BAJAPOX PRIMER 15300

CURING AGENT 95040

Description: BAJAPOX PRIMER 15300 is a two-component polyamide-cured epoxy primer containing zinc phosphate as corrosion inhibiting pigment. It cures to a strong and rust-preventing coating.

Recommended use: As a primer or intermediate coat in container systems. May be used as a general purpose epoxy primer according to painting specification.

Service temperatures:

	Dry :	In water (no temperature gradient):
Maximum:	140°C/284°F	35°C/95°F

PHYSICAL CONSTANTS:

Mixed product:	15300
Colours/Shade no:	Red-Grey
Finish:	Flat
Volume Solids, %:	51±1
Theoretical spreading rate:	12.75 m²/litre - 40 micron 521 sq.ft./US gallon - 1.6 mils
Flash point:	26°C/79°F
Specific gravity:	1.3 kg/litre - 10.8 lbs/US gallon
Dry to touch:	2-3 hours at 20ºC/68ºF
Fully cured:	7 days at 20ºC/68ºF
V.O.C.:	455 g/litre - 3.8 lbs/US gallon
Shelf life:	1 year (25°C) from time of production. Depending on storage conditions, mechanical stirring may be necessary before usage.

APPLICATION DETAILS:

Mixing ratio for 15300:	BASE 15300 : Curing agent 95040 4 : 1 by volume		
Application method:	Airless spray	Air spray	Brush
Thinner (max.vol.):	08450 (5%)	08450 (15%)	08450 (5%)
Pot life:	8 hours (20°C/68°F) (airless spray) 8 hours (20°C/68°F) (brush)		
Nozzle orifice:	0.021”		
Nozzle pressure:	175 bar/2500 psi (Airless spray data are indicative and subject to adjustment)		
Cleaning of tools:	BAJAK’S TOOL CLEANER 99610		
Indicated dft:	40 micron/1.6 mils (See REMARKS overleaf)		
Indicated wft:	75 micron/3 mils		
Recoat interval	See REMARKS overleaf		

2. BAJAPOX PRIMER 15300

SURFACE PREPARATION:	**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 PRIMER. **Other metals and light alloys:** Thorough degreasing and removal of any salty contamination. Abrasive sweeping to create a suitable dense anchor profile. **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. Improved surface preparation will improve the performance of BAJAPOX PRIMER 15300. Feather edges to sound intact areas. Dust off residues. Touch up to full film thickness. On pit-corroded surfaces, excessive amounts of salt residues may call for high pressure water jetting, wet abrasive lasting, alternatively dry abrasive blasting, high pressure fresh water hosing, drying, and finally, dry abrasive blasting again.
APPLICATION CONDITIONS:	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.
SUBSEQUENT COAT:	BAJATEX HI-BUILD 14637 or according to specification.
REMARKS:	
Weathering/service temperatures:	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.
Film thickness:	*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.*
Recoating:	**Recoating intervals:** Minimum (primarily only relevant for container coatings): 20 minutes' flash-off time for 40 micron/1.6 mils mils BAJAPOX PRIMER 15300 when topcoated 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. Maximum: Recoating interval for non-immersion services is 24 hours for acrylic or CRs, 3 days for PUs and 1 months at 20°C for epoxies. 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. To check whether the quality of the surface cleaning is adequate, a test patch may be relevant.
Note:	**BAJAPOX PRIMER 15300 is for professional use only.**
Safety:	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.