

# Resene Armourcote 220 epoxy primer

Resene Armourcote 220 is a polyamide cured inhibitive epoxy primer for general industrial and marine use. May be recoated with a wide range of topcoats to give durable paint systems for immersion and non-immersion services.

Excellent aged recoatability with epoxies.

## Typical uses

- Aluminium
- Chemical plants
- Galvanised steel
- General marine use
- Hydro-electric installations
- Oil rigs/refineries
- Pulp and paper mills
- Structural steel
- Tank farms
- Waste/water treatment plants

*Please ensure the current Data Sheet and Safety Data Sheet are consulted prior to specification or application of product. If in doubt contact Resene.*

<b>Vehicle type</b>	Two component epoxy
<b>Hardener</b>	Polyamide
<b>Pigmentation</b>	Zinc phosphate
<b>Solvent</b>	Aromatic/ketone
<b>Pot life</b>	8 hours at 21°C
<b>Mix ratio</b>	4:1 (by volume)
<b>Finish</b>	Low gloss
<b>Colour</b>	Red oxide, grey
<b>Dry time (minimum)</b>	Touch dry: 2-3 hours at 21°C Through dry: 4 hours at 21°C (minimum)
<b>Recoat time (minimum)</b>	4 hours at 21°C (by spray) Maximum varies with topcoat Overcoat with two pack products or acrylics
<b>Theoretical coverage</b>	10.4 sq. metres per litre (50 microns DFT) 6.9 sq. metres per litre (75 microns DFT)
<b>Volume solids</b>	52%
<b>Recommended DFT</b>	50-75 microns per coat
<b>Usual no. of coats</b>	1
<b>Abrasion resistance</b>	Very good
<b>Chemical resistance</b>	Excellent when suitably topcoated
<b>Heat resistance</b>	Up to 90°C (dry, continuous)
<b>Solvent resistance</b>	Excellent when suitably topcoated
<b>Durability</b>	Excellent when topcoated
<b>Thinning and clean up</b>	Resene Thinner No.12
<b>Pack size</b>	4 and 20 litre composite

## Physical properties

## Performance

## Performance and limitations

1. May be overcoated with a range of high performance topcoats to give a durable coating system.
2. General purpose inhibitive primer for immersion or non-immersion and severe chemical environments.
3. Suitable topcoats include epoxies, urethanes, vinyls, alkyds (see limitations) and acrylics.
4. Up to six month recoat time with high performance epoxies. Consult manufacturer for maximum recoat times when overcoating with topcoats other than epoxies, and recommendations for overcoating when maximum recoat times are exceeded.

## Limitations

1. Not designed to give long-term protection in exterior situations without topcoating.
2. Minimum temperature for satisfactory cure is 10°C. Extended cure times at a minimum temperature of 13°C is required for immersion service.
3. Drying and curing times are proportionally shorter at higher temperatures and longer at lower temperatures.
4. Drying times of alkyd finishes, such as Resene Super Gloss (see [Data Sheet D32](#)) and Resene Mica Bond (see [Data Sheet RA71](#)) will be extended when applied directly to Resene Armourcote 220.

# Armourcote 220 epoxy primer

## Surface preparation

Coating performance is, in general, proportional to the degree of surface preparation.

### Aluminium, galvanised steel, Zinalume

Remove oil and grease with Resene Roof Wash and Paint Cleaner (see [Data Sheet D88](#)) or Resene Emulsifiable Solvent Cleaner (see [Data Sheet D804](#)). Slightly roughen surface by light sanding or alternatively lightly blast with fine non-metallic abrasive.

Surface must be clean, dry and free from all contaminants including salt deposits. If surface is glazed, roughen by light sweepblasting.

### Steel

Degrease according to SSPC SP1 solvent cleaning. Round off rough welds and sharp edges and remove weld spatter and flux.

Abrasive blast clean in accordance with SSPC SP6 (Sa 2) minimum. For total immersion service, blast clean in accordance with SSPC SP5 (Sa 3). Blast to achieve a 25-50 micron anchor profile. If profile is greater, additional film thickness is required for equivalent protection. Remove abrasive residue and dust from surface.

*Residues and dust from old paint systems containing lead or chromate may be dangerous to the health of the operator and the environment. Ensure approved procedures are put in place to safeguard against this.*

## Application

### Mixing

Stir contents of each container separately using an explosion-proof mixer. Add total contents of hardener to total contents of base. Power mix for 5 minutes and allow to stand 5-15 minutes before applying.

### Thinning

Normally not required for airless spray application. For conventional spray application thin only to improve workability with no more than 5% Resene Thinner No.12.

### Application

- **Airless spray** - Standard airless equipment with a 28:1 or higher pump ratio and a 15 to 21 thou fluid tip is recommended.
- **Conventional spray** - Industrial equipment such as De Vilbiss MBC or JGA gun with 78 or 765 air cap and 'E' fluid tip. Separate air and fluid pressure regulators, mechanical pot agitator and a moisture and oil trap in the main air supply line are recommended. Apply a wet coat in even parallel passes overlapping each pass 50% to avoid bare areas. Pinholes or holidays can be touched up by brush, repair larger areas by spray.

## Safety precautions

Consult Safety Data Sheet for this product prior to use. Users should ensure that they are familiar with all aspects concerning safe application of this product. IF IN DOUBT, DO NOT USE THIS PRODUCT.

*Please ensure the current Data Sheet is consulted prior to specification or application of Resene products. If the surface you propose to coat is not referred to by this Data Sheet, please contact Resene for clarification.*

**In Australia**  
PO Box 785, Ashmore City, Queensland 4214  
Call 1800 738 383, visit [www.resene.com.au](http://www.resene.com.au)  
or email [advice@resene.com.au](mailto:advice@resene.com.au)

**Resene**  
the paint the professionals use

**In New Zealand**  
PO Box 38242, Wellington Mail Centre, Lower Hutt 5045  
Call 0800 RESENE (737 363), visit [www.resene.co.nz](http://www.resene.co.nz)  
or email [advice@resene.co.nz](mailto:advice@resene.co.nz)

Printed on environmentally responsible paper, which complies with the requirements of environmental management systems EMAS and ISO14001. Please recycle.