

PRODUCT DESCRIPTION

Hi-Alkyd 1404 Red Oxide Primer is a one-pack, fast-drying alkyd primer pigmented with red iron oxide for protection of structural steel in mild industrial and commercial environments.

INTENDED USE

It is designed for use as an economical anti-corrosive primer on fabricated structures, equipment, machinery, pipes and other ferrous metal surfaces such as gates and fences.

GENERAL PROPERTIES

Colour	: Reddish Brown
Gloss Level	: Matt
Volume Solid	: 50 ± 2 %
Specific Gravity	: 1.39 ± 0.02 kg/l
Flash Point	: 43 °C
VOC	: 412 g/L (EPA Method 24)
Typical Thickness	: 25 – 50 µm dry film 50 – 100 µm wet film

SURFACE PREPARATION

All surfaces should be clean dry, and free from contamination. The surface should be assessed and treated in accordance with ISO 8504. Oil or grease should be removed in accordance with SSPC-SP1 solvent cleaning.

Abrasive Blast Cleaning

For optimum performance, abrasive blast clean to Sa 2½ (ISO 8501-1) or SSPC-SP10 with a surface profile of 25 – 50 microns (1 – 2 mils). If oxidation has occurred between the blasting and application of this product, the surface should be re-blasted to the specified visual standard. Surface defect revealed by the blast cleaning process should be ground, filled or treated in the appropriate manner.

Hand or Power Tool Cleaning

Hand or power tool clean to a minimum St2 (ISO 8501-1) or SSPC-SP2. Note, all scale must be removed and areas which cannot be prepared adequately by chipping or needle gun should be spot blasted to a minimum standard of Sa 2 (ISO 8501-1) or SSPC-SP6.

Damaged Area

Damage area should be prepared with abrasive blast cleaning to Sa 2½ (ISO 8501-1) or SSPC-SP10. When abrasive blasting is not possible, mechanical cleaning to St3 (ISO 8501-1) or SSPC-SP3 is acceptable. Hi-Alkyd 1404 should be applied over a surface that is dry and free from all contamination.

Other Surfaces

The coating may be used on other substrates. Please contact your local Nippon Paint office for more information.

CONDITION DURING APPLICATION

Avoid paint application when the temperature is below 10 °C and relative humidity is above 85 %. The temperature of steel surface must be minimum 3 °C above dew point of surrounding air.

APPLICATION GUIDE

Mixing Ratio	: Product should be mixed thoroughly before use with a mechanical agitator
Theoretical Coverage	: 20.0 m ² /litre at 25 µm DFT 10.0 m ² /litre at 50 µm DFT
Thinner	: Hi-Pon Alkyd Thinner
Cleaner	: Hi-Pon Alkyd Thinner

APPLICATION METHOD

Conventional air and airless spray are recommended for application. Brush and roller are recommended for stripe coating and small areas. Care must be taken to achieve the specified dry film thickness.

APPLICATION DETAILS

Airless Spray	: Tip Size	: 0.015" – 0.021"	
	: Pressure at nozzle	: 140 – 200 bar	
Drying Time	: Substrate Temperature	<u>25 °C</u>	<u>40 °C</u>
	: Surface Dry	25 mins	15 mins
	: Through Dry	5 hrs	3 hrs
	: Dry to Overcoat (min)	5 hrs	3 hrs
	: Dry to Overcoat (max)	Extended	

Remarks: Where an "extended" overcoating time is stated, consult Nippon Paint Protective Coatings for recommended surface preparation to achieve optimal intercoat adhesion.

The given data must be considered as guidelines only. The actual drying time/times before recoating may be shorter or longer, depending on film thickness, ventilation, humidity, underlying paint system, requirement for early handling and mechanical strength etc. A complete system can be described on a system sheet, where all parameters and special conditions could be included.

**RECOMMENDED
COATING SYSTEM**

The following coating systems are recommended for Hi-Alkyd 1404 Red Oxide Primer:

Top Coat:

- Hi-Alkyd 1501 Alkyd Top Coat
- Hi-Acryl 1901 Acrylic Top Coat

For the choice of coating system for different application, refer to the product brochure or contact Nippon Paint for professional recommendation.

PACKAGING

<u>Unit</u>	<u>Volume</u>	<u>Container Size</u>
20 L	20 L	20 L

STORAGE

Shelf Life : 12 months (25 °C)

Subject to re-inspection thereafter. Higher temperature during storage may reduce the shelf life and may lead to gelling in the tin. Frequent temperature cycles may also shorten the shelf life.

Store in tightly closed container in a dry, cool and well-ventilated space, keep away from sources of heat and ignition.

SAFETY PRECAUTION

- This product is intended for use of professional applicators. Refer to the safety information display on the container and in the safety data sheet (SDS) before using the product.
- Use this product in well-ventilated area, avoid skin contact, spillage on the skin should immediately be removed with suitable cleanser, soap and water.
- Eye should be well flush with water and seek for medical attention immediately upon contact with this product.
- During the application, naked flame, welding operation and smoking is not allowed. Adequate ventilation should be provided.
- If you have any doubt regarding the suitability of use, refer to Nippon Paint for further advice.

DISCLAIMER

The information in this data sheet is given to the best of Nippon Paint's knowledge and practical experience. Users may consult with Nippon Paint on the general suitability of the product for their needs and specific application practices though it remains each user's responsibility to determine the suitability of the product for the user's particular use. The condition of the substrate and application are not within Nippon Paint's control. Therefore, no implied conditions,

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