

SAXON PRO 220

DESCRIPTION

It is a Surface Tolerant Primer, two-component, high solids polyamine adduct cured epoxy coating.

PRINCIPAL QUALITIES

- Can be applied directly to metal
 - Very good surface wetting
- Excellent anti-corrosive properties
 - Superb salt water resistance

COLOUR AND GLOSS LEVEL

- Standard Colours Available
 - Gloss

BASIC INFORMATION AT 20°C (68°F)

Information for mixed product	
Number of components	Two
Mass density	1.6 kg/l (13.4 lb/US gal)
Volume solids	74%
VOC (Supplied)	Directive 1999/13/EC, SED: max. 158.0 g/kgmax. 221.0 g/l (approx. 1.8 lb/US gal)
Recommended dry film thickness	150 - 250 µm (6.0 - 10.0 mils) depending on requirements
Theoretical spreading rate	5.5 m ² /l for 150 µm (219 ft ² /US gal for 6.0 mils)
Touch dry	1.5 hrs
Overcoating Interval	1.5 to 6 hours depending on ambient temperature
Shelf life	Base: at least 24 months when stored cool and dry Hardener: at least 24 months when stored cool and dry

RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES

Immersion exposure

- Steel; blast cleaned to ISO-Sa2½, blasting profile 40 - 70 µm (1.6 - 2.8 mils)
- Steel with approved zinc silicate shop primer; pretreated according to SPSS-Ss

Atmospheric exposure conditions

- Steel; pretreated preferably to ISO-Sa2½, , blasting profile 40 - 70 µm (1.6 - 2.8 mils) or according to ISO-St3
 - Shop primed steel; pretreated to SPSS-Pt3

Substrate conditions

- Previous coat (specific epoxy) must be dry and free from any contamination and within overcoating time

Substrate temperature

- Substrate temperature during application and curing should be above 5°C (41°F)
- Substrate temperature during application and curing should be at least 3°C (5°F) above dew point

INSTRUCTIONS FOR USE

Mixing ratio by volume: base to hardener 75:25 (3:1)

- The temperature of the mixed base and hardener should be above 10°C (50°F), otherwise extra thinner may be required to obtain application viscosity
 - Adding too much thinner results in reduced sag resistance and slower cure
 - Thinner should be added after mixing the components

Pot life

2 hours at 20°C (68°F)

Note: See ADDITIONAL DATA - Pot life

Airless spray

Volume of thinner

0 - 5%, depending on required thickness and application conditions

Nozzle orifice

Approx. 0.48 - 0.53 mm (0.019 - 0.021 in)

Nozzle pressure

15.0 MPa (approx. 150 bar; 2176 p.s.i.)

ADDITIONAL DATA

Spreading rate and film thickness	
DFT	Theoretical spreading rate
150 µm (6.0 mils)	5.5 m ² /l (219 ft ² /US gal)
250 µm (10.0 mils)	3.3 m ² /l (132 ft ² /US gal)

Curing time for DFT up to 150 µm (6.0 mils)	
Substrate temperature	Service– water immersion
5°C (41°F)	10 days
10°C (50°F)	7 days
15°C (59°F)	5 days
20°C (68°F)	3 days
30°C (86°F)	60 hours
40°C (104°F)	36 hours

Pot life (at application viscosity)	
Mixed product temperature	Pot life
15°C (59°F)	3 hours
20°C (68°F)	2 hours
30°C (86°F)	1 hour
40°C (104°F)	30 minutes

GENERAL INFORMATION

Apply all products in accordance with **BS 6150: 2006** Code of Practice for Painting of Buildings and **BS 8000: Part 12: 1989** Code of Practice for Decorative Wall Coatings and Painting.

All precautions are taken to ensure that the information provided in this technical data sheet is accurate. However, the manufacturer cannot guarantee the final results, as it has no control over the conditions in which its products are applied.

For assistance or more information, contact Saxon Paints or visit our website www.saxonpaints.com. Before using this product, ensure you have the most up-to-date information. The information is accurate as of the issue date: February 2022.

WARRANTY

SAXON PAINTS warrant its title to the product, that the quality of the product conforms to Saxon Paints' specifications for such product in effect at the time of manufacture and that the product shall be delivered free of the rightful claim of any third person for infringement of any patent covering the product. This product is for professional use only. The applicators and operators shall be trained, experienced and have the capability and equipment to mix/stir and apply the coatings correctly and according to Saxon Paints' technical documentation. Applicators and operators shall use appropriate personal protection equipment when using this product. This guideline is given based on the current knowledge of the product. These are the only warranties that Saxon Paints makes and all other express or implied warranties, under statute or arising otherwise in law, from a course of dealing or usage of trade, including without limitation, any other warranty of fitness for a particular purpose or use, are disclaimed by Saxon Paints. Any claim under this warranty must be made by Buyer to Saxon Paints in writing within five (5) days of Buyer's discovery of the claimed defect, but in no event later than the expiration of the applicable shelf life of the product, or one year from the date of the delivery of the product to the Buyer, whichever is earlier. Buyer's failure to notify Saxon Paints of such non-conformance as required herein shall bar Buyer from recovery under this warranty. Any suggested deviation to suit the site conditions shall be forwarded to the responsible Saxon Paints' representative for approval before commencing the work.

LIMITATIONS OF LIABILITY

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