Retek Application Process
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EST.1990
RETEK EPOXY COATINGS
Resintek (Pty) Ltd 2022/734768/07

Steel Epoxy Coatings Application Process:

REMEMBER; Preparation is key!

The coating can only be as good as the surface it is bonding to.

Retek's Zinc Phosphate Epoxy Primer is in effect cold galvanizing (coating steel in a zinc rich primer). The zinc metal in the coating has the effect of coating the steel surfaces with zinc metal due to electrochemical action affording a protection similar to that given by hot galvanizing. Cures to a hard tough film.

Surfaces must be clean, dry and free from oil's, grease, rust, dirt and any loose particles.

- **Step 1:**

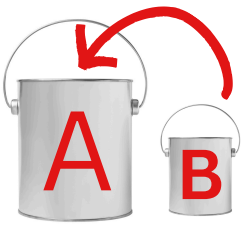
For the best results, sandblasting is recommended or hand sanding / mechanical sanding can also achieve great results.

- **Step 2:**

Wipe down surface with Retek's Thinners 300.

- **Step 3: Application of Zinc Phosphate Epoxy Primer:**

- Retek's Zinc Phosphate Epoxy Primer consists of two parts; Part A (Product), Part B (Hardner) and should be mixed at a ratio of Part A 11 : 1 Part B.
- Add Zinc Phosphate Epoxy Primer Part B to Zinc Phosphate Epoxy Primer Part A, stir well with a flat paddle or electric mixer. Try not to air rate the mixture to prevent foaming. Stir frequently to keep the chemicals from separating during the application



- Pot Life - Once Mixed use within 2 hours.
- Wait +/- 12 hours to dry. (drying times may vary depending on temperatures)
- Retek's Zinc Phosphate Epoxy Primer can be applied with a roller / paint brush or can be sprayed, using an air spray with sufficient air volume and a 1.8 - 2mm nozzle, and can be thinned, if necessary, with Retek's Thinners 300.

(Application of top coat on page 2.)

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- **Step 4: Application of Retek's Top Coat:**

- Either Retek's Poly Urethane / Heavy Duty Epoxy (depending on your requirements).
- Apply Retek's Poly Urethane / Heavy Duty Epoxy as a top coat.
- Retek Poly Urethane / Heavy Duty Epoxy consists of two parts; Part A (Product), Part B (Hardner) and should be mixed at the correct ratio. Poly Urethane at a ratio of 4:1. Heavy Duty Epoxy at a ratio of 11:1.
- Add Retek's Poly Urethane / Heavy Duty Epoxy Part B to Poly Urethane / Heavy Duty Epoxy to Part A, and stir well with a flat paddle or electric mixer. Try not to air rate the mixture to prevent foaming. Stir frequently to keep the chemicals from separating during the application.

- Pot life - Once mixed use within 2 hours.
- Retek's Poly Urethane can be sprayed using a conventional spray gun, airless spray gun, roller or paint brush.
- DO NOT thin down Poly urethane with Thinners, use ONLY Retek's Solvent Blend.
- Retek's Heavy Duty Epoxy can be sprayed using a conventional spray gun, airless spray gun, roller or paint brush.
- Use Retek's Thinners 300 to dilute the Heavy Duty Epoxy.
- Wait +/- 12 hours to dry. (drying times may vary depending on temperatures)
- Full curing time is 7 days.