

Product Data Sheet

Primax AC 92SG

Product Description	Primax AC 92SG is an epoxy-based zinc containing powder coating designed to be used as a primer coat on phosphated or blast-cleaned steel structures. Primax AC 92SG imparts excellent resistance to corrosion, excellent mechanical properties and inter-coat adhesion, very good degassing properties, very good edge coverage and very good flow. Suitable top coat products are Corro-Coat MX for interior applications and Corro-Coat PE or Corro-Coat PE-F for exterior applications.
Application Areas	Typical areas of application are steel building structures, agricultural machinery, steel fences, outdoor public area furniture among others.
Pre-treatment	The overall quality of the coating system is dependent on the type and quality of the pre-treatment and the top coat. The recommended type pre-treatment to reach Corrosion Class C4, according to ISO 12944, is blast cleaning with grit to Sa 2½ with profile of 40-60 micron surface roughness.
Curing Schedules (powder topcoat application)	<p>It is recommended to partially cure Primax AC 92SG before the application of a powder coating top coat. The following cure schedules are recommendations for partial cure:</p> <p>5 - 10 minutes at 160°C object temperature 2 - 5 minutes at 180°C object temperature</p> <p>The system is then cured following the primer or topcoat specifications; whichever is most stringent. Tests have shown that such cure schedules can give excellent results. The minimum curing requirements for Primax AC 92SG is:</p> <p>10 minutes at 180°C object temperature 6 minutes at 200°C object temperature</p>
Curing Schedules (liquid topcoat application)	<p>Primax AC 92SG requires to be fully cured prior to application of a liquid topcoat. The minimum curing requirements for Primax AC 92SG is:</p> <p>10 minutes at 180°C object temperature 6 minutes at 200°C object temperature</p> <p>For best adhesion to the topcoat, abrasion by a light sanding is recommended. For further information, please contact your local Jotun Powder Coatings representative.</p>
Inter-coat Adhesion	Inter-coat adhesion properties and complete system cure must always be verified. The application of a top coat must take place no later than 12 hours after the application of Primax AC 92SG. The shortest possible interval is recommended. To ensure inter-coat adhesion with a compatible liquid topcoat it is recommended that the surface treatment procedures from the liquid coating supplier are followed.
Colour Selection and Finish	Primax AC 92SG is only available in light grey colour and gloss level 75 ± 10 (angle 60° measured according to EN ISO 2813).
Powder Application	Primax AC 92SG is suitable for Corona or Tribo charging equipment.
Storage Conditions	Keep in a dry cool area. Maximum temperature 25°C. Maximum relative humidity 60%.



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Technical Properties

The technical data provided below are typical for Primax AC 925G applied to 0.8mm zinc phosphated steel panels (60-80 micron film thickness):

Description	Norm	Primax AC 925G
Colour		Light grey
Gloss	ISO 2813	75 ± 10 units at 60° angle
Specific Gravity		1.9 ± 0.1 kg/dm ³
Adhesion	ISO 2409 (2mm)	Cross-cut rating Gt0 (100% adhesion)
Impact resistance	ASTM D 2794 (5/8" ball)	> 60 inch-pounds without film cracking
Cupping test	EN ISO 1520	Passes 5mm without film cracking

Test Results

Test results for combinations of Primax AC 925G with Corro-Coat PE/PE-F (smooth glossy) as topcoat presented below.

Tested on 3.0mm grit blasted (Sa 2½) steel panels. Total film thickness 160 microns (80 microns primer + 80 microns topcoat).

Description	Norm	Primax AC 925G
Cross cut test	ISO 2409 (2mm)	Rating Gt0
Salt spray resistance	ISO 9227	After 720 hours: No blistering, rusting (Ri0), cracking or flaking. Maximum corrosion around the scratch 1.5mm.
Water condensation resistance	ISO 6270	After 480 hours: No blistering, rusting (Ri0), cracking or flaking.

Note: test results are provided only as performance indication and do not constitute specifications.

Third party tests performed by the Institute für Korrosionsschutz Dresden GmbH, concluded that a system of Primax AC 925G and Corro-Coat PE-F 2197 "qualified as 'high' for corrosivity categories C4 according to ISO 12944 part 6 (Laboratory performance test methods)."

Note: The information on this Product Data Sheet is given to the best of the manufacturer's knowledge, based on laboratory testing and practical experience. However, as the product is often used under conditions beyond the manufacturer's control, only the quality of the product itself can be guaranteed. Jotun Powder Coatings reserves the right without notice to alter or change the content of this Product Data Sheet.

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