



## PRIMECOAT

### Product description

PRIMECOAT is a **SINGLE-PACK** barrier coating **Base Coat** based on GRAFTED CO-POLYMER and specialty functional additives to protect metal surfaces in most aggressive conditions in combination with top coat systems.

### Product highlights

- Single Pack , Quick Drying system
- Impermeability to Oxygen
- Excellent Resistance to moisture
- Excellent adhesion to multi metal substrates.

### Recommended use

A universal formulation specifically designed for use in various environmental situations. To be used on steel in combination with top coat systems. It exhibits excellent adhesion properties with base metal surfaces. It offers excellent performance in salt and fresh water with its moisture resistant properties. PRIMECOAT offers excellent Aging & weathering resistance coupled with resistance to chemicals and it is used as base coat to top coat systems to protect the metal components & structure in the most aggressive conditions.

### Film thickness and spreading rate

Film thickness, dry ( $\mu\text{m}$ ) (DFT)	35-40 Microns per coat
Theoretical spreading rate ( $\text{m}^2/\text{l}$ )	6.0 per Liter

### Surface preparation

All surfaces should be clean, dry and free from contamination. The surface should be assessed and treated in accordance with ISO 8504. Bare steel Cleanliness: Blast-cleaning to Sa 2½ (ISO-8501-1:2007). Power tool cleaning to min. St 2 (ISO 8501-1:2007) may be acceptable, subject to exposure conditions. Blast Cleaning should be done after solvent wipe (SSPC SP1) to ensure removal of all dust, dirt, oil, grease, etc.

### Surface conditions

Temperature of the substrate – Minimum 3°C above the dew point of the air temperature

Relative humidity – Maximum 80 % measured in the vicinity of the substrate.

Ventilation - Good ventilation is required in confined areas

Do not use heated air until the solvents (Thinner) have evaporated (flashed off) from the paint film to avoid surface drying and solvent entrapment. During application and the initial drying of the coating, the object should not be exposed to high humidity as this can result in loss of gloss.



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### **Application methods**

Spray -Use Airless Spray

Brush - Recommended for stripe coating and small areas, care must be taken to achieve the specified dry film thickness.

Roller- May be used for small areas, however when using roller application care must be taken to apply sufficient material in order to achieve the specified dry film thickness.

### **Application data**

Mixing ratio - Single Pack System. (No Mixing of Two Components)

Pot life - Not Applicable. No Pot Life (Can be used for six months after opening the Container)

### **Guiding data airless spray**

Pressure at nozzle- 15 MPa (150 kg/cm<sup>2</sup>, 2100 psi)

Nozzle tip - 0.43-0.79 mm (0.017-0.031") Suitable

Spray angle - 40-80°

Filter Check to ensure that filters are clean.

### **Drying time**

Drying times are generally related to air circulation, temperature, film thickness and number of coats, and will be affected correspondingly. The figures given in the table are typical with: \* Good ventilation (Outdoor exposure or free circulation of air) \*

<b>Substrate temperature</b>	-10°C	0°C	10°C	23°C	40°C
<b>Surface dry (dry to handle)</b>	30 min	25min	20 min	15 min	10 min
<b>Hard dry</b>	72 hours				
<b>Dry to recoat, minimum</b>	30 minutes minimum (for testing purpose- 7 days)				

### **Recommendations for coating system**

PRIMECOAT - 1 to 2Coats (35-40 µm per Coat)

### **Handling coated jobs**

Do not stack coated components one over other immediately after coating.

Use Nylon ropes or Wire ropes with rubber padding at contact areas to shift the components after coating is dry to handle.

### **Storage**

The product must be stored in accordance with national regulations. Keep the containers in a dry, cool, well ventilated space and away from source of heat and ignition. Containers must be kept tightly closed.



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**Best use time**

If stored below 25°C in the recommended condition, the product remains usable for 6 months.

**Handling the containers**

Handle with care. Stir well before use. Do not leave the container open after use. Pack it air tight.

**Packing size**

20 liters Metal Containers

**Health and safety**

Please observe the precautionary notices displayed on the container& in our MSDS. Use under well ventilated conditions. Do not breathe or inhale mist. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water and medical attention sought immediately. For detailed information on the health and safety hazards and precautions for use of this product, we refer to the Material Safety Data Sheet.

**Disclaimer**

The information in this data sheet is given to the best of our knowledge based on laboratory testing and practical experience. However, as the product can be used under conditions beyond our control, we can only guarantee the quality of the product itself. We also reserve the right to change the given data without notice. Minor product variations may be implemented in order to comply with local requirements.

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