

255 Epoxy Ester Primer

Updated: January 2015

Specification Data

Generic Type: Epoxy Ester

Description: APCO 255 Epoxy Ester Primer fast drying single part epoxy ester primer. Provides tight barrier protection to properly prepared steel surfaces. Provides increased chemical resistance compared to conventional alkyds. 255 is specifically formulated for use on electrical transformers, but may also be used anywhere increased chemical resistance is desired.

Features:

- Fast drying
- Increased chemical resistance

Solids Content: 48% by Volume

Theoretical Coverage:

- 769 mil ft²
- 256 ft² @ 3 Mils

Allow for loss during mixing & application.

VOC Value:

- 3.71 lbs/gal per EPA Method 24

Color: 1044 Gray, 2018 Red Oxide

Substrate & Surface Preparation

Must be clean and dry. Any dirt, dust, oil, contaminants, loose rust or loose mil scale must be removed.

Immersion Carbon Steel: Not Recommended

Non-Immersion Carbon Steel: Minimum SSPC-SP3 Power tool Cleaning. For optimum performance SSPC- SP6 Commercial Blast, surface profile 1.5-3.0 Mil.

Galvanized Steel: Not recommended

Previously painted surfaces: Surface must be sufficiently roughened, either by abrasive blasting or mechanical abrasion. Surface must attain a minimum 3B rating in accordance with ASTM D3359 "X-Scribe" test. Apply a test patch to check compatibility, prior to primary application.

Topcoats: APCO 231, APCO 220

Application Equipment

Spray Application:

- **Conventional:** Pressure pot with dual regulators, 3/8" I.D. material hose, Binks 2001 Gun w/66 series nozzles and 565 needle.
- **Airless:** Graco 36:1 Min. 1/4" material line. Tip size .011-.013 Output PSI- 3000

Brush & Roller: Touch up only

- **Brush:** Natural Bristle
- **Roller:** 1/4" Nap cover with Phenolic Core

Mixing & Thinning

Components: One

Mixing: Mix to uniform consistency and color. Frequent stirring is required to keep aluminum pigments suspended.

Thinning: Normally not required

- **Spray:** Up to 12 oz/gal with S100 if necessary

Application

Pre-application: Flush all equipment with thinner S100 or xylene

Temperature: Application range from 50°F-110°F surface temperature. Do not apply below 50°F.

Method: Apply one coat maintaining a wet edge to achieve a WFT of 4-6 Mils. Maximum performance will be achieved with two coats totaling 4-6 mils DFT.

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Application Continued

Inspection: Visually inspect film to ensure adequate coverage.

Clean up & disposal: After use immediately flush all equipment with thinner S100 or xylene. Dispose of all containers, solvents and unused materials in accordance with all local, state and federal regulations.

Curing schedule:

Times based upon 75°F

Dry to touch: 30 minutes

Dry to recoat: before 2 hours

Dry through: 24 hours

A critical re-coat time may occur between 2 and 48 hours at room temperature. This may fluctuate depending on temperature and film thickness. Test small inconspicuous area first.

Dry times are greatly affected by weather conditions and film thickness.

Packaging & Handling:

Unit sizes: Drums

Shipping Weight: 12.25 lbs/gal Unit

UN Classification: UN1263, PAINT, CLASS 3, PGIII