ROFAST PRIMER 105

DESCRIPTION:

It is fast dry synthetic primer based on heat resistant resin up to 200 °C with high corrosion resistance properties applied on steel structure above water line in ship paint system or inshore purposes to give the following advantages :

- A high quality good anti corrosive primer for steel surfaces.
- Fast drying properties.
- Lead and chromate free.

TECHNICAL DATA :

- Finish : Egg shell.
- Color : Grey and red brown.
- Solid by volume : 60 % approx.
- Specific gravity : 1.56
- Theoretical spreading rate : 8 m2/ Gm (50 microns D.F.T)
- Dry film thickness : 50 microns
- Wet film thickness : 85 microns.
- Thinner : Roots thinner No. RO1001.
- Drying time
  - Surface : 15 min (at 25 °C & 60 % R.H.)
  - Full cured : 72 hrs. (at 25 °C & 60 % R.H.)
- Recoat interval
  - Min : 4 – 6 hrs. (at 25 °C & 60 % R.H.)
  - Max. : No limitation

- Shelf life : 6 months (at normal conditions in original containers)
  Flash point : 35 °C.
- Packing : 25 Kgm.

SURFACE PREPARATION :

Steel : Blast cleaned to Iso- Sa 21/2 .

Steel : Power tool cleaned to min Iso- St2.

Shop primer steel : Sweep blasted or power tool cleaned to SPSS-Ss or SPSS-St2.

Aluminum : Etched and passivated etch primed or sufficiently roughened .

Previous coat : Dry and free from any contamination .

Substrate temperature : Should be at least 3 °C above dew point .

APPLICATION METHODS :

By roller & brush :

- Volume of thinner : 2 – 5 %

By air spray :

- Volume of thinner : 5 – 10 %
- Nozzle orifice : 2 – 3 mm.
- Nozzle pressure : 3 – 4 bar.

By airless spray :

- Volume of thinner : 2 – 5 %
- Nozzle orifice : 0.02” – 0.03”.
- Nozzle pressure : 120 – 150 bar.