

## Resichem 506 Aluprime

- Solvent based epoxy primer
- Surface tolerant coating
- Capable of curing at temperatures as low as 5°C

### Cure Times

At 20°C (68°F) the product will have the following cure times:

<b>Usable life</b>	2 hrs
<b>Minimum overcoating</b>	6 hrs
<b>Maximum overcoating</b>	36 hrs.
	72 hrs when overcoated with 506 Aluprime or 508 UVPU

### Coverage Rates

The mixed product will give the following coverage rates -

5ltrs (1.3 US gallon) –
33.3m <sup>2</sup> at 150 microns
358ft <sup>2</sup> at 6mil

### Colour

Base component – Grey  
Activator component – Amber

### Over-coating times

Minimum - the material can be over-coated as soon as it is touch dry, approximately 6 hours at (20°C (68°F)).

Maximum - the over-coating time should not exceed 36 hours unless overcoating with itself or 508 UVPU.

### Typical applications

Primer for steel & concrete surfaces such as –  
Structural steel  
Stairways  
Tank surfaces  
External pipe surfaces  
Marine decks

### Technical specifications and characteristics

<b>Mixing ratios</b>	By weight	4.5 to 1
	By volume	4 to 1
<b>Density</b>	Base:	1.15
	Activator	1.02
	Mixed	1.12

### Surface Preparation

Metallic Substrates – Mechanical abrasion

1. All oil and grease must be removed from the surface using an appropriate cleaner such as MEK.
2. All surfaces must be mechanically abraded using handheld grinders to **ISO 8501/4 ST3 (SSPC SP3 ST3)**.
3. Once abraded, the surface must be degreased and cleaned using MEK or similar type material.
4. All surfaces must be coated before gingering or oxidation occurs

Metallic Substrates – Hydro-blasting

1. All surfaces must be hydro-blasted using clean water at 12,000 psi (850bar) to **NACE 5 (SSPC SP13 WJ3-WJ1)**.
2. All surfaces must be coated before gingering or oxidation occurs

Metallic Substrates – Abrasive blast cleaning

1. All oil and grease must be removed from the surface using an appropriate cleaner such as MEK.
2. All surfaces must be abrasive blasted to **ISO 8501/4 Standard SA2.5 (SSPC SP10/ NACE 2)** minimum blast profile of 75 microns (3mil) using an angular abrasive.
3. Once blast cleaned, the surface must be degreased using MEK or similar type material.
4. All surfaces must be coated before gingering or oxidation occurs.

### Mixing and Application

#### STEP 1

Ensure you have 1 x base unit, 1 x activator unit, 1 x spatula and slow speed drill and paddle mixer



#### STEP 2

Pour the entire contents of the activator container into the base container.



#### STEP 3

Mix thoroughly, taking to care To ensure any unmixed base component is scraped down from the edges of the container using a spatula. Continue mixing until a streak free, uniform material is achieved.



#### STEP 4

Pour the mixed materials into A paint tray or paint kettle. Using a medium pile roller Apply the product to the Prepared surface at a wet film Thickness of 150 microns.

