



Product description: P352 is a two-component primer based on epoxy poly-amide resin, and the outstanding features of this coating are its excellent adhesion to the surface, anti-corrosion properties, excellent resistance to water, chemicals and salt solutions.

Application: This coating (in an epoxy system) can be used to protect metal structures, machines, external surfaces of tanks and pipes, and oil refineries.

Technical data:

Specification	Details	EN Standard	ASTM Standard
Color / Shade	White and colored	Visual / EN ISO 3668	D1535
Solids by Volume %	66 ± 3	EN ISO 3251	D2697
Solids by Weight %	80 ± 2	EN ISO 3251	D2369
Density / Specific Gravity	1.3 - 1.6 kg/lit	EN ISO 2811	D1475
Bitumen percentage	28%		
Shelf life	12 months		
Dry Film Thickness (DFT) μm	50 - 60 μm	EN ISO 2808	D7091
Wet Film Thickness (WFT) μm	80 - 100 μm	EN ISO 2808	D4414
Spreading Rate (Theoretical Coverage) m ² /L	9.5 - 12 m ² /lit	EN ISO 6504	D2697
Flash Point	26° C	EN ISO 1523	D93

Temperature C° °F	Surface drying time (Clock)	Full Cure	Recoating time (hours)	Pot life (Clock)
59 (15)	4-6	minimum9	24 - 36	10
77 (25)	2-3	7	16 - 24	6
104 (40)	1 - 3	5	14 -16	4

Equipment Used:

AIRLESS SPRAY

Nozzle diameter: 0.017-0.021 inches

Output pressure: minimum 141 times

AIR SPRAY

Nozzle diameter: 1.8 -2.2 mm - Nozzle pressure: 3-5 times

Brush: 20-30 μm (for staining) - Roller: 20-30 μm (for staining)

Safety Tips:

This coating is flammable and must be away from flame and heat, and the operator is obliged to read and comply with the MSDS of this product, use a special mask and safety gloves during use, and operate in environments with proper ventilation.

LEGAL NOTES : The information contained in this Technical Data Sheet is based on laboratory testing and practical experience. Actual performance may vary depending on substrate condition, application method, and environmental conditions. Users should test suitability before large-scale application.

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PRIMER PAINTS- EPOXY PRIMER (P-352)

Environmental Conditions:

The temperature of the surface should be at least 3 degrees higher than the dew point. In hot weather, the temperature of the materials before mixing should be 20-25C⁰, Otherwise the pot life will be very short. To ensure the hardening of the coating, the temperature of the air and the surface should be above 10. This cover should not be implemented in areas where the weather changes or the wind speed exceeds 7 mis.

Surface Preparation:

- The target surface should be well clean, dry and free of any pollution and prepared in accordance with ISO 8504: 1992. Places that need to remove welding waste, smooth joints and sharp edges. Oil or grease should be washed according to SSPC-SP1 standard.
- Surface sandblasting should be done at least Sa21/2 for submerged surfaces, and at least Sa21/2 or Sa2 for surfaces exposed to atmospheric conditions. If the time between sandblasting and the application of the coating is prolonged and surface rust occurs, the surface should be sandblasted again.
- It is recommended for low profile thickness systems (40-50 μ) and for high profile thickness systems (50-70 μ).

Method of Applying:

- All equipment should be cleaned with recommended thinner before use.
- Part A should be mixed with a strong mixer.
- Add component B to component A and continue mixing for 5 minutes.

Note: Due to the fact that the storage time of the mixture (Pot life) is limited, avoid mixing more than the required amount.

Note: The best application time is 20-30 minutes after mixing the two components.

- For application with air spray, 5% thinner is recommended from 10-10% and for airless spray, 5% thinner is recommended.
- Each painting pulse must be applied in parallel so that each pulse covers 50% of the painted surface with a right angle.
- To ensure the desired thickness, angles, sharp edges, rivets and uneven parts should be covered again.
- If the application of coltar epoxy exceeds the minimum recoating time, the hardness of the surface should be taken into consideration for the adhesion of the next layers.

Note: Before applying the cycle, if the surface has been exposed to a polluted environment, it should be cleaned with high pressure of wind or water and the surface should be completely dry.

Storage Conditions: This product should be stored in a closed space away from direct rays at a temperature of 5-35 degrees.

Considerations: The drying time depends on the film thickness applied, all the data in this catalog are based on the thickness of the dry film in vitro conditions.

