

SIPKYD REDOX 415

Quick Drying PEB Steel Primer

Product No. 6415

Features

- Modified alkyd based one pack steel primer
- Quick Drying
- Easy to apply
- Weldable
- Very good protection
- Suitable for spray and dipping applications

Recommended Use

- As a prefabrication primer or a fast to recoat field primer on exterior & interior steel in mild to moderate corrosive, industrial & marine environment.
- Can be applied by manual or automatic operated airless or conventional spray equipment.
- As a weldable primer up to a dry film thickness of 25 microns without adverse effect on the quality of the weld.

Physical Data

Finish : Flat

Colour : Red Brown / Aluminium

Volume Solids : 38%

Recommended Film Thickness:
35 - 50 microns dry = 92 – 132 microns wet

Theoretical Coverage:
10.86 m²/ltr. at 35 microns

Density : 1.24 kg/ltr.

Drying and Recoating Times (25°C/65% RH):

Dust Free : 3-4 Minutes
Dry to Handle : 7-9 Minutes
Minimum Recoating Time : 25 Minutes
Maximum Recoating Time : No Limit

Heat Resistant : 90°C Dry

Flash Point : 27°C

Specification Data

Preparation

New Steel

To obtain maximum protection, sand blasting, 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.

Sand, Garnet, dry shot or grit blasting is recommended. The required standard of cleanliness being in accordance with Swedish Standard SA 2.5 or SSPC-SP-10.

All blasting equipment should be of an approved type and fitted with suitable moisture trap and grease / oil filters.

Machinery Steel

Can be applied directly on machinery steel & iron after degreasing & mechanical cleaning.

Paint System

Subsequent coats must be of alkyd type only. Not suitable for immersion service.

Application Data

Thinning	Thinner 730 depending upon ambient temperature and application.
Application Conditions	Application temperature: 5 - 50°C. The minimum temperature required for satisfactory drying is 5°C. The surface temperature must be at least 3°C above the dew point to prevent condensation. Never apply paint under adverse weather conditions.
Mixing Advise	Prior to application, mix paint thoroughly to obtain an homogeneous product. Use a mixer for this which is powered by air or a flameproof electric motor.

Application Methods and Details

	<u>Airless Spray</u>	<u>Conventional Spray</u>	<u>Dipping</u>
Recommended thinner	Type 730	Thinner 730	Thinner 730
Thinner Addition	0 - 5 vol.%.	0 - 5 vol.%	5 - 10%
Nozzle Orifice	0.38 mm = 0.015"	1.5 - 2 mm	-----
Working Pressure	120 - 140 bar	2 - 3 bar	-----

No thinning required for brush / roller applications.

The recommended method of application is by dipping and airless spray or conventional spray. However, brush, roller may be used for isolated areas only. The spray fan should be adjusted depending on the nature and shape of the substrate to be painted in order that overspray can be restricted to a minimum.

Cleaning of Equipment Use Thinner 730.

Storage Information

Pack Size	20 and 200 ltr. drums (Single component material)
Storage	Store generally in original sealed container, indoors, at a temperature between 5 and 40°C and relative humidity below 70%.
Shelf Life	1 Year

Safety Information

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

Disclaimer

The information in this data sheet represent test results or experience under well defined conditions. Its accuracy or suitability under the actual conditions of any intended use is not guaranteed and must be determined by the user. All advice given about this product is given in good faith. Since as we have no control over conditions of substrate and application, manufacturer and seller can not accept any liability in connection with the use of the product relative to coverage, performance, injury or damage, unless we specifically agree in writing to do so. The information in this data sheet is subject to change without notice and it is the user's responsibility to ensure it is current. For further information and advice contact SPCO Technical Services Department on Tel. (03) 847 2299, Fax (03) 847 3780.