

# SIPKYD SHOPRIME 421

Zinc Phosphate Shop Primer

Product No. 6421

## Features

- Modified short oil alkyd based
- Anticorrosive zinc phosphate / red oxide primer
- Fast drying
- Weldable primer

## Recommended Use

- As a prefabrication primer or a fast to recoat field primer on degreased or blast cleaned structural steel.
- Can be applied by manual or automatic operated airless or conventional spray equipment.
- As a weldable primer up to a dry film thickness of 30  $\mu$  without adverse effect on the quality of the weld

## Physical Data

**Finish** : Flat

**Colour** : Red Brown, Grey

**Volume Solids** : 45%

**Recommended Film Thickness:**  
30 microns dry = 67 microns wet

**Theoretical Coverage :**  
15 m<sup>2</sup>/ltr. at 30 microns

**Density** : 1.4 kg/ltr.

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

Tack Free : 10 Minutes

Recoatable : 06 Hours

**Heat Resistant** : 120°C

**Flash Point** : 27°C

## Specification Data

### Preparation

The substrate should be thoroughly cleaned in accordance with SSPC-SP1. All burs should be removed and sharp edges or rough welds seams should be ground down.

New cold rolled steel and steel free from mill scale and rust can be coated after this surface treatment.

For steel with mill scale and rust dry shot or grit blasting is recommended, the required standard of cleanness being in accordance with ISO (1508501) SA 2.5 or SSPC-SP10.

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

### Paint System

SIPKYD Shoprime 421 is designed for application on clean steel surfaces.

Subsequent coats must be of alkyd type only.

## Application Data

### Application Details

Prior to application, mix paint thoroughly to obtain a homogenous product. Use a mixer which is powered by either an air driven or a flame proofed electric motor.

Application below 4°C (39°F) or where the relative humidity is over 85% should be avoided.

Do not apply coating if difference between surface temperature and dew point is less than 4°C or 7°F.

### Spray Data

Airless Spray : Nozzle orifice : 0.015" Out put pressure 120 - 140 bar.  
Air Spray : Nozzle orifice : 1.5 - 2 mm. Out put pressure 2 - 3 bar.

### Thinning

Airless Spray : Type 730 thinner approx. 15% vol.  
Air Spray : Type 730 thinner approx. 20% vol.  
Brush / Roller : Type 730 thinner approx. 15% vol.

### Cleaning of Equipment

Use Thinner 730.

## Storage Information

### Pack Size

5 and 20 ltr. cans.

### 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

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