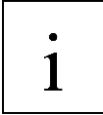


Always use correct Personal Protective Equipment

440 Industrial Primer

Description



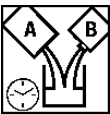
440 Industrial Primer is a 2 Pack Polyamide cured inhibitive Epoxy primer. Maybe top coated with a wide range of top coats for the Commercial Transport and light industrial markets.

Formulated for use with the following RALI topcoats: High Solids Acrythane, Std 805 Acrythane, Spraying Enamel, on correctly prepared steel and other ferrous substrates. Ideally this product is used with RALI topcoats as mentioned above however alternative topcoats can be applied but it is highly recommended that you test a small sample area first to ensure compatibility of your particular topcoat with desirable finish and product performance.

Point to Note:

All raw steel MUST HAVE Mill scale removed to white metal Sa 2.5 minimum by power tool or 30 micron anchor profile grit blasting with Garnett grade C. 440 Industrial Primer can be used on agricultural and industrial implements and machinery also ideal for heavy steel chassis. It has excellent adhesion on a variety of substrates and works very well as a holding primer for up to 3 months if kept out of the weather.

Products



Product Type:	Two Component Epoxy 2K Primer
Colour:	Light Grey, Dark Grey, Black, White and Tinted Colours
Pot Life:	4hr at 20 Deg C
Induction Time:	N/A
Recommended DFT:	50 – 70 microns DFT per coat.
Theoretical Coverage:	8 m ² / L this is only a guide due the varying methods of application equipment.

Properties



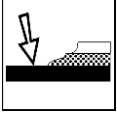
Volume Solids:	52%
Recoat-ability:	Can be recoated with 2K polyurethanes WOW or non sand after 4 hr or over night. This product can be left up to 3 months as a holding primer non exterior.

For best practise It is **highly** recommended that you test a small sample area first to ensure compatibility of your particular topcoat to achieve a desirable finish and satisfactory product performance. If 440 Industrial Primer has been left for some time ie after one week or more it is advisable to test a small area for topcoat performance given the varying nature of many topcoats. If necessary well abrade before topcoating.

No warranty either expressed or implied is made by RALI in this document, which is a technical data information sheet. The description of the product and its properties is for the sole purpose of identifying the product and does not constitute a warranty that the product or its properties shall conform to that description, nor is the description of the product and its properties a warranty by RALI that the goods are suitable for a particular purpose. Do not apply paint if relative humidity is above 85% or temperature is within 3 deg C of Dew Point being the MPT or Minimum Paint Temperature.

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Substrates



440 Industrial Primer can be applied over correctly prepared:

- Steel
- Galvanised Steel
- Aluminium
- Lead Bulbs for Yachts
- Sanded cured substrates.
- Sanded cured 2K substrates
- Composites such as Carbon Fibre & GRP.

Surface Preparation



Coating performance is in general, proportional to the degree of surface preparation. Surfaces to be painted must be clean, dry and free from all traces of contamination, corrosion and must be well abraded.

Heavy Steel:

On heavy steel with mill scale evident the substrate must be abrasive blasted with Garnett grade C to class 2.5 30 micron profile. The substrate should be clean white metal with no rust, mill scale, welding flux or any other surface contaminates. This exposed blasted surface should be kept in dry conditions and must not come into contact with any contaminates such as open or uncovered hands, the use of approved gloves are highly recommended. For best results this surface should have 440 Industrial Primer applied as soon as practical or within the working day in a controlled environment such as a heated spray booth.

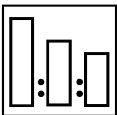
Aluminium & Galvanised Steel:

Degrease with Wax & Grease Remover. Mechanically abrade with P180 or P240 disc. Surfaces to be painted must be clean, dry and free from all traces of contamination, corrosion and must be well abraded. Using approved gloves and lint free cloths air blow and tack clean ready for primer application.

Veneer Coated Plywood & General Timbers:

Strongly advise testing a small area for coating success due to the amount of variables in veneers & timbers. Ensure substrate is dirt, dust & grease free. Depending on the particular wood substrate most can be coated on day one, left for overnight drying in warm temperatures (20°C at least) finish sand with 400 grit detail dry sand and recoated the following day.

Mix Ratios



Mixing By Volume:

Mix Ratio: 4:1:1 4 parts 440 Industrial Primer
 1 Part 440 Industrial Primer Hardener
 0 to 2 parts 440 Industrial Primer Reducer

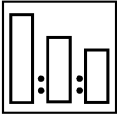
Ford4 viscosity cup time: 22 sec at 4:1:1

Note: Substitute 50% BV of the reducer ratio with RALI electrostatic reducer at 4:1:1 BV, this will achieve approx 20 Mega Ohm's for electrostatic application.

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Mix Ratios Cont



Dry Time @ 20°C: Touch Dry: 1 Hour / Handle: 6 Hours 20°C / can be force dried if needed. This is film build dependant and therefore a guide only.

Application Method:

Compliant & Conventional spray, air assisted airless or airless, Electrostatic.

Points to Note:

- 1) **Not designed to give extremely long-term protection without over coating with RALI topcoats however 440 Industrial Primer can be used as a holding primer for up to 3 months providing total film builds are sufficient.**
- 2) **When spraying, use the correct primer gun set up as recommended by your equipment supplier to achieve a dry film thickness (DFT) 50 microns above the peaks of the blast profile.**
- 3) **Application techniques should be adjusted as necessary to achieve the recommended dry film thickness. It is good practice to check this process on a small sample prior taking on a large project.**
- 4) **If you do not have a controlled environment to spray in it is good practice NOT to continue if relative humidity is above 85% and in particular if temperatures are below 15°C or below 3 Deg C of Dew Point.**
- 5) **For Uniform colour consistency 440 Industrial Primer should be applied within 30-45 minutes of mixing 440 Industrial Primer with 440 Industrial Hardener. Failure to do so could result in 'yellowing' of some tinted colours.**

If using Electrostatic Reducer 440 Industrial Primer can also be used through electrostatic spraying equipment however your equipment supplier would provide guidelines on appropriate resistant levels to achieve correct wrap.

Spread Rate guide:

Spraying equipment with a transfer efficiency of approx 35% you can expect a spread rate of approximately 4 to 5 m²/ litre. Compliant or HVLP equipment with a transfer efficiency rate of approx 65% can improve your spread rates up to approx 8 to 10 m²/ litre.

Remember always filter strain products before using them

Spray Equipment:



Compliant & Conventional suction and gravity feed guns.

Tip Size: 1.8 – 2.5 mm

Spray pressure: 275-380KPA (40-55 psi)

Number of coats: 2 coats (5-10 minutes flash between coats)

Air less / Air assisted airless & electrostatic: Follow equipment manufacturer's recommendations.

Remarks: Do not use activated material beyond pot life time or by reducing it further to get the viscosity down again. This practice results in poor flow and adhesion failures.

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Always use correct Personal Protective Equipment**Health & Safety**

For detailed information refer to Safety Data Sheet (SDS). Inhalation of vapours or dust from sanding may cause respiratory sensitisation. Splashes to eyes will cause irritation. Contact with skin may cause irritation. Applicators should use protective clothing and air feed respiratory equipment. Product is flammable, use and store away from heat and ignition sources

Transport & Storage

Sizes:	4L
Dangerous Goods:	3A
UN:	1263
Hazchem:	3(Y)
Packing Group:	III
Shipment name:	PAINT Flammable Liquid Low Flash Point
Flash point:	24°C

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