

# TECHNICAL DATA SHEET

## ALOCIT 28.14 EPOXY COATING-ZINC PRIMER DARK GREY

- Outstanding adhesion on oil contaminated and underwater surfaces
- Environmentally friendly - solvent-free and no heavy metals
- Long term stability
- Especially designed for application onto clean, profiled steel
- Excellent corrosion protection, including A.L.W.C.
- For use in temperate and tropical climates

### USAGE

Two-pack epoxy primer containing zinc. Solvent-free with outstanding adhesion qualities on both wet and dry surfaces providing excellent corrosion control. Should be used as a primer to clean, profiled steel surfaces in conjunction with Alocit 28.15 or other compatible finishing coat.

- Excellent performance in marine environments
- Indispensable in industry where moist, wet or slightly oily conditions exist
- Solvent free

### TECHNICAL DETAILS

Product Description	Two component epoxy zinc based solvent free primer
Volume Solids	100%
Mixing Ratio (by weight)	5 parts resin - 1 part hardener
Specific Gravity	Base only 2.2, Mixed 1.82
Dilution	Do not dilute
Brush/Tool Cleaner	Immediately after use. Acetone.
Theoretical Coverage Rate*	@ 200 $\mu$ /8 mil (Maximum WFT) - 2.70m <sup>2</sup> /mixed KG @ 150 $\mu$ /6 mil (Optimum WFT) - 3.60m <sup>2</sup> /mixed KG @ 100 $\mu$ /4 mil (Minimum WFT) - 5.46m <sup>2</sup> /mixed KG 1 US gallon @ 25 $\mu$ /1 mil = 1600 ft <sup>2</sup>
Number of Coats	One coat
Working Life **	@ 20°C/68°F 45- 60 minutes
Working Life **	@ 27°C/ 81°F 30/45 minutes
Drying Times	@ 20°C/68°F Touch dry 6-8 hours
Drying Times	@ 27°C/81°F Touch dry 3-4 hours
Min Practical Cure Temp.***	+5°C/41°C
Resistant to	Water, sea water, oils, petroleum, many solvents, alkalis and a certain range of acids.
Flash Point	Above +200°C/+392°F
Shelf Life	Unmixed approximately 1 year
Storage	Moderate room temperature 15/30°C
Colour	Dark Grey
Pack Size	UK/Europe 1.2kg (1.0 kg resin/0.2 kg hardener) 3 kg (2.5 kilo resin/0.5 kilo hardener)
	US 1 Quart, 1 Gallon, 5 Gallon (Pack includes both components)

- Notes
- \* Underwater application can result in reduced coverage rates.
  - \*\* Working life is dependent on unit size, ambient/product temperature, mixing method and time, application speed relative to reduction in vol. of mixed product.
  - \*\*\* Curing will take place at lower temperatures but over an extended period.

## SURFACE PREPARATION

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### A) NEW STEEL

All millscale to be removed by abrasive blasting, check for rogue peaks and laminations, take remedial action. Remove dust and other contaminations. A blast profile of between 50 and 100 $\mu$  (2-4 mil) is the aim, based on Swedish Pictorial Standards / ISO-8501-1/SSPC/NACE. We recommend SA2 (SP6, NACE 3) as a minimum, and SA 2.5 (SP10, NACE 2) as the optimum. A secondary choice for surface preparation is mechanical abrading to remove surface contamination before coating application.

### B) WEATHERED/EXPOSED/CORRODED STEEL

Our basic aim is to remove surface contamination such as corrosion deposits, marine growths, chemical compounds etc., to revealing a clean steel substrate with a surface profile of a minimum 25 microns/1 mil (50 microns/2 mil underwater), various options are:-

- 1) Abrasive blasting, dry, in areas of low chemical contamination followed by optional high pressure water blast (15-20,000psi).
- 2) UHP hydroblasting (30/40,000psi) to remove all previous coatings etc and reveal original profile. Especially suitable for wet environments such as ships tanks, piers, jetties etc. Clean to an agreed standard and check soluble salts level.
- 3) UHP and High Pressure water blasting may sometimes be employed with added abrasive.
- 4) Mechanical cleaning (power) i.e. needle gunning, rotary wire brushing etc to remove all contamination/dust etc.

#### Notes:

- 1) Stains of rust, paint or mill scale remaining on the surface do not present a problem providing minimum surface profile criteria are met.
- 2) Alocit product range can be applied to both dry, wet and underwater surfaces, however whilst clean steel in saltwater is acceptable, steel heavily contaminated with salt and/or other chemicals above water is not acceptable. This will require decontamination, with chemical levels measured before & after.

## PRODUCT APPLICATION - Methods

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**Atmospheric:** Brush & Roller  
Airless spray - minimum 63:1, Tip size 19-21 thou.

**Underwater:** Alocit brushes - use vigorous circular motion.  
Alocit K1 underwater pump with round brush - use vigorous circular motion.

#### Notes:

- 1) Please contact our technical dept for specific details or if in any doubt.
- 2) All equipment should be cleaned immediately after use with acetone.
- 3) Airless spray is not suitable for wet/damp surfaces

## PRODUCT APPLICATION - COATING SYSTEMS

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**Steel:** **Atmospheric and Underwater**  
Minimum - 1 coat Alocit 28.14 primer. 1 coat Alocit 28.15.  
Optimum - 1 coat Alocit 28.14 primer 2 coats Alocit 28.15

#### Notes:

- 1) Use Alocit 28.15 of a different colour in a multi-coat system.
- 2) Alocit 28.14 zinc primer is specially designed for application onto clean, rust-free profiled steel.

## PRECAUTIONS

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Mix thoroughly by hand or with a mechanical mixer - avoid aeration of mixed product. Make sure that material is mixed well around the walls and bottom of the can before mixing with hardener.

Always use up the entire can - product cannot be re-used after working life expires.

Always empty the entire amount of hardener into the base to maintain the proper mixing ratio.

Containers are pre-measured and the epoxy containers are oversized to allow adding and mixing of the hardener.

## IMPORTANT:

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On moist, wet, submerged, or oily surfaces, Alocit 28.14 Primer must be firmly brushed into the surface using circular motions. 1st coat of Alocit 28.15 must be applied as soon as the Alocit 28.14 is touch dry - not later

ALL INFORMATION IS GIVEN IN GOOD FAITH BUT WITHOUT WARRANTY

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