

Quick application guide – Airless Spray

Resichem 506 Aluprime

- Solvent based epoxy primer
- Surface tolerant coating
- Capable of curing at temperatures as low as 5°C

Cure Times

At 20°C (68°F) the product will have the following cure times:

Usable life 2 hrs
Minimum overcoating 6 hrs
Maximum overcoating 36 hrs.
72 hrs when overcoating with 506 Aluprime or 508 UVPU.

Colour

Base component – Grey
Activator component – Amber

Over-coating times

Minimum - the material can be over-coated as soon as it is touch dry, approximately 6 hours at (20°C (68°F)).

Maximum - the over-coating time should not exceed 36 hours, unless overcoating with 506 Aluprime or 508 UVPU.

Technical specifications and characteristics

Mixing ratios	By weight	4 to 1
	By volume	3 to 1

Density	Base:	1.32
	Activator	1.03
	Mixed	1.25

Coverage Rates

The mixed product will give the following coverage rates -

4ltrs (1.05 US gallon) –
26.6m² at 150 microns
286ft² at 6mil

Typical applications

Primer for steel & concrete surfaces such as –
Structural steel
Stairways
Tank surfaces
External pipe surfaces
Marine decks

Surface Preparation

Metallic Substrates – Mechanical abrasion

1. All oil and grease must be removed from the surface using an appropriate cleaner such as MEK.
2. All surfaces must be mechanically abraded using handheld grinders to **ISO 8501/4 ST3 (SSPC SP3 ST3)**.
3. Once abraded, the surface must be degreased and cleaned using MEK or similar type material.
4. All surfaces must be coated before gingering or oxidation occurs

Metallic Substrates – Hydro-blasting

1. All surfaces must be hydro-blasted using clean water at 12,000 psi (850bar) to **NACE 5 (SSPC SP13 WJ3-WJ1)**.
2. All surfaces must be coated before gingering or oxidation occurs

Metallic Substrates – Abrasive blast cleaning

1. All oil and grease must be removed from the surface using an appropriate cleaner such as MEK.
2. All surfaces must be abrasive blasted to **ISO 8501/4 Standard SA2.5 (SSPC SP10/ NACE 2)** minimum blast profile of 75 microns (3mil) using an angular abrasive.
3. Once blast cleaned, the surface must be degreased using MEK or similar type material.
4. All surfaces must be coated before gingering or oxidation occurs.

Mixing and Application

STEP 1

Ensure you have 1 x base unit, 1 x activator unit, 1 x spatula and slow speed drill and paddle mixer, 1 x Graco x60 king pump with 15-19 thou tip sizes, MEK for cleaning



STEP 2

Pour the entire contents of the activator container into the base container.



STEP 3

Mix thoroughly, taking care to ensure any unmixed base component is scraped down from the edges of the container using a spatula. Continue mixing until a streak free, uniform material is achieved.



STEP 4

Where required, stripe coat, by Brush, edges, corners, and all areas inaccessible to spraying with 150 microns wft Aluprime 506.



STEP 5

Feed mixed material into Suitable single leg airless Spray Unit. Unit should be fitted with 1/4" or 3/8" hoses and 15-19 thou tip size. Typical spray pressure is 2,500-3,500 psi (170-200Bar). Spray to 100 microns wft.



STEP 6

On completion, clean unit out With MEK or other suitable thinner

