

ITW PHILADELPHIA RESINS RUST INHIBITIVE PRIMER

Technical Bulletin # 1021D

PRODUCT DESCRIPTION: A lead and chromate free, rust inhibitive, two component epoxy primer specifically designed for use in conjunction with Philadelphia Resins coatings applied to metal substrates. It also meets USDA standards for maintenance protective coatings not in direct contact with food in federally inspected meat and poultry plants.

RECOMMENDED USES: 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; it provides 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: All 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.

RECOMMENDED SYSTEMS: One coat of RUST INHIBITIVE PRIMER is recommended as a primer under all Philadelphia Resins coatings when applied over ferrous substrates.

IMPORTANT: When coating previously painted surfaces, always apply test patch and examine for lifting and proper intercoat adhesion. If lifting occurs, remove old coating or apply an appropriate barrier coat.

MIXING AND 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.



TECHNICAL INFORMATION

COLOR:	Gray
GLOSS:	Satin
VOLUME SOLIDS:	67%
VOC: (based on mixed components)	<2.8 lbs./gal. (<350 gms./ltr.)
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)
PACKAGING:	2-gal. unit containing 1 gal. can epoxy resin, 1 gal. can hardener (7.5 liter unit) 10-gal. unit containing 5 gal. can epoxy resin, 5 gal. can hardener (38 liter unit)
APPLICATION TEMPERATURES:	55°F minimum to 95°F maximum (13°C minimum to 35°C maximum) * 5°F (3°C) above dew point
RELATIVE HUMIDITY:	85% maximum
SERVICEABILITY:	Recoat--8 hours minimum @ 72°C (22°C) @ 50% RH Full Cure--5 days maximum @ 72°F (22°C) @ 50% RH
MIXING RATIO:	1:1 equal parts epoxy resin/hardener
INDUCTION:	30 mins. (sweat-in-time)
POT LIFE:	6 hrs. @ 72°F (22°C)
FLASH POINT:	80°F TCC (27°C)
VISCOSITY:	1000 cps
REDUCER:	Impax IXT-59 (for clean-up only)
SERVICE TEMPERATURE:	200°F (90°C) Dry Heat Resistance
SHELF LIFE:	12 months in closed container stored @ 0°F to 90°F (-18°C to 32°C)
PRECAUTION:	Flammable -- Keep away from heat and open flame. Maintain good ventilation and avoid breathing vapors. Avoid prolonged and repeated skin contact.