

PRODUCT DESCRIPTION

Generic: Polyamide Epoxy

General Description: A high performance, chemically cured, rust inhibitive epoxy primer for interior or exterior steel, galvanized metal or aluminum surfaces. An excellent holding primer with excellent aged recoatability. Also may be used on concrete, masonry, glazed brick or ceramic tile to assure adhesion of a protective or decorative finish. The color permits easy coverage with topcoats.

Typical Uses: Provides excellent adhesion and corrosion resistance for metal substrates such as steel structural members, hollow metal doors & frames, cabinetry, machinery, equipment, piping and tanks in all industrial environments. May be used for both interior and exterior applications in chemical, fertilizer & power plants, petroleum refineries, pulp and paper mills, water and sewage treatment plants and mining operations. Also an excellent prime coat in the hard service areas of public and private institutional, educational, and commercial buildings, transportation equipment and difficult substrates such as galvanized metal, fiberglass, glazed brick, ceramic tile, brass, terne metal, or aluminum.

Special Qualifications: Performance alternate for MIL-DTL-23377D.

SPECIFICATION DATA

Color: Light Gray (205K2735)

Finish: Flat

Reduction Solvent: T-10 Thinner

Clean-up Solvent: T-10 Thinner

Weight/Gallon: 12.3 lbs./gal.(1.48 kg/L)

VOC (EPA 24): 3.18 lbs./gal.(381 g/L)

Thinned 5% with T-10 thinner 3.35 lbs./gal. (402g/L)

Solids By Volume (ASTM D 2697-7 days): 58% + 2%

Theoretical Coverage at 1.0 Mil (25 microns) Dry: 930 sq.ft./gal.(22.8 m²/L)

Recommended Film Thickness: 2.0-4.0 mils (50-100 microns) dry – 4.0 - 7.0 mils (100-175 microns) wet. (Make allowances for loss due to overspray & irregular surfaces.)

Systems: Please consult the appropriate system guide, the particular job specification or your ICI Paints Representative for proper systems using this product. Systems must be selected considering the particular environment involved.

Minimum Dry Time (ASTM D 1640): At 3 mils (75 microns) DFT

Substrate Temperature	50°F (10°C)	77°F (25°C)	95°F (35°C)
Minimum Recoat	36 Hours	18 Hours	9 Hours
Dry Hard	40-48 Hours	24 Hours	12 Hours
Maximum Recoat			
Self	30 Days	30 Days	30 Days
220, 224HS, 4508H	30 Days	30 Days	30 Days
359, 389, 349QC	14 Days	14 Days	14 Days
378, 379	5 Days	5 Days	5 Days
4308, 4328	30 Days	30 Days	30 Days
DEVFLEX	30 Days	30 Days	30 Days
TRU-GLAZE-WB			

Ventilation, film thickness, humidity, thinning, and other factors can influence the rate of dry

Warning: The above table provides general guidelines only. Always consult your ICI Paints Representative for appropriate recoat windows since the maximum aged recoat time of this product may be significantly shortened or lengthened by a variety of conditions, including, but not limited to humidity, surface temperature, and the use of additives or thinners. The use of accelerators or force curing may shorten the aged recoat of individual coatings. The above recoat windows may not apply if recoating with a product other than those listed above. If the maximum aged recoat window is exceeded, please consult your ICI Industrial Coatings Specialist for appropriate recommendations to enhance adhesion. Failure to observe these precautions may result in intercoat delamination.

Shelf Life: Over 24 months at 70°F (21°C) – unopened

Mix Ratio By Volume: 9 (base):1 (converter) – see mixing instructions.

Induction: 30 minutes at 77°F (25°C) – see mixing instructions.

Pot Life: 8 hours @ 77°F (25°C) & 50% R.H.

FEATURES

Advantages:

- Excellent adhesion to difficult substrates
- Excellent holding primer
- Excellent corrosion resistance
- Excellent aged recoatability with all types of finishes
- Resists splash and spillage or fumes of a wide range of chemicals
- Easily applied by brush, roller, or spray
- Formulated without lead, chromate, or mercury containing materials
- Versatile – for use on most substrates under many different types of topcoats
- Excellent maintenance touch-up primer for hand-cleaned substrates
- Light gray color permits good finish coat hiding

PERFORMANCE DATA

Adhesion: (ASTM D 4541) – Excellent

Abrasion Resistance: (ASTM D 4060) – Good

Impact Resistance: (ASTM D 2794) – Excellent

Humidity Resistance: (ASTM D 4585) – Excellent

Service Temperature Limits: 250°F (121°C) dry.

Hardness: (ASTM D 3363), 7 day cure @ 77°F (25°C) - B

DANGER! FLAMMABLE. HARMFUL OR FATAL IF SWALLOWED. Read label and Material Safety Data Sheet Prior to Use. See other cautions on last page. DSF3-0696

GENERAL SURFACE PREPARATION

Surfaces must be sound, dry, clean, free of oil, grease, dirt, mildew, form release agents, curing compounds, loose and flaking paint and other foreign substances.

New Surfaces: Steel – Best results are obtained over a surface abrasive-blasted to a Near White Blast (SSPC-SP-10, ISO-Sa 2 1/2). Performance over hand or power-tool cleaned surfaces is dependent on the degree of cleaning. **Concrete and Masonry** – Cure at least 30 days before painting. pH must be 10.0 or lower. Roughen slick poured or pre-cast concrete by acid etching or sand sweeping. Follow acid manufacturer's application and safety instructions. Rinse thoroughly and allow to dry. Remove loose aggregate. Prime with PRE-PRIME™ 167 sealer or this product. **Galvanized Steel** – Solvent clean per SSPC-SP1 (recommended solvent is mineral spirits) or clean with DEVPREP® 88 or other suitable cleaner followed by a thorough water rinsing, then prime with this product. In aggressive environments allow the surface to weather for three (3) to six (6) months for best results. When weathering is not possible or the surface has been treated with chromates or silicates, first clean by the method intended to be used on the job and apply a test patch of the coating system specified. Allow product(s) to dry and cure at least one week before testing adhesion per ASTM D 3359. If adhesion is poor, brush blast, then prime with this product. **Aluminum** – Remove oils and dirt by solvent cleaning or with

DEVPREP 88 other suitable cleaner followed by a thorough water rinsing. Then prime with this product. **Terne Metal** – May be coated with an asphaltic varnish which must be removed prior to coating. Mineral spirits may normally be used to remove this varnish.

Previously Painted Surfaces: If the old paint is more than 25% failed by rusting, peeling, or flaking, it must be removed and treated as a new surface. If less than 25% has failed, clean the failed areas and spot-prime with this product. Old coatings should be tested for lifting. If they lift, remove them. Scuff sand glossy areas and aged epoxy coatings.

WARNING! If you scrape, sand, or remove old paint, you may release lead dust. LEAD IS TOXIC. EXPOSURE TO LEAD DUST CAN CAUSE SERIOUS ILLNESS, SUCH AS BRAIN DAMAGE, ESPECIALLY IN CHILDREN. PREGNANT WOMEN SHOULD ALSO AVOID EXPOSURE. Wear a NIOSH-approved respirator to control lead exposure. Clean up carefully with a HEPA vacuum and a wet mop. Before you start, find out how to protect yourself and your family by contacting the National Lead Information Hotline at 1-800-424-LEAD or log on to www.epa.gov/lead.

DIRECTIONS FOR USE

Tinting: May be tinted up to 2 oz./gal. with CHROMA-CHEM® 844 Colorants (Do not use water based or other colorants). Add colorants to only the base portion. Mix thoroughly before adding the converter.

Thinning: Thin only if necessary with up to 5% T-10 thinner.

Mixing: This product is supplied in two parts. Mix base component thoroughly. To 9 parts of base add 1 part of converter by volume. (Both components are provided in partially filled cans which, when mixed, provide a full one gallon or five gallon mix at the proper ratio.) Stir thoroughly and scrape sides of can to ensure thorough blending. Power mix at low speed continuously for 30 minutes. Mixed material is usable for eight hours: if it thickens, do not add thinner, but discard and mix fresh material. Avoid storing or placing containers in direct sunlight.

Application: Brush (natural bristle), roll (short nap) or spray. No thinning required. For airless spray, use a .015" tip. Adjust pressure as needed. Spray is preferred for appearance and build. Use clean short nap synthetic roller. New rollers should be thoroughly wet with T-10 thinner and spun vigorously to remove loose fibers. Brushing and rolling may require multiple coats to achieve correct film thickness and/or hiding.

Spreading Rate: Apply at 230-465 sq.ft. per gallon (5.6-11.4 m²/L) or 4.0-7.0 mils (100-175 microns) wet. Make allowances for overspray loss and irregular surfaces.

Topcoats: DEVTRAN® 205 primer can be overcoated with epoxy, urethane, polyester epoxy, alkyd, or latex coatings. The light gray color permits good coverage with the first finish coat applied.

Dry Time (ASTM D 1640): Minimum application temperature is 50°F (10°C). At 77°F (25°C) & 50% R.H., dries to touch in 60 minutes; to recoat with epoxy or urethane, in approximately 18 hours; to recoat with conventional alkyd or acrylic latex coatings in approximately 4 hours. Achieves full cure in 7 days at 77°F (25°C). Low temperature, high humidity or poor ventilation will increase these times.

Clean-up: Clean immediately with T-10 thinner.

PRECAUTIONS

DANGER! FLAMMABLE LIQUID AND VAPOR. CORROSIVE. CAUSES EYE AND SKIN BURNS. HARMFUL OR FATAL IF SWALLOWED. ASPIRATION HAZARD-CAN ENTER LUNGS AND CAUSE DAMAGE. HARMFUL IF INHALED. MAY CAUSE CENTRAL NERVOUS SYSTEM EFFECTS, INCLUDING DIZZINESS, HEADACHE OR NAUSEA. CAUSES RESPIRATORY TRACT IRRITATION. MAY CAUSE ALLERGIC SKIN AND RESPIRATORY REACTION. MAY BE HARMFUL IF ABSORBED THROUGH SKIN. OVEREXPOSURE MAY CAUSE CARDIAC, BLOOD, LIVER, KIDNEY DAMAGE. CONTAINS MICA WHICH MAY CAUSE PNEUMOCONIOSIS. USE ONLY WITH ADEQUATE VENTILATION. KEEP OUT OF THE REACH OF CHILDREN. NOTICE: Products in this series contain solvents. Reports have associated repeated and prolonged occupational overexposure to solvents with permanent brain and nervous system damage. Intentional misuse by deliberately concentrating and inhaling the contents may be harmful or fatal. For emergency information call (800) 545-2643. **Note: These warnings encompass the product series. Prior to use, read and follow product-specific MSDS and label information.** Keep away from heat, sparks and flame. **Do not** smoke. Vapors may ignite. Extinguish all flames, burners, stoves, heaters and pilot lights and disconnect all electrical motors and appliances before use and until all vapors are gone. Prevent build-up of vapors by opening all windows and doors to achieve cross-ventilation. If sanding is done, wear a dust mask to avoid breathing of sanding dust. Do not breathe vapors or spray mist. Ensure fresh air entry during application and drying. Avoid contact with eyes and skin. If you experience eye watering, headaches, or dizziness, leave the area. If properly used, a respirator may offer additional protection. Obtain professional advice before using. Close container after each use. **FIRST AID:** In case of skin contact, wash thoroughly with soap and water. If any product remains, gently rub petroleum jelly, vegetable or mineral/baby oil onto skin, then wash again with soap and water. Repeated applications may be needed. Remove contaminated clothing. For eye contact, flush immediately with large amounts of water, for at least 15 minutes. **Obtain emergency medical treatment.** If swallowed, **obtain medical treatment immediately.** If inhalation causes physical discomfort, remove to fresh air. If discomfort persists or any breathing difficulty occurs, get medical help. **KEEP FROM FREEZING.**

DS267-1003

SHIPPING

Flash point: 85°F (29°C)
Packaging: 1 gallon kit (3.785L) 5 gallon kit (18.925L)
 0.90 gallon base 4.50 gallon base
 0.10 gallon converter 0.50 gallon converter

Shipping Weight: 4 - 1 gallon kits - 55.2 lbs. (25.1 kg)
 5 gallon kit - 67.5 lbs. (30.7 kg)

205 (05/07)
 Ad Stock #68697F

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Strongsville, Ohio U.S.A.
 800-654-2616
www.devvoecoatings.com

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