



# SIPRIME 215

## Poly-amide Epoxy Primer

Product No. 6215

### Features

- New high solid technology based on proven technology, long recoatability, outstanding adhesion and fast dry to recoat.
- Excellent holding primer.
- Outstanding aged recoatability
- Approvals :  
Meets specifications given in US Naval Ships' Technical Manual, Chapter 631, and Military Sealift Command Instructions 4750.2.

Approved under APCS-1B, 1E & 12.

### Recommended Use

- The SIPRIME 215 primer is a widely used as a general purpose exterior primer for high performance coating systems: Primer for steel, aluminium, galvanised metal or fibreglass, Ideal tie coat over inorganic zinc primers. Suitable for chlorinated rubber, solution vinyl, urethane, polyester and epoxy topcoats. Suitable primer for all kinds of steel fabrication, Recommended primer for hand cleaned touch-up and maintenance painting. Used on offshore structures, drill ships and support vessels.

### Physical Data

**Finish** : Semi-Gloss

**Colour** : Buff

**Volume Solids** : 62%

**Recommended Film Thickness** :  
50 -75 microns dry = 80 - 120 microns wet

25 -30 microns dry as a holding primer for heavy duty Epoxy Tank Lining System.

**Theoretical Coverage** :  
12 m<sup>2</sup>/ltr. at 50 microns

**Density (Mixed)** : 1.45 kg/ltr.

#### Drying and Recoating Times (25°C / 65% RH):

Dry to Recoat : 2 Hours

Hard Dry : 6 Hours

Maximum Recoatability : No Limit

**Heat Resistant** : 121°C dry

**Flash Point** : 27°C

### Specification Data

#### Preparation

##### Steel Surfaces

All surfaces must be free of oil, grease and moisture before blast cleaning to a near white metal Steel Structures Painting Council SP10 or ISO 8501-1, Sa 2.5.

Surface must be free of grit dust. Primer should be applied to cleaned surfaces as soon as possible to prevent re-rusting or contamination. For areas where sandblasting cannot be accomplished, hand clean, preferably with a power disc sander, to bright, non-polished metal.

##### Aluminium and Galvanised Surfaces

New surfaces must be free of grease, oil, moisture and dirt and treated with a mordant solution SIP-GALVTREAT 626 according to label directions. A light blast cleaning or abrasive blasting after degreasing is the ideal surface preparation prior to coating. Old surfaces require cleaning with SIPCLEAR 615 Cleaner followed by a high pressure water rinse.

## Application Data

<b>Mixing Ratio by Volume</b>	Base : 9 parts Hardener : 1 part
<b>Mixing Advice</b>	SIPRIME 215 is a two component product supplied in 20 ltr. or 5 ltr. Kits which contain the proper ratio of ingredients. The entire contents of each container must be mixed together. Power mix the base portion first to obtain a smooth, homogeneous condition. After mixing the base portion, add the hardener slowly with continued agitation. After adding all the hardener, continue to mix slowly for 15 minutes.
<b>Thinning</b>	Thinner 740 Thinning is not normally required or desired; however, at lower temperatures or in extreme conditions, small amounts (20% or less) of Thinner 740 can be added, any solvent addition should be made after the two components are thoroughly mixed.
<b>Pot Life</b>	12 hours at 25°C.
<b>Induction Time</b>	SIPRIME 215 requires a 15 minutes induction time at 25°C.
<b>Application Details</b>	SIPRIME 215 can be applied by both conventional air spray and airless spray equipment. For air spray application, use a fluid tip of .070" to .086". Where airless equipment is used, a 30 to 1 pump and .017" to .023" tip size will provide a good spray pattern. Ideally fluid hoses should not be less than 3/8" ID and not longer than 50 feet, not including short 1/4" ID whips. For touch-up work, SIPRIME 215 can be applied by brush or roller.
<b>Cleaning of Equipment</b>	Use Thinner 740.

## Storage Information

<b>Pack Size</b>	5 and 20 ltr. two component kits.
<b>Storage</b>	Store generally in original sealed container, indoors, at a temperature between 5 and 40°C and relative humidity below 70%.
<b>Shelf Life</b>	1 Year

## Safety Information

See the material safety data sheet and product label for complete safety and precaution requirements.

## Disclaimer

The information in this data sheet represent test results or experience under well defined conditions. Its accuracy or suitability under the actual conditions of any intended use is not guaranteed and must be determined by the user. All advice given about this product is given in good faith. Since as we have no control over conditions of substrate and application, manufacturer and seller can not accept any liability in connection with the use of the product relative to coverage, performance, injury or damage, unless we specifically agree in writing to do so. The information in this data sheet is subject to change without notice and it is the user's responsibility to ensure it is current. For further information and advice contact SIPCO Technical Services Department on Tel. (03) 847 2299, Fax (03) 847 3780.