

**BAJAPOX HS 13220**

CURING AGENT 63028

Description: BAJAPOX 13220 is a high solid, high build two-component polyamide-cured self-primer intermediate coat . It cures to a strong and rust-preventing coating.

Recommended use: As a primer or intermediate coat in protective coating systems. May be used as a general purpose epoxy primer according to painting specification. The product can be over coated with Bajapox or Bajathane or Bajatex coat.

PHYSICAL CONSTANTS:

Mixed product:	13220
Colours/Shade no:	Grey (7278)
Finish:	Semi-flat
Volume Solids, %:	77±2
Theoretical spreading rate:	7.5 m ² /litre - 100 micron
Flash point:	28°C/ 82°F
Specific gravity:	1.36 kg/litre
Dry to touch:	4 hours at 20°C/68°F
Fully cured:	7 days at 20°C/68°F

APPLICATION DETAILS:

Mixing ratio for 13220:	BASE 13220 : Curing agent 63028 3 : 1 by volume		
Application method:	Airless spray	Air spray	Brush
Thinner (max.vol.):	08020 (5%)	08020 (15%)	08020 (5%)
Pot life:	8 hours (20°C/68°F) (airless spray)		
	8 hours (20°C/68°F) (brush)		
Nozzle orifice:	0.017-0.023"		
Nozzle pressure:	250 bar/3600 psi		
Cleaning of tools:	BAJAK'S TOOL CLEANER 99610		
Indicated dft:	100 micron/4 mils (See REMARKS overleaf)		
Indicated wft:	200 micron/8 mils		
Recoat interval	See REMARKS overleaf		

2. BAJAPOX PRIMER 13220

SURFACE PREPARATION:	<p>New steel: Abrasive blasting to Sa 2½. For temporary protection, if required, use a suitable shopprimer. All damage of shopprimer and contamination from storage and fabrication should be thoroughly cleaned prior to final painting. For repair and touch-up use BAJAPOX 13220.</p> <p>Other metals and light alloys: Thorough degreasing and removal of any salty contamination. Abrasive sweeping to create a suitable dense anchor profile.</p> <p>Repair and maintenance: Remove oil and grease, etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. Clean damaged areas thoroughly by power tool cleaning to St 3 (minor areas) or by abrasive blasting to min. Sa 2, preferably to Sa 2½.</p> <p>Improved surface preparation will improve the performance of BAJAPOX 13220. Feather edges to sound intact areas. Dust off residues. Touch up to full film thickness.</p> <p>On pit-corroded surfaces, excessive amounts of salt residues may call for high pressure water jetting, wet abrasive blasting, alternatively dry abrasive blasting, high pressure fresh water hosing, drying, and finally, dry abrasive blasting again.</p>
APPLICATION CONDITIONS:	<p>Use only where application and curing can proceed at temperatures above 10°C/50°F. The temperature of the paint itself should be 15°C/59°F or above to secure proper application properties. In confined spaces provide adequate ventilation during application and drying. Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation.</p>
SUBSEQUENT COAT:	<p>BAJAPOX or BAJATHANE or according to specification.</p>
REMARKS:	
Weathering/service temperatures:	<p>The natural tendency of epoxy coatings to chalk in outdoor exposure and to become more service sensitive to mechanical damage and chemical exposure at elevated temperatures is also reflected in this product.</p>
Film thickness:	<p>May be specified in another film thickness than indicated depending on purpose and area of use. This will alter spreading rate and will influence the amount of thinning necessary, drying time and recoating interval. Normal range dry is 25-75 micron/1-3 mils.</p>
Recoating:	<p>Recoating intervals:</p> <p>Minimum (primarily only relevant for container coatings): 20 minutes' flash-off time for 40 micron/1.6 mils BAJAPOX 13220 when top coated with designed container coatings, epoxy, polyurethane, acrylic or CR types. The minimum recoating interval only applies in the case of forced ventilation, proper application and if the completed paint system is thoroughly dry before exposed to aggressive environments.</p> <p>Maximum: Recoating interval for non-immersion services is 24 hours for acrylic or CRs, 3 days for PUs and none for epoxies.</p> <p>In the case of long recoating intervals, a completely clean surface is mandatory to ensure intercoat adhesion. Any dirt, oil and grease to be removed with eg suitable detergent followed by high pressure fresh water cleaning. Salts to be removed by fresh water hosing. Any degraded surface layer, as a result of a long exposure period, must be removed as well. Water jetting may be relevant to remove any degraded surface layer and may also replace the above-mentioned cleaning methods when properly executed. Consult BAJAK for specific advice if in doubt.</p> <p>To check whether the quality of the surface cleaning is adequate, a test patch may be relevant.</p>
Note:	<p>BAJAPOX 13220 is for professional use only.</p>
Safety:	<p>Handle with care. Before and during use, observe all safety labels on packaging and paint containers, consult BAJAK Material Safety Data Sheets and follow all local or national safety regulations. This goes for personal protection such as, but not limited to, protection of lungs, eyes and of the skin, medical treatment in case of swallowing the paint or in case of other direct contact with the paint. Take necessary precautions against possible risks of fire or explosions as well as protection of the environment. Apply only in well ventilated areas and ensure that adequate forced ventilation exists when applying paint in confined spaces or when the air is stagnant.</p>