

Technical Data Sheet

Description

7I.2.70121 is a 1K, phenolic alkyd primer with built in corrosion resistance and excellent adhesion onto properly prepared hot or cold roll steel, fiberglass and over properly prepared painted surfaces.

Suggested Uses

As a non sand or primer surfacer.

Over hot roll or cold roll steel fiberglass and sanded 2K coatings where:

- High level of corrosion resistance is needed.
- Excellent adhesion is needed.
- High productivity is required.
- Excellent performance when applied with airless, air-assist airless, airless, pressure pot, cup gun, brush or rolled.

Components

7I.2.70121

OG.002

OG.005

Base

Standard Nitro Reducer

Quick drying synthetic Reducer

Field Applications

- Structural steel
- Work panel trucks
- Trailers and frames
- Construction equipment
- Many OEM applications
- Oil Field Equipment

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71.2.70121

1K Gray DTM Primer

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Mixing Ratio

Mix

71.2.70121 Nitro Resistant Phenolic Alkyd primer comes ready for use, but can be reduced 25% with selected reducer.

Application

Apply:

One to two medium wet coats, allow 5-10 minutes flash between coats.

Spray Gun:

HVLP Gravity Feed – 1.6 – 1.8mm tip and needle
Pressure Pot HVLP – 1.0 – 1.2mm tip and needle
Air Assist Airless - 1.0 – 1.2mm tip and needle
Conventional – 1.5 – 1.8mm tip and needle
Airless - 310 – 610 – 313 – 613 nozzle
Brush or roller for small surfaces

Film Build:

60-80 microns

Dry Times

Dust Free:

15-20 minutes @ 20° C (68° F)

Dry to Touch

40-60 minutes @ 20° C (68° F)

Total Hardness

24 hours @ 20° C (68° F)

Force Dry

30 minutes @ 60° C (140° F) light sanding needed.

Surface Preparation

Ferrous metals:

Best Case

SA2 sandblast Blow all dust and contaminates off and apply primer within 8 hours.

Second Best Case

Hot Phosphate wash system, blow dry and apply 71.2.70121 primer within 8 hours.

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Third Best Case

Careful mechanical abrasion. Clean all dust, oil residue, finger prints and contaminants before and after mechanical abrasion with a clean drying wax and grease removal solvent making sure all residue is removed then apply 7I.2.70121 primer within 4 hours.

Aluminum:

Clean surface with clean drying wax and grease remover. apply 2I.3.70121 Epoxy Primer, over coat with 7I.2.70121 within 4 hours as per directions.

Galvanized Steel:

Clean all dust, oil residue, and contaminants from surface using a Clean drying wax and grease remover. Light Sanding (320P grit) Clean again with clean drying wax and grease remover using a wipe and dry process. Globalstar 2I.3.70121 Epoxy Primer, followed by 7I.2.70121 primer as required.

VOC

Ready for Use VOC

540 g/l

Solids

By Volume

48% (+ or - 2%)

By Weight

68% (+ or - 2%)

Specific Gravity

1.42 kg/l

Coverage

6-8 m²/kg

Repainting

After a minimum of 4 Hrs for 2K topcoat systems.
After a minimum of 2 hour for 1K topcoat systems
After 7 days @ 20° C (68° F) or force drying light sanding needed.

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Storage Stability

One year, stored in closed package, in cool dry place, away
From any sources of heat.

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