

POLYURETHANE ZINC PHOSPHATE HIGH BUILD GREY PRIMER

RAMCOAT[®] PRIME 305 HB

Product Description

An acrylic aliphatic Polyurethane high build surfacer which provide excellent adhesion over metal surface and getting leveling of top coat when applied on RAMCOAT[®] PRIME 305 HIGH BUILD primer. It can be applied directly on MS substrate as Primer cum Surfacers.

Recommended Use

- For application on Structural Steel, Pipelines, Storage Tank, Plant Equipments etc.
- Subjected to Corrosive environment. Suitable for Pulp & Paper, Chemical Plants, Fertilizer Plant, Refineries, Petrochemical and Pharmaceutical Industries, Cement Plants, Steel Plants, OEM sectors.

Technical Information

PROPERTY	SPECIFICATION
Type	Two Component
Finish	Smooth & Matt
Colour	Grey
Mixing Ratio	Base : Hardener (By Volume) – As per recommendation
POT LIFE @30°C	10 Minutes
Volume Solid, %	3 ±1 hr
Recommended DFT	55 – 60μ / Coat
Recommended WFT	110–120μ
Covering Capacity (TCC)	8.33 m ² / l @ 60μ 9.09m ² / l @ 55μ

Drying Time (At 30° C & 65 % Relative Humidity)

STAGE	TIME
Surface Dry	15–20 Min
Hard Dry	2 hr

Over Coating Interval : MIN: 50 MIN ; MAX: 2 hrs.

Relative Humidity (%) –30 Min, Overcoating Interval – 8 hrs.

Flash Point

COMPONENT	FLASH POINT
Base	Above 25 °C
Hardener	Above 25 °C

Recommended Thinner :

"RAMCOAT" SPL Thinner

Shelf Life:

12 months under normal storage conditions in original containers at 30°C

SURFACE PREPARATION:

- Clean the surface and remove grease, oil, water, dust and other Contaminants in accordance with SSPC–SPI solvent cleaning.
- Abrasive blast cleaning upto Sa 2½ performance (ISO 8501-1: 2007) or SSPC–SP6 (Surface profile from 50 to 75 Micron) to avoid oxidation, RAM SIL has to be applied immediately after blasting.
- Excessive burnishing of metal substrate is to be avoided.

APPLICATION :

- RAMCOAT[®]SIL is supplied in two pack:
- PART-A (Liquid Binder-Base) and PART-B (Powder Component).
- PART-B (Powder component) to be added slowly into the PART-A (Liquid Binder) under stirring with mechanical stirrer.
- **NOTE: Liquid-Binder should not be added in to the powder.**
- Apply directly without thinner. However, Thinner may be used depending upon climatic condition.
- Now filter the mix material before application. Make sure when starts applying primer, mix material should be under stirring.
- Also make sure mix material should be consumed within specified time of pot life. Surface temperature should be above 3°C of dew point.
- Brush – Apply preferably without thinning for small area only.
- Airless Spray – Airless spray essential to achieve high DFT and uniform finish.
- Suggested Tip Size: 15-21 thou.
- Output fluid pressure: 1500-2000 psi.

Do not apply paint when temperature falls below 10°C or rises above 50°C and when humidity rises above 85%. Also do not apply during Rain, Fog or Mist.

Apply the paint in well ventilated area with suitable personal protective equipments.

SAFETY PRECAUTIONS :

- This product is to be used by professional applicators.

PACKING :

- Packing : As per Requirement

The information given in this literature sheet is, to the best of our knowledge, true and accurate. Their accuracy, completeness or appropriateness under the actual conditions of any intended use is not guaranteed. For further assistance please contact our technical dept.

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