



RUST INHIBITIVE EPOXY PRIMER

346D7744 Dark Gray Base
346X2169A Activator

PRODUCT DESCRIPTION

346 Series, **Rust Inhibitive Epoxy Primer** contains rust inhibitive pigments, which combat the onslaught of corrosion. Coupled with the inherent tight film associated with two-component epoxies, this primer offers excellent protection to properly prepared steel.

Rust Inhibitive Epoxy Primer may be used, not only as a prime coat, but as an intermediate coat as well, when specifications call for a two or three-coat system.

Rust Inhibitive Epoxy Primer is formulated to be lead and chromate free. It meets the performance requirements of SSPC Paint No. 22, MIL-DTL-2444 (formerly MIL-P-24441), MPI #101 and MPI #108.

PERFORMANCE PROPERTIES

System Tested:

Substrate: Steel
Surface Preparation: SSPC-SP6
1 ct. Rust Inhibitive Epoxy 346 @ 3.0 mils dft

Adhesion:

Method: ASTM D4541
Result: Passes 750 lbs/sq in

Pencil Hardness:

Method: ASTM D3363
Result: 7-day cure: 2H

Flexibility:

Method: ASTM D522
Result: Passes 180° bend 5/8" Mandrel

Dry Heat Resistance:

Method: ASTM D2485
Result: Passes 250°F

Salt Spray Resistance:

Method: ASTM B117
Result: Passes 1000 hours – no rust, no blistering

Abrasion Resistance:

Method: ASTM D4060 1 kg load
Result: 1000 cycles, 75 mg loss

TECHNICAL INFORMATION

Generic Types: Polyamide Epoxy – Two Components

Gloss: < 10 units @ 60°

Use: Protective / Decorative

Color: Dark Gray

Recommended Film Thickness: 2.0 – 4.0 mils dry
5.1 – 10.2 mils wet

Spread Rate: 313 - 156 sq. ft/gal @ the recommended dft

Dry Time: @ 77°F (25°C) & 50% Relative Humidity

To Touch: 90 minutes
To Handle: 120 minutes
To Re-coat: wet-on-wet after 30 minutes or
2 – 72 hours
including polyurethanes

Drying times are dependent upon film thickness, temperature and humidity.

Storage Temperature: 20°F (-7°C) Minimum
110°F (43°C) Maximum

Flash Point: 40°F (7°C)

Viscosity: 35" – 45" # 4 Ford (activated) @ 77°F (25°C)

VOC: 4.13 (496 g/l) ± 1% (activated)

#HAPS / Gal Solids: 4.446 (activated)

Solids by Volume: 39.04 ± 2% (activated)

Solids by Weight: 55.64 ± 2% (activated)

Weight per Gallon: 10.65 lbs. ± 2% (Base)
7.70 lbs. ± 2% (Activator)

Mix Ratio: 4 parts base to 1 part activator

Pot Life: Three hours @ 77°F (25°C)

Shelf Life: 24 months unopened from date of manufacture, each component.

Recommended Primer: Product is self-priming, but can be used over Enviro-Zinc Epoxy Primer for maximum protection.

Rust Inhibitive Epoxy 346 can be used as a primer, intermediate coat, and/or topcoat in a three-coat system.

Clean Up: 560X1301 (Universal Flush Solvent)

APPLICATION INFORMATION

SURFACE PREPARATION:

Surface of substrate should be dry, clean, and in sound, paint-worthy condition. The surface must be free of dirt, grease, oil, salts, loose rust, loose mill scale, and any other foreign materials or contaminants. For non-severe exposure, SSPC-SP3, Power Tool Cleaning may be all that is required. SSPC-SP6, Commercial Blast Cleaning is required for more demanding conditions or severe chemical exposure.

Steel and Iron:

The minimum surface preparation for steel and iron is SSPC-SP2/SP3, Hand Tool or Power Tool Cleaning. Prior to this procedure, the surface should be solvent cleaned per SSPC-SP1. For more severe exposures, begin with SSPC-SP1, followed by SSPC-SP6, Commercial Blast Cleaning. Bare metal should be primed as soon after surface preparation as possible, or before flash rusting occurs.

APPLICATION CONDITIONS:

Surface Temperature:

50°F (10°C) Minimum 110°F (43°C) Maximum

Paint Temperature:

50°F (10°C) Minimum 90°F (32°C) Maximum

Surface should be dry and a minimum of 5°F (3°C) above the dew point.

Relative Humidity:

Dry times may be adversely affected as the relative humidity increases. Caution should be taken when painting in very humid conditions.

MIXING & THINNING INSTRUCTIONS:

Before use, mix paint thoroughly by boxing and stirring. Mechanical agitation is preferred. Be sure all settlement, if any, is well incorporated. Mix four-parts Base Component to one-part Activator Component by volume.

Note: The addition of thinner reduces viscosity, which, in turn, affects spread rate and application characteristics. If thinner is used, make sure it is well incorporated into the paint prior to application.

This product is available in 5-gallon kits. Each kit consists of four gallons 346 base component and one gallon 346 activator component.

Prices may be obtained from your Sumter Coatings Sales Representative, or by calling Sumter Coatings Customer Service at 1-888-471-3400.

APPLICATION EQUIPMENT:

The following are general recommendations. Pressure and tip size may be varied due to temperature changes and for proper spray characteristics.

Thinning: Thin up to 10% by volume with 560X0015 (Epoxy Thinner, Medium)

See Mixing and Thinning Instructions for further information.

Airless Spray:

Pump Ratio: 30:1
Hose: 1/4" or 3/8"
Tip Size: .013 – .019
Pressure: 1200 – 1400 psi
Filter: 60 Mesh

Conventional Spray:

Gun: Graco AirPro or equal
Fluid Nozzle: 1.4 mm
Air Cap: 289773
Atomization Pressure: 40 – 50 psi
Fluid Pressure: 15 – 20 psi

Brush, roll or spray.

HINTS FOR BETTER PERFORMANCE:

A clean substrate is necessary for optimal performance, as direct contact of coating and steel surface is required for rust inhibition and good adhesion.

All welds, sharp edges, angles, and other areas prone to early rusting due to insufficient coverage should be stripe-coated prior to full application in order to help prevent premature failure in these areas.

Over-thinning of the coating material can result in an insufficient film-build, poor adhesion and overall poor appearance.

During the spray application, use a 50% overlap with each pass of the gun. This will help ensure complete and thorough coverage, avoiding low build areas, which may corrode prematurely due to insufficient primer.

January 2020