

PRODUCT DATA SHEET

HDPRIME 901



Description: A single pack quick drying product having excellent adhesion and anti corrosive properties. Specifically for aluminium and galvanized surfaced and newly blasted or cleaned steel. Meets ASTM D 3455 specification.

Recommended use: Designed as fast drying etch primer with excellent adhesion to ferrous metals.

Physical Properties :

Colours/shade Nos.:	White* (Other shades are Available on request)
Finish:	Flat
Volume solids, %:	15 ± 2%
Theoretical spreading rate:	12.56 m ² /litre, 12micron
Flash point:	15°C
Specific gravity:	1.00 kg/litre
Touch dry:	15 minutesat 30°C
Hard dry:	1 hours at 30°C
VOC content:	720 g/litre

Application details:

Version, mixed product	HDPRIME 901
Mixing ratio:	Single pack
Application method:	Airless spray /Air spray/Brush/Flow coating
Thinner (max.vol.):	25-30%
Nozzle orifice:	.036"- .052"
Nozzle pressure:	110 kg/cm ² [1520 psi] <i>(Airless spray data are indicative and subject to adjustment)</i>
Indicated film thickness, dry:	10-15 micron
Indicated film thickness, wet:	80-85 micron
Overcoat interval, min:	According to Specification
Overcoat interval, max:	According to Specification

Safety: Handle with care. Wear Necessary PPEs like safety shoes, gloves, goggles.

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Surface preparation:

Steel: Remove rust, solder and other loose material with grinder, wire brush and mechanical sander. Surface should be cleaned with grease remover.

Galvanized Steel:

Clean and degrease while abrading the surface with a **coarse** abrasive pad. Abrade new or shiny surfaces until all shine is removed. Abrade to remove all surface corrosion, tough grime and short term protective coatings.

Alternatively, wash with a phosphoric acid based metal treatment using a coarse abrasive pad. Ensure surface is rinsed and dried according to instructions before applying UNIPRIME 901. A small area should be tested to ensure adhesion is acceptable. Apply *UNIPRIME 901* to 10-12 micron dry film thickness.

Aluminum:

Thorough surface preparation is critical with aluminum surfaces.

Round off all sharp edges and corners. Remove weld spatter and grind welds smooth.

Clean and degrease with *thinner*. The rags should be frequently discarded so that contamination is cleaned off as opposed to being spread by dirty rags. This step is especially important for new aluminum which is usually contaminated with a film of roll forming oil.

Thoroughly abrade by sand blasting (whip blasting), by machine using 60 grit aluminum oxide paper, or by hand using 80-120 grit wet & dry paper or coarse (maroon) abrasive pad.

Clean and degrease again with *thinner*.

Application conditions:

Apply only on a dry and clean surface Temperature of the surface to be coated must be at least 3°C above the dew point. For optimum application properties bring the material to 21-27°C. In confined spaces provide adequate ventilation during application and drying.

Preceding coat:

According to specification.

Subsequent coat:

According to specification.

Remarks/Notes:

Use suitable proprietary equipment.

If thinned multiple coats may be required to achieve minimum specified dry film thickness.

Application by brush is recommended for small areas only.

Multiple coats will be required to achieve specified film thickness

Shelf Life:

12 months in 25°C.

Store in dry, shaded conditions away from sources of heat and ignition.

This Product Data Sheet supersedes those previously issued.

Data, specifications, directions and recommendations given in this data sheet represent only test results or experience obtained under controlled or specially defined circumstances. Their accuracy, completeness or appropriateness under the actual conditions of any intended use of the Products herein must be determined exclusively by the Buyer and/or User.

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