

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 PRODUCT PRESENTATION

Colour range	See Saxon Colour Chart (other colours available on request)
Size	10 litre drum - 20 litre drum (larger sizes available on request)

MAIN PROPERTIES

PREPARED MIX PRODUCT	
Application	Roller, brush, or spray gun/machine
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 m²/l for 150 µm (219 ft²/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
Pot life	2 hours at 20°C (68°F)

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

New surfaces

Apply to a clean dry surface. Ensure any rust or damp is removed prior to application. All surfaces must be sound, suitably dry, and free from anything that will interfere with the adhesion of the materials to be applied. Surfaces with suction (porous surfaces) should be treated with an application of previous coating recommended by the manufacturer based on surface conditions.

Previously painted surfaces

All surfaces must be sound, suitably dry, and free from any contamination that will interfere with the adhesion of the materials to be applied. Remove all loose, failing, or unsuitable material by scraping or brushing with a stiff bristle brush (do not use wire brush) to a sound edge. Dirt, fungus, rust, or any other contaminant growth must be removed, and the areas treated before applying the coating. For surfaces in poor condition mechanical means may be necessary like pressure washing with a minimum 1500 psi, a proprietary paint removal system, wet or dry grit blasting. Care must be taken not to damage the underlying surface.

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

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.)

PREPARATION

COATING SYSTEM APPLICATION

Stir well before and during use.

ROLLER



Apply using a roller, using it directly from the drum ensuring the entire sleeve is covered. Work in a methodical, systematic manner maintaining a manageable wet edge blending the material to achieve the desired pattern whilst still wet. Maintaining a continuous wet edge (approximately 1 m²)

BRUSH



Before use, flick the bristles back and forth to remove dust. Make sure you remove excess liquid before painting. Fill the brush by dipping in up to half the length of the bristles. Tap it gently against the side of the can: don't wipe the brush hard against the lip. The bristles should flex only slightly as you brush – don't over press – let the paint flow from the brush.

Start at the top and work down, painting with light even strokes, working back into the wet edge. If you are painting a large area by brush, apply paint to an area about 50cm x 50cm, then brush the paint in horizontal strokes to even the paint out and finish off with light vertical strokes all in one direction. If you are using a brush and roller, paint the edges of the area first.

SPRAY



For best results in terms of finish, coverage, speed of application and low overspray the following set up is recommended.

Use conventional spray equipment i.e., GC 200/24 2HP compressor or larger that can continuously deliver a minimum of 80psi at 4-5 cubic feet per minute on a 3 meters (maximum) length airline to the spray gun. A GC 330 hopper feed spray gun with a 3mm air cap and tip size of 3-4mm tip size. Apply at 40psi air flow/spraying pressure with an 18" (450mm) distance from gun tip to surface being coated (target). Cover areas not to be sprayed with masking tape and wet strength masking paper or film. Spray using a circular or 'cross hatch' method, i.e., horizontally, and vertically to achieve a full, uniform and even texture overall. Clean the tip and air cap frequently during use to prevent blocking.

CLEANING

Return excess material/paint to container. Wash with clean water immediately after use.

HEALTH AND SAFETY RECOMMENDATIONS

Please refer to the Safety, Health, and Environmental Information on the container. When preparing the surfaces avoid the inhalation of dust and/or metal particles. Wear a suitable facemask and recommended safety personal protection. Material Safety Data Sheets for this is freely available at Saxon Paints website.

STORAGE

Store in secure dry conditions. Keep out of reach of children. Containers should be kept closed during storage. Do not empty into drains, water rivers or access routes to septic drums.

For further information contact Saxon Paints

ADDITIONAL DATA

Spreading rate and film thickness

DFT	Theoretical spreading rate
150 µm (6.0 mils)	5.5 m²/l (219 ft²/US gal)
250 µm (10.0 mils)	3.3 m²/l (132 ft²/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: April 2024.

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

The information in this document is given to the best of Saxon Paints' knowledge. The information in this sheet is intended for guidance only and is based upon laboratory tests that Saxon Paints' believes to be reliable. Saxon Paints' products are considered as semi-finished goods and as such, products are often used under conditions beyond Saxon Paints' control like the quality or condition of the substrate, or the many factors affecting the use and application of the product. The product and related information are designed for users having the requisite knowledge and industrial skills in the industry and it is the end-user's responsibility to determine the suitability of the product for its own particular use and it shall be deemed that Buyer has done so, as its sole discretion and risk. Saxon Paints' does not accept any liability arising from any loss, injury or damage resulting from such use or the contents of this information. Variations in the application environment, changes in procedures of use, or extrapolation of data may cause unsatisfactory results. Minor product variations may be implemented in order to comply with local requirements. Users should always consult Saxon Paints' for specific guidance on the general suitability of this product for their needs and specific application practices. If there is any inconsistency between different language issues of this document, the English (United Kingdom) version will prevail.