



PRODUCT DATA

305

Zinc Rich Epoxy Polyamide Primer

Description: 305 is a user friendly zinc-rich epoxy primer formulated for use as a primer under acrylic, epoxy, and urethane finish coats.

Typical Uses: Zinc-rich epoxy primer to applied over abrasive blast cleaned surfaces or as a field maintenance primer. May be used to repair itself or inorganic zinc primers. Zinc pigment provides cathodic protection and film undercutting resistance to corrosion. Performance similar to hot-dipped galvanizing.

Dry Temperature Limits: 225 deg.F

Surface Cleanliness: NACE No.3/SSPC-SP 6 Commercial Metal Blast

Profile Depth: average 1.5 to 2.0 mils (visual comparator), maximum 2.3 mils (Testex replica tape)

Profile Texture: sharp and angular (viewed under magnification)

Mixing: Mix only complete units. Power mix the activator and base separately, then combine. After mixing activator and base gradually sift in the zinc dust portion under constant agitation. Never dump the zinc dust portion into the activator as it will lump up and be unusable. Do not thin until all components have been mixed together thoroughly. Strain through 30 to 60 mesh screen into agitator-equipped container and immediately turn agitator on at slow speed. Maintain constant agitation during use.

Application Equipment: Airless or conventional spray using agitated containers. Conventional Spray: Binks Model 18 Gun with 67 Fluid Nozzle, 67PB Air Nozzle, and 67 Needle. Airless Spray: Minimum 30:1 ratio pump with teflon packings, a 60 mesh filter and .017" to .019"(432-483 microns) orifice tip on gun. Supply lines should not exceed 50 feet. For longer supply lines use 1/2" I.D. airless lines

Application Conditions:

- Noncontaminated profile (pretreat and blast contaminated surfaces)
- Dry, dust-free metal surface
- Metal temperature above 60 deg.F
- Metal temperature at least 5 deg. above the dew point
- Ambient temperature above 50 deg.F
- Humidity less than 90%
- Material temperature between 70 and 90 deg.F

Primer: n/a

Thinner: T-35 Thinner up to 1/2 pint per gallon

Safe Application Conditions: Consult MSDS for proper handling, cleanup, disposal, and use of personal protective equipment. Circulate sufficient air to maintain working environment below the PEL and LEL. Apply according to local, state, and federal (OSHA) regulations.

Finish: matte

Color: reddish gray

Volume Solids: 54% +/- 2%, (mixed)

VOC: 3.2 lbs./gal. (374 g/l), (mixed)

Mixing Ratio: mix only complete units

Dry Film Thickness: 2.5 mils

Wet Film Thickness: 4-1/2 mils

Theoretical Coverage: 866 sq.ft./gal. @ 1 mil

Induction Time: none required

Pot Life Time: 7 hours @ 77 deg.F

Shelf Life Time: 1 year

Dry Time: @ 77 deg.F (25 deg.C)

Dry to Touch	15 min.s
Dry to Handle	1 to 2 hours
Dry to Recoat	2 to 8 hours, varies with temperature

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