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|--|---|---|-------------------|------------------|-----------------------|
| <b>Product Description</b>                   | One package, iron red or light yellow.  |   |                   |                  |                       |
| <b>Intended Uses</b>                         | Epoxy iron red ester primer is suited for ferrous metal surface, and the light yellow version is suited for aluminium and aluminium –magnesium alloy. The film can match with etching primer which will improve adhesion between different layers, as well as improve the film's salt fog resistance. |   |                   |                  |                       |
| <b>Product Information</b>                   | Volume Solids   | 56%   |                   |                  |                       |
|  | Dry Film Thickness  | 40 microns equivalent to 87microns of wet film                |                   |                  |                       |
|  | Theoretical Coverage  | 10.3 m <sup>2</sup> /kg                                       |                   |                  |                       |
|  | Practical Coverage  | Allow to appropriate loss factors                             |                   |                  |                       |
|  | VOC   | 381 g/L   |                   |                  |                       |
| <b>Application Details</b>                   | Mix ratio   | One package   |                   |                  |                       |
|  | Airless Spray   | Recommended: Tip range: 0.43-0.53mm. Fluid pressure: ≥17.6MPa |                   |                  |                       |
|  | Brush or Roller   | Recommended   |                   |                  |                       |
|  | Conventional Spray  | Suitable, But not recommended.                                |                   |                  |                       |
|  | Thinner   | OUP 103, Suggest adding 3%~5%.                                |                   |                  |                       |
|  | Cleaner   | OUP 103   |                   |                  |                       |
|  | Pot Life  | No limited  |                   |                  |                       |
|  | Drying Time   | Substrate Temperature   | Touch Dry (hours) | Hard Dry (hours) | Over coating Interval |
|  |   |   |                   | Minimum          | Maximum               |
|  | 5℃  | 2   | 30                | 30 hours         | No limited            |
|  | 23℃   | 1   | 18                | 18 hours         | No limited            |
|  | 35℃   | 0.5   | 12                | 12 hours         | No limited            |
| <b>Storage and Packing</b>                   | Storage   | Store in cool and dry conditions                              |                   |                  |                       |
|  | Storage Life  | One year  |                   |                  |                       |
|  | Pack Size   | 20 Kg in 20 litre container                                   |                   |                  |                       |
|  | Flash Point   | 30℃   |                   |                  |                       |
|  | Specific Gravity  | Approx 1.3-1.4 Kg/L   |                   |                  |                       |
| <b>Specification and Surface Preparation</b> | The steel surface: Blast cleaned to ISO 8501:2007 Sa2.5 or be rust-removed manually or with power tool to St3, and should be clean and dry.   |   |                   |                  |                       |
| <b>Limitations</b>                           | Recommended coat: Spray two coats with high-pressure airless spray and dry film thickness should be reach 80µm.<br>Subsequent coat: Epoxy resin paint, chlorinated rubber paint, alkyd resin paint, chorosulphonated polyethylene paint etc.  |   |                   |                  |                       |

## Safety Precautions for Solvent Paint

This product should be used in painting area by professional operators. When painting, please refer to Product Data Sheet and MSDS. Consult our company if consumers could not completely understand the precautions for safety and health when applying this product.

This product is a kind of solvent-based paint. In order to avoid danger or accident, minimal safety precautions, as follow, should be done:

The paint contains volatile solvent and is flammable. So must keep away from sparks and open flames. No smoking at application site. Effective precautions (such as using explosion-proof electrical equipments, no static electricity accumulation or metal collision etc) also should be done so as to avoid producing sparks. Flash point of paint, mentioned above on Product Data Sheet, is the lowest temperature at which mixture of the volatile materials of paint can ignite or explode with air, so we suggest painting should be stopped above the temperature of flash point.

Enough ventilation is necessary at application site. In order to remove any danger of explosion, must keep the ratio of gas to air is less than 10%, the minimum explosive limit in general. Therefore, 200m<sup>3</sup> of ventilation quantity per 1Kg solvent (according to the solvent) is necessary.

Protect skin and eyes, and avoid touching with paints (Recommend to wear working clothes, gloves, eye protection, face masks, barrier creams and so on). If paint gets in touch with skin, wash fully with a large amount of fresh water and soap or appropriate commercial cleaner. In case of eyes being contaminated, rinse with fresh water for 10min at least and give medical treatment immediately.

Recommend face guard with ventilation pipe for the sake of no absorption of paint fog and harmful solvent gas, especially in badly ventilated conditions.

Handle empty containers with care and do not bring about environmental contamination.

NOTICE: If consumers haven't taken effective safety precautions (Refer to the specifications), our company will NOT be responsible for any accident.

The purpose of the data sheet is to advise you. We can accept no liability for the results obtained during use, due to the variety of applications and the different substrates involved. The publication of the data sheet invalidates all previous data sheets for the product.