

## Technical Data Sheet

# Indopoxy 740ZR

### Epoxy High Build Zinc Rich Primer

## Product Description

740ZR is a two component polyamide cured high build zinc rich epoxy primer. It provides very good corrosion protection as part of anti-corrosion coating system. It provides a tough coating with long term protection. It has excellent barrier action for steel structures especially exposed to high corrosive environments.

## Recommended Use

740ZR is recommended as undercoat on Steel Structures, Equipments, Pipe Lines, Vessels, Machinaries, Storage Tanks etc in Infrastructure projects, Refineries, Power Plants, transmission lines etc. Highly recommended as a primer for coating systems where extended durability is required.

## Physical Data

Colour	: Grey
Finish	: Matt
Soild by Volume	: 55 ± 3%
Supply Weight (Kg/ Ltr)	: 1.80±0.05
Flash Point	: 27° C
Dry Heat Resistance	: Intermittent : 130°C, Continuous: 110°C
Shelf Life	: 12 months

## Film Thickness

### Recommended film thickness per coat

Dry Film Thickness	: 50-90μ in single coat
Wet Film Thickness	: 90-160μ in single coat
Therotical Coverage Rate	: 11 sq.mt / lit at recommended DFT of 50μ

## Surface Preparation

All surfaces to be coated should be clean, absolutely dry and oil or moisture free before painting application. Oil and grease should be removed by solvent cleaning.

**New steel:** Abrasive blasting to Sa 2½ (ISO 8501-1:2007). For temporary protection, if required, use a suitable shopprimer. All damage of shopprimer and contamination from storage and fabrication should be thoroughly cleaned prior to final painting.

**Shop Primed:** Indopoxy 740ZR is suitable for application to steelwork freshly coated with zinc silicate shop primers. If the zinc silicate shop primer shows extensive or widely scattered breakdown, or excessive zinc corrosion, overall sweep blasting is a must.

## Application Data

Application Method	: Airless Spray/ Spray/ Brush/ Roller
Mixing Ratio	: 4 Part (Base) : 1 Part (Hardener)
Pot Life	: Four Hours at 30°C
Thinner and Cleaner	: Indopoxy Epoxy Thinner (IK.1501)
Airless Nozzle Orifice	: 0.43 - 0.53mm
Nozzle Pressure	: 176 kg/cm <sup>2</sup> or 2500 psi

**Working Precautions:** Material should not be allowed to remain in pipeline, hoses, gun or spray equipment. Thoroughly flush all equipment with IK.1702 thinner. Once units of paint have been mixed they should not be resealed and it is advised that after prolonged stoppages, the work should recommence with freshly mixed units.

**Maintenance:** Clean all equipment immediately after use with IK.1702 thinner. It is good working practice to periodically flush out spray equipment during the course of the working day. All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.

## Drying Characteristics

Surface Dry	: 30 mins
Touch Dry (to Handle)	: 2 Hours
Hard Dry	: 24 Hours
Overcoating Interval	: Minimum 2 Hours

Drying and curing times are determined at 30°C under controlled temperatures and relative humidity below 85 %, and at average of the DFT range for the product.

## Compatibility

Previous Coating	: Inorganic Zinc Silicates Shop Primers
Subsequent Coating	: Epoxy, Epoxy MIO, Epoxy Mastics, Polyurethanes, Alkyds

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## Product Features

To ensure good anti-corrosive performance, minimum 50 microns of dry film thickness of Indopoxy 740ZR is needed. Indopoxy 740ZR is a high build coating and is compatible with the fine to coarse blast profiles.

Intermediate coat can be avoided in case of medium corrosive environment like C3 Low to Medium per ISO 12944 and can be directly overcoated by Polyurethane or Epoxy topcoats, keeping total system DFT requirement intact.

Surface temperature must always be a minimum 3°C above dew point and relative humidity be less than 85%. Indopoxy 740ZR can be used for the localized repair of damaged inorganic zinc silicate primer as well.

## Storage

This is solvent based coating and the containers should be kept in a dry, cool, well ventilated space and away from sources of heat and ignition. Containers must be kept tightly closed.

## Caution

This product is for professional use only. The paint applicators should be trained, experienced and have the capability and equipment to mix and apply the coatings correctly as instructed. Applicators should use appropriate protection equipment when using this product.

This is solvent based product and should be used under well ventilated conditions. Do not inhale spray mist. Skin contact should be avoided. In case of spillage on the skin, it should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water.

### Limitation of Liability

This information is given to the best of our knowledge. Because of the multitude of formulations, production, and application conditions, all the above-mentioned statements have to be adjusted to the circumstances of the processor. Our products are often used under conditions beyond INDOKOTE's control. INDOKOTE cannot guarantee anything but the quality of the product itself. No liabilities can be derived from this fact for individual cases. This issue replaces all previous versions – Printed in India.

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