PRODUCT DATA

PRODUCT NAME : AK-513

PRODUCT DATA

DESCRIPTION: Two component air drying polyurethane based primer containing zinc phosphate/ zinc chromate as anti corrosive pigment.

RECOMMENDED USE: Recommended as a primer for suitably cleaned MS surface in OEM equipment painting as well as an anti corrosive primer in Process industries like fertilizer plants, Refineries, Petrochemical complexes for protection of steel pipelines and structures from corrosion.

PHYSICAL DATA

COLOUR: RED OXIDE / GREY
FINISH: Matt
SOLIDS BY VOLUME: 56±3%
THEORITICAL COVERAGE: 14 sq.mt/ltr at recommended DFT of 40µ
FLASH POINT: Base: 23degree C; Hardener: 23degree C; Mixed: 23degree C
DRYING CHARACTERISTICS: Surface dry**:** 20-30 Minutes; Hard dry: 24 Hours; Full cure: 7 Days
(At 30degree C and 65% Relative humidity)
SHELF LIFE: Base: 9 months; Hardener**:** 6 Months At 25degree C

APPLICATION DATA

MIXING RATIO: Base: Hardener – As per our recommendation
MATURATION TIME: 5 – 10 minutes
POT LIFE: 6 hours at 30degree C
APPLICATION: By Brush / By Air spray / By Airless spray
THINNER :AK-582
RECOMMENDED DFT: 40-45 µ per coat
CORRESPONDING WFT: 72-80 µ per coat
OVERCOATING INTERVAL: MIN: 8 hours; MAX: 24 hours
If exceeds, the surface should be roughened by emery scuffing.
COMPATIBILITY: Can be applied over recommended Epoxy and Polyurethane primers, Intermediate coats.

SURFACE PREPARATION

This being a top coat which is applied over underneath or intermediate coats, the surface should be free from oil, moisture, dust and dirt. Aged coating should be roughened by emery paper grade 220.For better bonding, all surface should be clean, dry and free from contamination. The surface should be assessed and treated in accordance with ISO 8504. For more details contact us. It is advisable that a small trial be carried out before applying a full coat.

HEALTH & SAFETY

All work involving the application and use of this product should be performed in compliance with all relevant National Health, Safety & Environmental standards and regulations. Prior to use, obtain, consult and follow the Material Safety Data Sheet for this product concerning health and safety information. Read and follow all precautionary notices on the Material Safety Data Sheet and container labels. If you do not fully understand these warnings and instructions or if you can not strictly comply with them, do not use this product. Proper ventilation and protective measures must be provided during applying and drying to keep solvent vapors concentrations within safe limits and to protect against toxic or oxygen deficient hazards. Take precautions to avoid skin and eye contact (i.e. gloves, goggles, facemasks, barrier creams etc.) Actual safety measures are dependant on application methods and work environment. This is a solvent based paint and care should be taken to avoid inhalation of spray mist or vapor as well as contact between the wet paint and exposed skin or eyes.

Warning: Contains isocyanate. Wear air-fed hood for spray application.

APPLICATION METHOD

Stir the Base part thoroughly. Mix the base and hardener as per our recommended ratio, by volume. Stir & mix thoroughly to attain homogeneity. Add PU Thinner AK-582 into the mix, if required, depending on application method, and stir thoroughly for few minutes. Allow the mixture to stand still (maturation) for about 10-15 minutes to initiate the reaction. Strain the paint through Nylon filter cloth of 400 mesh size and apply uniformly over the surface. The temperature of the substrate should be minimum 3°C above the dew point of the air, temperature and relative humidity measured in the vicinity of the substrate. Good ventilation is

usually required in confined areas to ensure correct drying. All equipments used for above should be properly cleaned. Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with recommended thinner. Once units of paint have been mixed they should not be resealed and it is advised that after prolonged stoppages work recommences with freshly mixed units. Clean all equipments immediately after use with recommended thinner. It is good working practice to periodically flush out spray equipment during the course of the working day. Frequency of cleaning will depend upon amount sprayed, temperature and elapsed time, including any delays. Do not exceed pot life limitations. All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation. In the event where welding or flame cutting is performed on metal coated with this product, dust and fumes will be emitted which will require the use of appropriate personal protective equipment and adequate local exhaust ventilation.

Application: By Brush/By Air Spray / By Airless Spray
For Brush application, a maximum of 5% thinner, if required, is to be added. Apply uniformly in criss-cross manner and ensure there are no misses. Use quality brushes for paint application.

For Air spray application:
Thinner: AK-582
Addition: 10-15%
Nozzle Orifice: 1 .2 -1 .4 mm
Nozzle Pressure: 40-70 p.s.i

For Airless spray application:
Thinner: AK-582
Addition: Max 5%
Nozzle Orifice: 0.28 mm
Nozzle Pressure: 1400-1800 psi.

ADDITIONAL INFORMATION

Further information regarding industry standards, terms and abbreviations used in this data sheet
can be found in our Data manual.

NOTES

1. Do not apply paint when temperature falls below 10°C or rises above 50°C and when Relative Humidity is above 85%, Do not apply during rain, fog, or mist.
2. Brushes and spray equipment should be cleaned with recommended thinner otherwise equipment is liable to damage.
3. Volume Solids will vary depending on shades. Products with different volume solids are also available on request.
4. DFT variation can be obtained by change in application method/thinning ratio. Contact us for further assistance.
5. Shelf life indicated is minimum for this Product and it is subjected to re-inspection thereafter. Individual component is required to be store in cool, dry and covered condition, away from heat and ignition.

DISCLAIMER

The information contained within this data sheet is based on information believed to be reliable at the time of its preparation. The company will not be liable for loss or damage howsoever caused including liability for negligence which may be suffered by the user of the data contained herein. It is the users' responsibility to conduct all necessary tests to confirm the suitability of any product or system for their intended use. No guarantee of results is implied since conditions of use are beyond our control.