

Technical Bulletin # 1021F

Product Description

RUST INHIBITIVE PRIMER is a lead and chromate free, rust inhibitive, two-component, epoxy primer specifically designed for use in conjunction with ITW Polymer Technologies coatings applied to metal substrates. It meets USDA standards for maintenance protective coatings not in direct contact with food in federally inspected meat and poultry plants.

Use & Benefits

RUST INHIBITIVE PRIMER is recommended for use as a metal primer in severe industrial and chemical environments. It possesses excellent adhesion to properly prepared iron and steel surfaces, providing rust resistance to ferrous substrates, both on initial application and in the event of damage to the topcoat. It can be used under many epoxy, urethane, vinyl, chlorinated rubber and coal tar/epoxy finish coats.

Surface Preparation

Steel: Surfaces must be dry, clean and free of all previous coatings, rust and surface contamination. Minimum surface preparation is abrasive blast to Commercial Grade SP-6. Blasted surfaces must be coated within 8 hours. Prior to blast cleaning, remove all deposits of oil or grease using Solvent Clean method SP-1.

Previously Painted Surfaces: If the paint is peeling or degrading in any way, it should be completely removed by sanding, blasting or stripping. If previous paint coating is completely intact, the surface may be cleaned with a strong detergent or solvent and scuff sanded to remove the gloss. A spot test should be made by applying a small amount of coating over old paint. The old finish may wrinkle or lift within 60 minutes. If it does not, wait 5 days and test for adhesion. Do this by cutting an "X" into the coating, place tape firmly over the cut, then strip with a hard, fast pull. If the old finish fails, it must be removed.

Application Instructions

Pour 1 part resin (dark gray) and 1 part hardener (cream) into a container and power mix for 2-3 minutes to insure that all pigment is completely dispersed. Allow 30 minutes "sweat-in-time" in covered container before applying. All material and surface temperatures must be at least 55°F (13°C) and air temperature must be 5°F (3°C) above dew point. Relative humidity must be less than 85%.

Application can be done with brush, roller or spray. Recommended "airless spray equipment" includes Devilbiss JGA-Gun, Graco Golden Gun, etc. (tip size -- 0.015 to 0.021" @ approximately 2500 psi). Clean all equipment with IMPAX IXT-59. Allow 8 hours cure time before applying finish coats. Apply finish coat within 5 days of priming.

Physical Properties

VOLUME SOLIDS	67%
VOC (Based on mixed components)	<2.8 lbs./gal. (<263 gms./ltr.) (Based on mixed components)
FLASH POINT	80°F TCC (27°C)
VISCOSITY	1000 cps
SERVICE TEMPERATURE	200°F (90°C) Dry Heat Resistance

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Product Information

COLOR	Gray
GLOSS	Satin Sheen
COVERAGE	250 to 300 sq.ft./gal. @ 3 to 3.7 mils DFT (23.2 to 27.9 m ² /gal. @ 75 to 95 microns DFT)
APPLICATION TEMPERATURE	55°F minimum to 95°F maximum (13°C minimum to 35°F maximum) * 5°F (3°C) above dew point
RECOAT	Minimum - 6 Hours @ 72°F (22°C) @ 50% RH Maximum - 24 Hours @ 72°F (22°C) @ 50% RH
MIXING RATIO	1:1 equal parts epoxy resin/hardener
INDUCTION	30 mins. (sweat-in-time)
RELATIVE HUMIDITY	85% maximum
POT LIFE	6 hrs. @ 72°F (22°C)
CURE TIME (approximate)	Fully cured in 7 days
REDUCER	None
CLEAN UP	IMPAX IXT-59 Solvent
SHIPPING WEIGHT	11.3 kg (25 lbs.)
UNIT PACKAGING	Resin (NH): 3.9 L (1.0 gal) in a 1 gal can Hardener (NH): 3.9 L (1.0 gal) in a 1 gal can
UNIT WEIGHT	Resin: 5.4kg (12.0 lbs) Hardener: 3.7 kg (8.1 lbs)
SHELF LIFE	12 months in closed container stored @ 50°F to 90°F (10°C to 32°C)

Precautions

Flammable -- Keep away from heat and open flame. Maintain good ventilation and avoid breathing vapors. Avoid prolonged and repeated skin contact.

Date

10/2006

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