

FEATURES

Advantages:

- Contains new technology anti-corrosive inhibiting pigments (no lead or chromate pigments)
- Single package
- Economical
- Provides good corrosive protection on steel surfaces
- Applies readily by spray application
- Coated articles dry quick to handle
- Can be top coated in 1 hour
- Contains Anti-corrosive Zinc Phosphate Pigment
- Ready for use

Limitations of Use:

- Do not use Duroprime HB in chemical or continuous wet exposure
- For exposed conditions should be top coated with alkyd enamel finish coats

RECOMMENDED USES

A fast drying rust inhibiting primer for steel surfaces in non-immersion areas.

- Suitable for shop application
- High Build primer for alkyd enamel finish coats

SPECIFICATION DATA

Coating Type:	Modified Alkyd
Colour:	Red Oxide, Grey
Packaging:	20 litre
Mix Ratio:	n/a
Gloss	Matt
Flash Point:	38 °C Setaflash
Thinner:	X-100 Thinner
Pot Life:	n/a
Induction Time:	n/a
Shelf Life:	Store under cool dry conditions

Density:	1.29 kg – 1.31 kg per litre
VOC:	
Temperature Resistance:	May discolour over 107 °C
Volume solids:	43 %
Theoretical Coverage Rate:	6.1 sq. metres per litre at 70 microns DFT
Recommended Film Thickness Per Coat:	163 microns wet to obtain 70 microns dry
Application:	Spray, Brush or Roller

Dry Times (70µm DFT / 50% RH):				
Recoat – minimum:	5°C	10°C	25°C	30°C
Single pack	24 hrs	8 hrs	3 hrs	3 hrs

Recoat – maximum:	5°C	10°C	25°C	30°C
Single pack	n/a	n/a	n/a	n/a

SURFACE PREPARATION

All surfaces to be coated should be clean, dry and free from contamination. Oil or grease should be removed in accordance with AS1627.1 solvent cleaning. Surface defects revealed by the preparation process, should be ground, filled, or treated in the appropriate manner. Clean to remove all grit dust and debris and ensure the surface is dry.

Steel Surfaces:

Abrasive blast to AS1627.4 Class 2 ½ to achieve a uniform blast profile between 38 to 63 microns and a jagged nature as opposed to a peen pattern. A lesser degree of cleaning will reduce the service life of the coating.

Previously Painted Surfaces:

Clean with Altex P40 Cleaner. Remove loose and peeling paint. Prepare all corroded and damaged paint areas in accordance with the preparation required for the applicable primer. Feather back edges to a sound clean existing coating. Abrade all existing coating to provide a fine matt finish. Clean to remove all grit dust and debris and ensure the surface is dry.

DIRECTIONS FOR USE

Mixing:

Use mechanical agitation for proper mixing, to ensure uniform condition. Stir until thoroughly mixed.

Thinning:

Thinning maybe required to assist application. Any solvent addition should be made after the component is thoroughly mixed. Excessive thinning can cause low film thickness and coating defects.

Clean-up:

Use X-100 Thinner

Application:

The preferred method of application for Duroprime HB is spray. Small areas may be brush or rolled if conditions are suitable, however care must be taken to ensure that the correct film thickness is obtained.

Suggested spray equipment is:

Air Spray:	DeVilbiss JGA 544 Gun, 'E' Tip and 704 Air Cap or equivalent. Adjust fluid and air pressure to get a good spray pattern.
Airless Spray:	Graco 30 to 1 pump or equivalent and 017 to .019 range tip sizes.

Note: Other equipment equivalent to the above may be used.

PRECAUTIONS

For industrial use only.
See the Altex Coatings Limited General Safety Data Sheet, product label and Material Safety Data Sheet (MSDS) for health and safety information prior to use.

Duroprime HB is flammable. Keep away from heat, sparks and open flame. Use with adequate ventilation.
May cause eye and skin irritation.
Do not breathe vapour or spray.
Wear suitable protective clothing such as gloves and eye and face protection.

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