

Application Instructions

ACTIVE RUST PRIMER 662 SG

Active Rust Primer 662 SG is a surface-tolerant coating with special properties as a repair primer. Applied on rusty steel surfaces, the primer penetrates and reacts chemically with solubilised ferric ion as well as with Fe in the rust layer, forming an extremely stable insoluble complex compound with Fe. The primer may also be applied directly to bare steel and can be applied to most types of primers and existing coating systems.

It may well be applied over damp substrates. Surface must be free from water droplets. Use rags, towels or other cloth/paper material to remove water droplets on surface. Refer to the Product Data Sheet for detailed properties and uses.

Surface Preparation

Remove all thick rust scale, loose rust, dirt, oil, grease and other contaminants from the surface. Use power or hand tools to clean in accordance with St 1 - 3. Flush prepared area with plenty of fresh water to reduce salt crystals and contaminants. Cleaned, brown tightly-adhering steel rust may be overcoated with the primer.

Use of a high-pressure waterjet is excellent. Minimum pressure 500 - 600 bar, depending on the surface condition. Detergents can be used. Always flush with fresh water after detergents or other degreasing agents have been used. Do not use inhibitors.

Surface steel profiles: a semi-polished surface is acceptable. If using an abrasive blast (or equivalent) use the finest abrasive grade available and work at an angle of 30 - 45 degrees. Active Rust Primer 662 SG will adhere to a near-polished surface. Unlike most coatings it does not depend on a substrate's "anchoring".

Environmental Conditions

Air temperature + 5°C to 40°C
Steel temperature + 5°C to 50°C
Steel temperature must be at least +1°C above dewpoint.
RH can be up to 95 %.

Application Equipment

The primer may be applied with conventional or airless spray equipment, brush or roller.

Airless spray:	nozzle	0.015" - 0.018"
	angle	50° - 65°
	air pressure	3.5 - 4 kp/cm ²

Ensure good ventilation when applied in confined areas to assist evaporation and curing.

Application Procedure

Active Rust Primer 662 SG is a stable liquid and needs no stirring before use. Just turn the drum upside down and rock back and forth 8 - 10 times before opening. The primer is single-component - no mixing required. Do not dilute and never use thinner.

Before use pour into non-metallic container. Never pour unused portion back or dip brush directly into original container. The drum may be opened and closed. Potlife time: 12 months after opening.

1. Flush equipment with fresh water before use.
2. Work primer well into surface while wet. It dries quickly, so do not rework after the drying process has started. Stripe coat all welds, rough spots, sharp edges and corners, etc. Apply a wet coat in even, parallel passes. Overlap each pass 50 % to avoid bare areas, pinholes and holidays.
3. Recommended application is 2 coats of approx. 50 - 60 microns each. Allowable range is 20 - 150 microns. Do not recoat before it has dried at least 1 hour. The application of a wetfilm thickness of 100 - 125 microns will normally provide 50 - 60 microns.
4. Repair larger areas with spray. Do not overspray. Work can be interrupted with no deterioration in quality.
5. Touch up random pinholes, holidays, small damages or bare areas by brush when film is dry to handle.
6. Clean all equipment immediately after use with water.

Inside tanks, leave 48 - 72 hours or longer to cure before applying topcoat.

Safety

Active Rust Primer 662 SG does not contain any organic solvents and therefore does not present the dangers which are normally related to solvents. It is non toxic and non-flammable, classified non-hazardous. If used in confined areas, maintain adequate ventilation and sufficient fresh air during application and drying. Dust mask is sufficient when exposed to mist. Further details - See Safety Data Sheet.