



A lead free alkyd based quick drying primer containing zinc phosphate.

Recommended use	General purpose primer on well cleaned steel surface in mildly to moderately corrosive atmosphere, interior and exterior, including coastal and marine environments. Not suitable for permanent immersion service.
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Physical Properties

Finish and Color	Flat. Green (4433), Red (2272), Grey For application where light color topcoats are used or only one topcoat application is specified, use gray to facilitate better hiding from the topcoat.					
Specific gravity	Approx. 1.3					
Solids by volume	Approx. 48 % (Determined by ISO 3233)					
Spreading rate (Theoretical)	9.6 m ² /L in 50 μm dry film thickness on a smooth surface.					
Flash point	35 °C/96 °F (Closed cup)					
Chemical Resistance		Acids	Alkalis	Solvents	Salts	Water
	Splash & Spillage	NR	NR	NR	Good	Excellent
	Fumes	Poor	Poor	Poor	Fair	Excellent
	Immersion	NR	NR	NR	NR	NR
* NR : Not Recommended						

Application details

Surface preparation	Remove any oil, grease, dirt and any other contaminants from the surface before painting by proper method such as solvent cleaning and fresh water washing, etc. * Steel : Blast cleaning to Sa 2.5 or Power tool cleaning to St3, St2, etc.			
Method of application	Spray (Airless or Air), Roller or Brush application. For airless spray application : Nozzle orifice : 432 μm ~ 584 μm (0.017" ~ 0.023") Output pressure : 14.5 MPa Fan : 60 ° (Airless spray data are indicative and subject to adjustment)			
Thinning	For spray application : Thinner No. 002 For brush and roller application : Thinner No. 002			
Application conditions	The surface should be completely cleaned and dried. Do not apply when relative humidity is above 85 %. The surface temperature should be at least 2.7°C (5 °F) above dew point to prevent condensation. In confined, areas, ventilate with clean air during application and drying to assist solvent evaporation.			
Film thickness	40 μm dry. Depending on the purpose and the area of use, different film thickness may be applied.			
Drying time	Substrate temperature	5 °C/41 °F	20 °C/68 °F	30 °C/86 °F

Set to touch	6 h	2 h	1 h
Dry through	12 h	4 h	3 h

* The actual drying time is subject to the film thickness, ventilation, humidity etc.,
and drying time under other temperature conditions should be checked and informed by KCC.

Subsequent Coat	Koramel Enamel LT313, or according to specification.
Recoating interval	At 20 °C/68 °F, Minimum : 8 h Maximum : Free Before overcoating, remove the oil, salt, chalking material and any other contaminants on aged coating film completely by proper cleaning method such as solvent cleaning and/or fresh water washing.
Heat resistance temperature	Continuous : 93 °C/200 °F (Non-immersion service) Non-continuous : 121 °C/250 °F (Non-immersion service)

Storage and package

Shelf life	12 months
Packing Unit	4L, 18 L, 20 L

Remarks

Handling Precautions	Protect skin and eyes from direct contact with liquid paint, and avoid prolonged breathing of solvent vapors. Use with adequate ventilation. Respiratory protection is recommended during application in confined spaces or stagnant air. Keep away from sparks and open flames.
Note	
1'st issue	2009-04-01
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Disclaimer : The information in this data sheet is believed to the best of our knowledge based on laboratory test and practical experience. However, there are many factors affecting the performance of product and the product quality itself, so we are not able to guarantee without the confirmation of the purpose of using the product from us in writing. We reserve the right to change the data without notice and you should check that this data sheet is current prior to using the product.

