



PRODUCT INFORMATION



Product Name:	RAPIDAC HIGH BUILD METAL PRIMERS
Reference Number:	13-Line
Coating Type:	Modified alkyd/zinc phosphate.
Typical Uses:	General purpose, high build, fast drying primers for steel.
Colours Available:	Red Oxide - ref: 13-90 Grey - ref: 13-91
Appearance Of Dried Film:	Low sheen.
Volume Solids:	40% (may vary with colour).
Dry Film Thickness:	Typical: 75 Microns.
Theoretical Coverage:	5.33m ² per litre at 75 microns.
Drying Time At 20°C: (Will Vary With Temperature, Air Movement etc.).	Touch Dry: 20 minutes. Firm Dry: 1 hour. Overcoat: See note 1&2 overleaf.
Packaging:	5 litre and 20 litre containers.
Shelf Life:	2 years or longer in unopened containers when stored under cover in good storage conditions.
Storage:	Under cover within temperature range of 5°C to 32°C.

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- Surface Preparation:** Preferred method is abrasive blast to ISO 8501-1 (SA2.5).
- Manual Clean:**
Chip, scrape and wire brush to remove all loose millscale, rust, etc. Degrease with Dacrylate Thinner R5.
- Application:** May be applied by conventional or airless spray. Up to 10% Dacrylate Thinner R5 may be added to obtain optimum spray characteristics.
- Apply to an approximate wet film thickness of approximately 190 microns to achieve 75 microns dry film thickness.
- Small areas and narrow sections can be brush applied. Apply with a full wet brush, do not attempt to 'brush out' or 'lay off'.
- Overcoating:**
- i) May be overcoated after 45 minutes or as soon as firm-dry with all white spirit based finishing coats (e.g. Dacrylate Vehicle and Machinery Enamels, QD2, Dacshield, etc)
SEE NOTE 2
 - ii) Fast-drying finishing coats based on stronger solvents (e.g Dacrylate QD3, QD1, etc.,) should be overcoated when primer is firm-dry **but within 2 hours**, or allow primer to dry overnight.
- Note:**
- (1) Overcoating and drying times will depend on ambient temperatures and especially ventilation, air movement, etc.
 - (2) If allowed to dry overnight the primer should ideally be abraded to improve intercoat adhesion of White Spirit based finishes.
- Clean-Up:** Dacrylate Thinner R5
- Health And Safety:** Please see relevant MSDS sheet.

Data sheets are issued to supply **general information** on the product but without warranty. Since conditions of service and application are beyond our control we cannot accept claims for loss, damage etc., based on this information. Dacrylate will not accept any claim for consequential or incidental damages.