

The Advanced Material

The Significant Differences...

PRODUCT DATA SHEET

Rev. 1/04.05

PLC 328 EP INHIBITIVE EPOXY PRIMER

DESCRIPTION

PLC 328 EP is a two-component pigmented polyamide cured inhibitive epoxy primer. **PLC 328 EP** is a general purpose epoxy primer for commercially blasted steel. A shop or field primer to be used in conjunction with other PLC protective and decorative topcoats. Cures to a hard, tough film with excellent sub-film corrosion resistance. Has excellent adhesion and better tolerance of field application variables.

RECOMMENDED USES

PLC 328 EP is recommended for protection of structural steel, equipment and tank exterior in chemical plants, paper mills, power stations and other industrial facilities.

LIMITATIONS

PLC 328 EP is not recommended for immersion service or exposure to highly corrosive chemicals without suitable topcoat. Direct exposure to ultra violet light will cause chalking to the paint film.

ADVANTAGES

- Excellent resistance against abrasion and impact.
- Adhesion - Excellent adhesion over wide range of substrates.
- Top-coat - Can be top-coated by most top-coats.
- Anti-corrosion - Contains effective corrosion inhibitor to ensure long term protection.
- Fast dry - Very short drying time.

PHYSICAL DATA

Finish	: Matt.
Volume Solids	: 50 ± 2 %
No. of Components	: Two
Recommended Thickness.	: 25 to 50 microns DFT per coat
Theoretical Coverage	: 20 m ² /litre @ 25 microns DFT
No. of coats recommended	: One
Drying Time	: Touch dry - 30 minutes Topcoat - 4 hours
Packing Size	: 5 litres & 20 litres
Temperature	: Continuous - 93°C
Resistance	: Non-continuous - 120°C

APPLICATION INSTRUCTIONS

SURFACE PREPARATION : Remove oil or grease from surface to be coated with clean rags soaked in PLC Cleaner #2 in accordance with SSPC-SP1.

STEEL : For maximum protection, dry abrasive blast to a near white metal finish in accordance with SSPC-SP10 with blast profile about 15 to 25 microns.

MIXING : Stir Component A resin till homogeneous and empty Component B Hardener into component A and continue to mix for five minutes.

THINNING : Thin not more than 10% by volume with PLC Thinner #7 for workability.

SPRAY : Do not apply when the surface temperature is less than 3°C above the dew point or the RH is above 90%. Hold gun 8 to 10 inches from the surface and at a right angle to the surface. Make a 50% overlap with each pass of the gun. Adjust the material valve and the hand speed to give a wet coat on the substrate.

ROLLER & BRUSH : **PLC 328 EP** can also be applied by roller or brush. Short hair roller is highly recommended to ensure even coating thickness.

DRYING : The drying time is dependant on the environment temperature and sufficient ventilation after application. To ensure proper drying, always apply to the recommended thickness.

CLEANING : Cleaning all application tools with Cleaner #2 immediately after use.



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