

# Cladcote 220

## epoxy primer

Cladcote 220 is a polyamide cured inhibitive epoxy primer for general industrial and marine use. May be recoated with a wide range of topcoats to give durable paint systems for immersion and non-immersion services.

Excellent aged recoatability with epoxies.

### Typical uses

- Aluminium
- Chemical plants
- Galvanised steel
- General marine use
- Hydro-electric installations
- Oil rigs/refineries
- Pulp and paper mills
- Structural steel
- Tank farms
- Waste/water treatment plants

*Please ensure the current Data Sheet and Safety Data Sheet are consulted prior to specification or application of product. If in doubt contact .*

### Physical properties

<b>Vehicle type</b>	Two component epoxy
<b>Hardener</b>	Polyamide
<b>Pigmentation</b>	Zinc phosphate
<b>Solvent</b>	Aromatic/ketone
<b>Pot life</b>	8 hours at 21°C
<b>Mix ratio</b>	4:1 (by volume)
<b>Finish</b>	Low gloss
<b>Colour</b>	Red oxide, grey
<b>Dry time (minimum)</b>	Touch dry: 2-3 hours at 21°C Through dry: 4 hours at 21°C (minimum)
<b>Recoat time (minimum)</b>	4 hours at 21°C (by spray) Maximum varies with topcoat Overcoat with two pack products or acrylics
<b>Theoretical coverage</b>	10.4 sq. metres per litre (50 microns DFT) 6.9 sq. metres per litre (75 microns DFT)
<b>Volume solids</b>	52%
<b>Recommended DFT</b>	50-75 microns per coat
<b>Usual no. of coats</b>	1
<b>Abrasion resistance</b>	Very good
<b>Chemical resistance</b>	Excellent when suitably topcoated
<b>Heat resistance</b>	Up to 90°C (dry, continuous)
<b>Solvent resistance</b>	Excellent when suitably topcoated
<b>Durability</b>	Excellent when topcoated
<b>Thinning and clean up</b>	Thinner No.12
<b>Pack size</b>	4 and 20 litre composite

### Performance

### Performance and limitations

1. May be overcoated with a range of high performance topcoats to give a durable coating system.
2. General purpose inhibitive primer for immersion or non-immersion and severe chemical environments.
3. Suitable topcoats include epoxies, urethanes, vinyls, alkyds (see limitations) and acrylics.
4. Up to six month recoat time with high performance epoxies. Consult manufacturer for maximum recoat times when overcoating with topcoats other than epoxies, and recommendations for overcoating when maximum recoat times are exceeded.

### Limitations

1. Not designed to give long-term protection in exterior situations without topcoating.
2. Minimum temperature for satisfactory cure is 10°C. Extended cure times at a minimum temperature of 13°C is required for immersion service.
3. Drying and curing times are proportionally shorter at higher temperatures and longer at lower temperatures.
4. Drying times of alkyd finishes, such as Synthetic Enamel and Mica Bond will be extended when applied to Cladcote 221