

# 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. Pressure 200 - 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 <sup>2</sup>

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.

# Product Data Sheet

## ACTIVE RUST PRIMER 662 SG

- highly surface-tolerant repair primer
- perfect on power tool-cleaned or waterjetted steel surfaces
- penetrates and wets surface to full adhesion
- adheres to near-polished, shiny metal surface
- enhanced tolerance of moisture and salts
- converts and seals tightly-adhering rust
- quick drying
- environmentle - non-flammable - non toxic
- low in VOCs - single-component

### Typical Uses

Designed as a rust-inhibiting acrylic primer and converter for marine environments. For use under dry or damp conditions on steel structures difficult to prepare to traditional standards. Active Rust Primer 662 SG is specially formulated for ballast tanks, cofferdams and other voids, superstructures and decks and general maintenance.

### Outstanding Characteristics

The extraordinary wetting, penetrating and converting properties provide a means of reinforcing and neutralizing surface rust - this in turn insures the adhesion of subsequent coatings. Active Rust Primer 662 SG provides excellent adhesion to a wide variety of substrates. No surface anchor profiles are required for complete adhesion. The primer is hard but flexible. It has excellent application characteristics and can be applied using conventional or airless spray equipment, brush or roller.

### Topcoatings

Can be overcoated with any marine coating, whether epoxy, acryl, alkyd, chlorinated rubber, vinyl or polyurethane coatings etc., from all leading coatings suppliers.

### Recommended film thickness - Coverage

Dryfilm:	40 - 60 microns (wetfilm: 80 - 130 micr.)
Coverage:	12.5 - 7.7 m <sup>2</sup> /ltr
Practical coverage:	10 - 6 m <sup>2</sup> /ltr

### Drying Times

Touch dry:	15 min. at 23°C
Hard dry:	1 - 3 hours
Dry to recoat:	1 - 3 hours inside tanks: 12 - 24 hours no limited max. time
Curing time:	12 - 24 hours inside tanks: 48 - 72 hours
Dry for topcoat:	apply after curing time no limited max. time

Number of coats:	1 - 3
Min. air/steel temperature applying:	+ 5°C
RH:	up to 95 %

### Physical Data

Colour:	brownish liquid. Mild odour. Curing into black/silver grey neutralized insoluble compound. Transparent on existing paint.
Finish:	semi gloss
Volume solids:	44 %
Specific gravity:	1.05 kg/ltr
Flash point:	N/A
VOC:	15 g/ltr
Solubility:	100 % soluble
Thinner:	no
Dilute:	no
Clean up:	water

### Storing - Transport

Shelf life:	24 months
Temperature:	+ 5°C to 40°C

**Keep away from direct sunlight and do not expose to temperatures below 0°C.**

**No transport restrictions, easy to move by plane, truck or vessel.**

Packaging:	24 ltr drums ( 25 kg )
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### Safety - Environments

**Classified non-hazardous - See Safety Data Sheet**