

## TECHNICAL DATA SHEET

# PERMAGRIP PI 555

## EPOXY GALVANIZED / SS/ ALUMINIUM PRIMER

<b>DESCRIPTION:</b>	A two component epoxy, pigmented with zinc phosphate. It cures to flexible, well adhering coating with good abrasion and Impact resistance.		
<b>RECOMMENDED USE:</b>	As a primer / intermediate for galvanized steel surface, aluminum and stainless steel in severe atmospheric exposure conditions. As a primer or intermediate for high performance epoxy-polyurethane systems.		
<b>RESISTANCE TO:</b>	Moisture – Excellent	Aliphatic Solvents – Excellent	
	Abrasion – Excellent	Weather – Excellent	
	Petroleum Solvents – Excellent		

### PRODUCT INFORMATION:

Colour:	Off white
Finish:	Matt
Volume solids %:	57 ± 1% (ASTM-D2697-86)
V.O.C.:	384 g/l (NB. – Thinning will affect VOC compliance and volume solids)
Typical thickness:	50 - 150 microns dry film thickness
Theoretical coverage:	11.4 m <sup>2</sup> /ltr. @ 50 microns dft
Density:	1.45 ± 0.1 g/cc (mixed)
Flash point	Base : 30°C C/A : 25°C
Mixing ratio:	3 : 1 by volume
Shelf life:	24 months from the date of manufacture
Pot life:	2 hours @ 35°C
Pack size:	Comp. A – 15 liters + Comp. B – 5 liters = 20 liters

FILM THICKNESS AND SPREADING RATE:	MIN.	MAX.	UNIT
Dry film thickness	50	150	µm
Wet film thickness	88	263	µm
Spreading rate	11.4	3.8	m <sup>2</sup> /l (theoretical)

This figure makes no allowance for surface profile, uneven application, overspray or losses in containers and equipment. Film thickness will vary depending on actual use and specification.

**SERVICE TEMPERATURE:** 120°C maximum dry

**RECOMMENDED THINNER:** Thinner No.5 (5%)

### DRYING & CURING TIME:

SUBSTRATE TEMPRATURE	15°C	23°C	35°C
Touch dry	6 hours	4 hours	3 hours
Dried to over coat (minimum)	8 hours	4 hours	3 hours
Hard dry	24 hours	16 hours	12 hours
Fully cured	10 days	9 days	7 days

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### SURFACE PREPARATION:

Galvanized steels, stainless steels and light alloys should be thoroughly degreased and prepared for painting by removing all oil, grease and other loose materials using KPC's T30.

### RECOMMENDED COATING SYSTEM:

Intermediate: PERMAGRIP IT 880 / PERMAGRIP IT 401 / PERMAGRIP IT 653 / Permagrip PI 555  
Topcoat: PERMATHANE T 137

Note: The above mentioned is a generally used system for galvanized steel structures, and if any alternative systems are required, please contact the KPC's technical team.

**RECOMMENDED APPLICATION METHODS:** Airless spray, roller, brush

### APPLICATION EQUIPMENT DETAILS:

AIRLESS SPRAY: Nozzle Size: 0.38mm (18 thou)  
Fan Angle: 40°  
Operating Pressure: 115kg/cm<sup>2</sup> (2200 psi)

### APPLICATION CONDITIONS AND OVER COATINGS:

This material should preferably be applied at temperatures in excess of 10°C. In conditions of high relative humidity, i.e. 80-85%, good ventilation conditions are essential. Substrate temperature should be at least 3°C above the dew point and always above 0°C. At application temperatures below 10°C, drying and curing times will be significantly extended, and spraying characteristics may be impaired. Application at ambient air temperatures below 5°C is not recommended.

### HEALTH AND SAFETY:

Please observe the precautionary notices displayed on the container. Do not breathe or inhale mist. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water and medical attention sought immediately.

Consult Product Health and Material Safety Data Sheet for information on safe storage, handling and application of this product.

**Disclaimer:** The information in this document is given to the best of KPC Paint's knowledge that based on laboratory testing and practical experience Products are often used under conditions beyond KPC's control and KPC Paints cannot guarantee anything but the quality of the product itself.

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