



# SIPRIME 219

## Fast Drying Shop Primer

Product No. 6219

### Features

- Excellent weld through shop primer
- Dry to recoat in minutes
- Good thin film corrosion protection
- Wide compatibility with variety of top-coats
- Long pot life and overcoatability
- Easy spray application
- **Excellent adhesion to aluminium or polyester fabrications**

### Recommended Use

- A holding primer for blasted subassemblies or steel fabrications
- A "tie coat" or "zinc seal" over inorganic zinc primer
- A conventional epoxy primer

### Physical Data

<b>Finish</b>	: Flat
<b>Colour</b>	: Oxide Red / Grey / Yellow
<b>Volume Solids</b>	: 28%
<b>Recommended Film Thickness :</b> 20 microns dry = 71 microns wet	
<b>Theoretical Coverage:</b> 14 m <sup>2</sup> /ltr. At 20 microns	

<b>Density (mixed)</b>	: 1.10 kg/ltr.
<b>Drying and Recoating Times</b> <b>(25°C / 65% RH):</b>	
Dry to Recoat	: 5 Minutes
Hard Dry	: 3 Hours
Maximum Recoatability	: No Limit
<b>Heat Resistant</b>	: 150°C
<b>Flash Point</b>	: 4°C

### Specification Data

#### Preparation

##### Steel Surfaces:

To obtain maximum protection, blast cleaning, grinding or phosphating is recommended. The substrate should be thoroughly cleaned in accordance with SSPC-SP1. All burs should be removed and sharp edges or rough welded seams should be ground down.

##### Aluminium and Galvanized Surfaces

New surfaces must be free of grease, oil, moisture and any other contaminants. A light blast cleaning or abrasive blasting after degreasing it the ideal surface preparation prior to coating. Old surfaces require cleaning with SIPCLEAN 615 cleaner followed by high pressure water rinse.

## Application Data

<b>Mixing Ratio by Volume</b>	Base : 1 part Hardener : 1 part
<b>Mixing Advice</b>	The paint is a one is to one mixture of base and hardener portion. Pour the complete contents of both the base and hardener portions into a suitable container. Mix together preferably with a power mixer, until completely homogeneous. The mix paint must be applied within 24 hours.
<b>Thinning</b>	No thinning is required.
<b>Pot Life</b>	8 hours at 25°C.
<b>Induction Time</b>	Allow 20 minutes induction before application.
<b>Application Details</b>	SIPRIME 219 can be applied by both conventional air spray and airless spray equipment. For air spray application, use a fluid tip of 0.070" to 0.086". Where airless spray equipment used, a 30 to 1 pump and 0.015" to 0.019" tip size will provide a good spray pattern. Ideally fluid hoses should not be less than 3/8" ID and not longer than 50 feet, not including short 1/4" ID whips. For touch-up work, SIPRIME 219 can be applied by brush or roller.
<b>Cleaning of Equipment</b>	Use Thinner 740.

## Storage Information

<b>Pack Size</b>	5 and 10 ltr. two component kits.
<b>Storage</b>	Store generally in original sealed container, indoors, at a temperature between 5 and 40°C and relative humidity below 70%.
<b>Shelf Life</b>	1 Year

## Safety Information

See the material safety data sheet and product label for complete safety and precaution requirements.

## Disclaimer

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