

# Steelguard 3290

## High solids epoxy zinc phosphate primer

### Product Data/ Application Instructions

- **Rapid drying two pack epoxy zinc phosphate primer**
- **EPA compliant (1998) in accordance with PG6/23**
- **High build, high solids and low VOC**
- **Corrosion inhibiting**
- **Excellent adhesion to blast cleaned steel**
- **Excellent abrasion and impact resistance**
- **No maximum overcoating restrictions**

#### Typical Uses

Anticorrosive primer or primer intermediate coating for general structural steelwork operating in moderate corrosive environments. Ideal for use as a one coat functional finish or primer in CIRIA report 174 specifications.

#### Overcoating

Typically overcoated with PPG two pack epoxy and polyurethane topcoats. There are no maximum overcoating restrictions with these products provided the Steelguard 3290 is clean, dry and free of contamination before overcoating. For overcoating with other coatings please contact your PPG representative.

#### Physical Data

Finish .....	low sheen
Colour .....	red oxide, light grey, grey, buff and off white.
Components .....	2
Mixing ratio (by volume)	
resin .....	6.2 parts
cure .....	1 part
Curing mechanism .....	solvent release and reaction between components. Effective cure down to 5°C/41°F

Volume solids : ..... 72+/-3%

#### VOC\*

EC SED 1999/13/EC .....	189 g/kg (297 g/l)
UK PG6/23(92) Appendix 3 .	245 g/l

Dry film thickness ..... 75-200 µm per coat

#### typical minimum maximum

Dry film thickness (µm)	75	75	200
Wet film thickness (µm)	101	101	270

(wet film thicknesses quoted are typical for one airless spray coat)

Number of coats ..... 1

Calculated coverage ..... 9.6 m<sup>2</sup>/l at 75 µm dft

Allow for application losses, surface irregularities, etc.

Specific gravity ..... 1.6 kg/l (mixed product)

#### Flash points

(Closed Cup).....	°C	°F
resin .....	24	75
cure .....	24	75
Amercoat 18 .....	25	77
Amercoat 12 cleaner.....	24	75

\* VOC figures are quoted according to both the EC directive 1999/13/EC which are theoretically calculated figures and the UK PG6/23(92) Appendix 3 which are practically determined figures.

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## Surface preparation

Surfaces must firstly be thoroughly cleaned of all contaminants such as dust, dirt, oil, grease and salts. Then abrasive blast clean to ISO 8501-1, Sa2<sup>1/2</sup>. The blast profile achieved should be within the range 50 to 100 microns. Priming should occur before degradation of the surface takes place. If oxidation occurs then the surface should be re-prepared. The surface must be dry and free of dust, salts, grease and other contaminants immediately before coating.

## Mixing

Stir the resin component thoroughly, then add the cure and continue mixing until the product is uniform throughout. A powerful mixer should be used.

## Application

**AIRLESS SPRAY:** Use standard airless spray equipment capable of producing a minimum pressure at the tip of 2800 psi (200 kg/cm<sup>2</sup>). Tip size range 15-21 thou (0.38-0.53mm). Adjustments to pressure and tip size/angle may be necessary to obtain spray characteristics required for specific substrate configurations.

**BRUSH/ROLLER:** Application by these methods should be limited to small areas only such as repairs and when stripe coating. Apply evenly using a clean, well-loaded brush or roller. With this application more than one coat may be necessary to achieve the required dry film thickness

## Application Data

Substrate ..... blasted steel  
Application methods ..... airless spray, brush or roller  
Potlife (at 20°C/68°F) ..... 2 hours  
Induction time (at 20°C/68°F) not applicable

### Environmental conditions

Steelguard 3290 should only be applied within the limits of temperature and humidity set out below.

Relative humidity: ..... Up to 90%  
Surface temperature: ..... Minimum 2°C/36°F  
..... Maximum 40°C/104°F

The surface temperature must also be at least 3°C/5°F above the dew point during application.

As with most coatings early contact with water can result in water spotting damage. Care should be taken to protect the coating during the early stages of cure to prevent water marking.

Drying characteristics	°C/°F		
	Temperature	5/41	10/50
Touch dry	4 hours	2 hours	1 hours
Hard dry	8 hours	5 hours	2 <sup>1/2</sup> hours
Overcoating (minimum)	8 hours	5 hours	2 <sup>1/2</sup> hours
Overcoating (maximum)	-	-	-

This product will cure down to 0°C/32°F, however drying times will be extended.

Note: All information relates to the typical dry film thickness.

Thinner ..... Amercoat 18  
Cleaner ..... Amercoat 12 cleaner

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## Application procedure

1. Clean the equipment with the recommended cleaning solvent before use.
2. Stir the resin component thoroughly, then add the cure and continue mixing until the product is uniform throughout. A powerful mixer should be used. Thinning is not required.
3. For airless spray, apply a wet even coat in parallel passes. Overlap each pass by 50% to avoid bare areas, pinholes or holidays.
4. Give special attention to welds, rough spots, sharp edges and corners, rivets, bolts, etc.
5. Application at 104µm wet film thickness will normally provide 75µm dry film.
6. Check thickness of dry coating with a non-destructive dry film thickness gauge, such as Mikrotest or Elcometer. If less than specified thickness, apply additional material as needed.
7. Small damaged or bare areas and random pinholes or holidays can be touched up by brush. Repair larger areas either by spray, brush or roller using Steelguard 3290.
8. In confined areas ventilate with clean air during application and drying. The humidity should be maintained below 90% and the temperature such that moisture condensation will not form on the surface.
9. Clean all equipment with fresh, clean solvent immediately after use.

Before using the product, read the label on the can and consult the material safety data sheet.

## Shipping Data

Packaging.....	20 litres in two part units
resin .....	17.23 l in 20 l can
cure .....	2.77 l in 5 l can
Shipping weight (approx)	
resin .....	31 kg
cure .....	4 kg
Shelf life .....	1 year from shipment date or as indicated on label when stored indoors in unopened, original containers at 5 to 40°C (41 to 104°F).

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## Safety

Since improper use and handling can be hazardous to health and cause of fire or explosion, safety precautions included with Product Data/Application Instruction and Material Safety Data Sheet must be observed during all storage, handling, use and drying periods.

## Warranty

PPG warrants its products to be free from defects in material and workmanship. PPG's sole obligations and Buyer's exclusive remedy in connection with the products shall be limited, at PPG's option, to either replacement of products not conforming this warranty or credit to Buyer's account in the invoiced amount of the non-conforming products. Any claim under this warranty must be made by Buyer to PPG in writing within five (5) days of Buyer's discovery of the claimed defect, but in no event later than the expiration of the applicable shelf life, or one year from the delivery date, whichever is earlier. Buyer's failure to notify PPG of such non-conformance as required herein shall bar Buyer from recovery under this warranty.

**PPG makes no other warranties concerning the product. No other warranties, whether express, implied or statutory, such as warranties of merchantability or fitness particular purpose, shall apply. In no event shall PPG be liable for consequential or incidental damages.**

Any recommendations or suggestion relating to the use of the products made by PPG, whether in its technical literature, or response to specific enquiry, or otherwise, is based on data believed to be reliable; however, the products and information are intended for use by Buyer's having requisite skill and know-how in the industry, and therefore it is Buyer to satisfy itself of the suitability of the products for its own particular use and it shall be deemed that Buyer has done so, as its sole discretion and risk. Variation in environment, changes in procedures of use, or extrapolation of data may cause unsatisfactory results.

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Due to PPG's policy of continuous product improvement, the information contained in this Product Data/Application Instructions sheet is subject to change without notice. It is the Buyer's responsibility to check that this issue is current prior to using the product. For the most up-to-date Product Data/Application Instructions always refer to the PPG Protective & Marine Coatings website at [www.ppgpmc.com](http://www.ppgpmc.com)

To avoid any confusion that may arise through translation into other languages, the English version of the Product Data/Application Instructions will be the governing literature and must be referred to in case of deviations with product literature in other languages.

## Condition of Sale

All our transactions are subject to our Terms and Conditions of Sale.

