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## PRODUCT DATA SHEET

## SP-5818 EPOXY ZINC-RICH PRIMER

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- DESCRIPTION:** SP-5818 is an Organic Zinc-Rich galvanic functioning two-component epoxy-polyamide cured primer with high zinc content for steel surfaces.
- ADVANTAGES:**
- Exceptional build on edges and rough areas.
  - As a corrosion resistant primer for use with a wide range of paint systems.
  - Provides cathodic protection.
  - Excellent salt spray resistance.
- USES:**
- Excellent corrosion protection for steel structures, bridges, tanks, piping, valves, and other steel surfaces exposed to coastal and/or moderate to severe industrial environments.
- APPLICATION:**
- Airless Spray: Graco 30:1 Pump or equivalent - Tip Size: 0.019-0.023". Hose should be 3/8" I.D. minimum but a 1/4" whip end section is recommended for easier application. Maximum hose length of 50 feet. Material should be kept agitated during application.  
Thinning: 5-10% by volume with SP-140 Epoxy Thinner. \*
  - Air Spray: Devilbiss gun, 765 air cap and 15 E fluid tip and needle or equivalent. Fluid hose should be 3/8" I.D. with maximum length of 50 feet recommended. Pot should be kept at the same elevation as the spray gun. Material should be agitated during application. Moisture trap should be used between air supply and pressure pot.  
Thinning: 10-15% by volume with SP-140 Epoxy Thinner. \*
  - Brush or Roller: Primarily used for touch-up and repairs and/or small areas where spraying is not possible. Low nap rollers.  
Thinning: 5% by volume with SP-140 Epoxy Thinner. \*
- \* Guide Only: Amount of thinning affected by temperature conditions.
- CLEANING MATERIALS:**
- SP-100 Equipment Wash
  - SP-110 Tool Cleaner
  - SP-120 Internal Storage Lubricant



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**RECOMMENDED DRY FILM THICKNESS:** 2-3 mils

**SURFACE PREPARATION:**  
(Steel Substrate)

- Cleanliness: The surface to be treated shall be dry and free of grease, oil, dust, abrasive material or any other contaminants. Remove grease and oil with a suitable detergent. Remove salts and other contaminants by high-pressure fresh water cleaning.
- Standards/Profile: Abrasive Blast to minimum SSPC SP-10 (Near White) with blast profile of 1.5 to 2.5 mils.

**RE-COAT INTERVAL:**

- 25°C (77°F) - Minimum: 4 Hours  
- Maximum: 4 Days
- Sweep blasting of the surface is required to ensure inter-coat adhesion if the maximum re-coat interval is exceeded. Small areas  $\leq 316$  sq. cm. ( $\leq 49$  sq. in.) may be sanded using a medium grit (80-100) carborundum cloth.
- All dust from the sanding or blast roughening must be removed from the surface prior to the re-coat application.
- Zinc-rich primers can form zinc salts on the surface. They should not be exposed to the weather for an extended period before top coating. If this should occur, then sweep blasting will be required.

**MIXING RATIO:**

- By Volume: 5 Parts Base to 1 Part Hardener.
- By Weight: 100 Parts Base to 7.55 Parts Hardener.

**HANDLING PROPERTIES:**

Pot Life (200 grams mass @ 25°C / 77°F).....	>8 Hours
Dry Time [ASTM D-1640 @ 25°C (77°)]	
Touch Dry Time .....	2 Hours
Hard Dry Time .....	6 Hours
Minimum Application Temperature.....	10°C (50°F)
Minimum Coating Temperature.....	15°C (59°F)



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**HANDLING PROPERTIES (cont.):**

- Ideal Temperature Range for Surface and Coating ..... 15-25°C (59-77°F)
- Substrate Temperature.... The substrate temperature must be a minimum of 3°C (5°F) above the dew point temperature to avoid condensation before proceeding with application of the primer.
- Relative Humidity .....
  - Maximum: 80%
  - Preferable: 40-60%
- Storage / Shelf Life ..... Store in a cool, dry, well-ventilated area at temperatures between 5°C (41°F) and 40°C (104°F). Keep the lids sealed. The Shelf Life is a maximum of 24 months in unopened containers.

**LIQUID PROPERTIES:**

- Appearance..... Grey-Green colour
- Volume Solids (%) ..... 54
- VOCs..... 424 g/litre

**SAFETY:** Read the Material Safety Data Sheets before use.

**EFFECTIVE DATE:** September 23, 2005