



Rev. 1 10/2017

FEATURES

: Metal Primer is anti-corrosive primer which base on special alkyd resin and iron oxide pigment. It is characterized with quick drying ,good flow and strong adhesion for metal substrate.

: It is suitable for application to a wide range of exterior and interior steel structure (above water area) and combination with alkyd system.

TECHNICAL INFORMATION

Type : Alkyd Paint
 Color : Red-Brown
 Film appearance : Matt
 Specific gravity : 1.45 ± 0.05
 Solid by volume : 55 ± 2 %
 Flash point : 32 °C

		Minimum	Maximum	Recommended
Dry film thickness	(Microns)	30	50	40
Wet film thickness	(Microns)	55	91	73
Theoretical coverage.	m ² / Liter	18.3	11.0	13.8
	m ² / Gallon	69.4	41.6	52.0
Practical coverage.	m ² / Liter	16.5	10.0	12.4
	m ² / Gallon	62.5	37.5	46.8

Remark : Actual Surface coverage will depend on surface irregularities, Mixing, Application Condition method and technique; as well as the structure and dimensions of the object to be coated.

	Temperature	25 °C	30 °C	35 °C
Touch dry	Surface dry	1 hr.	40 mins	20 mins
	Hard dry	8 hrs.	6 hrs.	4 hrs.
Full cure	Minimum	8 hrs.	6 hrs.	4 hrs.
	Maximum	-	-	-

Potlife

Remark : Drying times are generally related to air circulation, temperature, film thickness and number of coats, and will be affected correspondingly.

APPLICATION

	Mixing Ratio	Part A	Part B	
	By Volume	1	-	
	By Weight	1	-	
Application Method		Airless Spray	Air Spray	Brush / Roller
Diluted by TOA Thinner 12		5-10	15-20	10-15
Applicator		Graco 519 Graco 521	Coventional Spray (Iwata)	Short Hair Stiff Nylon Roller (Stanley) Stiff Nylon Brush
Pressure		110-140 kg/cm ²	3-4 kg/cm ²	-



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Mix Part A and Part B, strictly follow mix ratio recommendations before dilute by Thinner mixing and stir for 2-3 minutes until the mixture is homogeneous after leave 5 minutes before application.

APPLICATION SYSTEM

Surface Preparation

Steel

Remove all oil, grease, dirt, oxide and other foreign material.

High Quality

: Should be blast cleaned in accordance with NACE No.2 / SSPC-SP10 / ISO 8501:1 / SIS Sa 2.5 to a near-white finish using a suitable abrasive.

Medium Quality

: Treatment by using Power tool cleaning in accordance with SIS St 3 or SSPC-SP3 .

Remark : The surface must be thoroughly dry and apply the protective coating within 4 hours to cleaned surface.

Before Recoat by Topcoat

: Remove all oil, grease, dirt, oxide and other foreign material by cleaning per SSPC-SP1, Solvent Cleaning before coating.

: If over 7 days gives cleaning surface by sand paper no. 320-400 and cleaning surface per SSPC-SP1, Solvent Cleaning before coating.

Coating System

Protective Coating

: Primer	Metal Primer	40 microns x 2 coats
: Topcoat	TOA High Gloss Enamel	40 microns x 2 coats

Recommendation

: The proper relative humidity in the work shall not exceed 85% RH.

: The temperature of the substrate should be minimum 10 °C and at least 3 °C above the dew point of the air, temperature and relative humidity measured in the vicinity of the substrate for prevent moisture and water drop on substrate effective adhesion and drying time.

HANDLING AND STORAGE

Storage condition

: The product must be stored in accordance with national regulations. Storage conditions are to keep the containers in a dry, cool, well ventilated space and away from source of heat and ignition.

Shelf life

: 24 months at 30-35 °C

: The product must be stored in accordance with national regulations. Storage conditions are to keep the containers in a dry, cool, well ventilated space and away from source of heat and ignition.

Containers must be kept tightly closed.

Package

Packaging size

1 Gallon Set	1 Gallon
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HEALTH AND SAFETY

: Please observe the precautionary notices displayed on the container. Use under well ventilated conditions. Do not breathe or inhale mist. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water and medical attention sought immediately.

: For detailed information on the health and safety hazards and precautions for use of this product, we refer to the Safety Data Sheet.

**DISCLAIMER**

: The information in this data sheet is given to the best of our knowledge based on laboratory testing and practical experience. However, as the product is often used under conditions beyond our control, we cannot guarantee anything only the quality of the product itself. We reserve the right to change the given data without notice.