PPG AQUACOVER™ 2560

DESCRIPTION

Two-component, polyamine adduct cured, waterborne zinc phosphate epoxy primer

PRINCIPAL CHARACTERISTICS

- General-purpose epoxy primer in protective coating systems for steel structures in atmospheric exposure
- Particularly suitable when solvents are not permitted because of health and safety reasons
- Speed curing in steel fabrication
- VOC compliant
- Can be overcoated with most dispersion and alkyd paints, and two-component durable finishes
- Easy application by brush/roller and (airless) spray

COLOR AND GLOSS LEVEL

- Limited color range available
- Eggshell

BASIC DATA AT 20°C (68°F)

Data for mixed product	
Number of components	Two
Mass density	1.4 kg/l (11.8 lb/US gal)
Volume solids	50 ± 2%
VOC (Supplied)	max. 100.0 g/l (approx. 0.8 lb/US gal) China GB 30981-2020 (tested) 175.0 g/l (approx. 1.5 lb/gal)
Recommended dry film thickness	50 - 75 µm (2.0 - 3.0 mils) depending on system
Theoretical spreading rate	10.0 m^2/l for 50 µm (401 ft^2/US gal for 2.0 mils) 6.7 m^2/l for 75 µm (267 ft^2/US gal for 3.0 mils)
Dry to touch	45 minutes
Overcoating Interval	Minimum: 9 hours Maximum: 6 months
Full cure after	7 days
Shelf life	Base: at least 6 months when stored cool and dry Hardener: at least 12 months when stored cool and dry

Notes:

- See ADDITIONAL DATA – Overcoating intervals
- See ADDITIONAL DATA – Curing time

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RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES

Substrate conditions

- Steel with suitable primer must be dry and free from any contamination within the recoat times
- Galvanized surfaces are variable and the preferred method of treatment is to lightly sweep blast followed by degreasing and cleaning
- Concrete; surface must be cured, clean, dry and free of desintegrated or chalky materials

Substrate temperature and application conditions

- Substrate temperature during application and curing should be above 10°C (50°F)
- Substrate temperature during application and curing should be at least 3°C (5°F) above dew point
- Relative humidity during application and curing should not exceed 75%

INSTRUCTIONS FOR USE

Mixing ratio by volume: base to hardener 11.5:1

- Adequate ventilation must be maintained during application and curing (please refer to INFORMATION SHEETS 1433 and 1434)
- Must be protected from freezing at all times during storage and/or transport
- Too much water results in reduced sag resistance and slower cure
- The temperature of the mixed base and hardener should preferably be above 15°C (59°F), otherwise extra thinner may be required to obtain application viscosity
- Water should be added after mixing the components

Induction time

10 minutes

Pot life

3 hours at 20°C (68°F)

Note:

- See ADDITIONAL DATA – Pot life

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Air spray

Recommended thinner

Tap water

Volume of thinner

0 - 10%, depending on required thickness and application conditions

Nozzle orifice

1.5 – 2.0 mm (approx. 0.060 – 0.079 in)

Nozzle pressure

0.3 - 0.6 MPa (approx. 3 - 6 bar; 44 - 87 p.s.i.)

Airless spray

Recommended thinner

Tap water

Volume of thinner

0 - 5%, depending on required thickness and application conditions

Nozzle orifice

Approx. 0.38 – 0.48 mm (0.015 – 0.019 in)

Nozzle pressure

15.0 MPa (approx. 150 bar; 2176 p.s.i.)

Brush/roller

Recommended thinner

Tap water

Volume of thinner

0 – 10%

CLEANING PROCEDURE

- Pulsator filter and tip filter must be taken out of the equipment and cleaned properly
- The following tables illustrate the cleaning procedure of the spray equipment when changing from spraying with solvent- borne paint to waterborne paints (table 1) and from waterborne paints to solvent-borne paints (table 2)

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Table of cleaning procedure

Table 1: Cleaning procedure from solvent-borne to waterborne paints	
Steps	**Text**
1st cleaning	THINNER 90-53
2nd cleaning	With warm tap water of 30°C (86°F) to 35°C (95°F) after which waterborne paints can be sprayed

Table 2: Cleaning procedure from waterborne to solvent-borne paints	
Steps	**Text**
1st cleaning	Warm tap water of 30°C (86°F) to 35°C (95°F)
2nd cleaning	THINNER 90-53

ADDITIONAL DATA

Overcoating interval for DFT up to 100 µm (4.0 mils)					
Overcoating with...	**Interval**	**10°C (50°F)**	**20°C (68°F)**	**30°C (86°F)**	**40°C (104°F)**
itself, PPG AQUACOVER™ 200/ 400/4580/5500	Minimum Maximum	12 hours 6 months	9 hours 6 months	6 hours 6 months	4 hours 6 months
SIGMADUR 520 and SIGMADUR 550	Minimum Maximum	32 hours 6 months	24 hours 6 months	18 hours 6 months	12 hours 6 months

Curing time for DFT up to 100 µm (4.0 mils)			
Substrate temperature	**Full cure**	**Dry to touch**	**Dry to handle**
10°C (50°F)	10 days	1.5 hours	6 hours
20°C (68°F)	7 days	45 minutes	4 hours
30°C (86°F)	5 days	35 minutes	3 hours
40°C (104°F)	4 days	30 minutes	2 hours

Pot life (at application viscosity)	
Mixed product temperature	**Pot life**
10°C (50°F)	4 hours
20°C (68°F)	3 hours
30°C (86°F)	3 hours
40°C (104°C)	2 hours

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SAFETY PRECAUTIONS

- Although this is a waterborne paint, care should be taken to avoid inhalation of spray mist, as well as contact between the wet paint and exposed skin or eyes
- For paint and recommended thinners see INFORMATION SHEETS 1430, 1431 and relevant Material Safety Data Sheets

WORLDWIDE AVAILABILITY

It is always the aim of PPG Protective & Marine Coatings to supply the same product on a worldwide basis. However, slight modification of the product is sometimes necessary to comply with local or national rules/circumstances. Under these circumstances an alternative product data sheet is used.

REFERENCES

- Information sheet | Explanation of product data sheets

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