white zinc corrosion products by hand abrasion cleaning. Self prime with Tru-Glaze-WB 4030. Galvanised substrates must be test patched for adhesion prior to use, due to the high variability of surface treatments.

Previously Painted Surfaces:

The water borne components of this product generally allow use over most old coatings. Old coatings should be tested for lifting. If they lift, remove them. Wash to remove contaminants. Rinse thoroughly with water and allow to dry. Dull glossy areas by light sanding. Remove sanding dust. Remove loose paint. Prime bare areas with primer specified under New Surfaces.

APPLICATION

Mixing	Material is supplied in two containers as a unit. Always mix a complete unit in the proportions supplied. Once the unit has been mixed it must be used within the working pot life specified.	
	(1) Agitate Base (Part A) with a power agitator. (2) Combine entire contents of Curing Agent (Part B) with Base (Part A) and mix thoroughly with power agitator.	
	Allow the mixed material to stand 30 minutes before use.	
Mix Ratio	4 part(s) : 1 part(s) by volume	
Working Pot Life	25°C (77°F) 8 hours	
Airless Spray	Recommended	Use a 0.48mm (19 thou) tip size and adjust pressure as needed.
Brush	Suitable - small areas only	
Roller	Suitable	See Product Characteristics section for further details
Thinner	Clean Water	
Cleaner	Warm soapy water	
Work Stoppages	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with clean water. Once units of paint have been mixed they should not be resealed and it is advised that after prolonged stoppages work recommences with freshly mixed units.	
Clean Up	Clean all equipment immediately after use with warm soapy water. It is good working practice to periodically flush out spray equipment during the course of the working day. Frequency of cleaning will depend upon amount sprayed, temperature and elapsed time, including any delays. All surplus material and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.	

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PRODUCT CHARACTERISTICS

Advantages:

- Excellent adhesion
- Excellent corrosion resistance
- Light gray colour permits good finish coat hiding
- Excellent recoatability with all types of finishes
- Low odour and a high flash point
- Low VOC.

In most cases one coat is sufficient, although two coats may be required on steel to obtain proper dry film thickness depending on the application method. Care should be taken that proper and uniform film thicknesses are obtained. Brushing and rolling may require multiple coats to achieve correct film thickness and/or hiding. Use clean short nap synthetic roller (new rollers must be free of loose fibres).

Apply in good weather, when air and surface temperatures are above 10°C (50°F).

Note: VOC values are typical and are provided for guidance purpose only. These may be subject to variation depending on factors such as differences in colour and normal manufacturing tolerances.

SYSTEMS COMPATIBILITY

The following topcoats are recommended for Tru-Glaze-WB 4030:

Devthane 359	Devthane 359H
Devthane 379	Devthane 379H
Devthane 389	Tru-Glaze 4508
Tru-Glaze-WB 4406	Tru-Glaze-WB 4408
Tru-Glaze-WB 4418	Tru-Glaze-WB 4426
Tru-Glaze-WB 4428	

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ADDITIONAL INFORMATION

Further information regarding industry standards, terms and abbreviations used in this data sheet can be found in the following documents available at www.international-pc.com:

- Definitions & Abbreviations
- Surface Preparation
- Paint Application
- Theoretical & Practical Coverage

Individual copies of these information sections are available upon request.

SAFETY PRECAUTIONS

This product is intended for use only by professional applicators in industrial situations in accordance with the advice given on this sheet, the Material Safety Data Sheet and the container(s), and should not be used without reference to the Material Safety Data Sheet (MSDS) which International Protective Coatings has provided to its customers.

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.

In the event welding or flame cutting is performed on metal coated with this product, dust and fumes will be emitted which will require the use of appropriate personal protective equipment and adequate local exhaust ventilation.

If in doubt regarding the suitability of use of this product, consult International Protective Coatings for further advice.

PACK SIZE	Unit Size	Part A		Part B	
		Vol	Pack	Vol	Pack
	1 US gal	0.8 US gal	1 US gal	0.2 US gal	1 US quart
	5 US gal	4 US gal	5 US gal	1 US gal	1 US gal
For availability of other pack sizes, contact International Protective Coatings.					
SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A		Part B	
	1 US gal	9.5 lb		2.4 lb	
	5 US gal	44.7 lb		11.2 lb	
STORAGE	Shelf Life	24 months minimum at 25°C (77°F). Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.			

Important Note

The information in this data sheet is not intended to be exhaustive; any person using the product for any purpose other than that specifically recommended in this data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at their own risk. All advice given or statements made about the product (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing to do so, we do not accept any liability at all for the performance of the product or for (subject to the maximum extent permitted by law) any loss or damage arising out of the use of the product. We hereby disclaim any warranties or representations, express or implied, by operation of law or otherwise, including, without limitation, any implied warranty of merchantability or fitness for a particular purpose. All products supplied and technical advice given are subject to our Conditions of Sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is liable to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to check with their local representative that this data sheet is current prior to using the product.

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