



# SIPRIME 216

## Poly-amide Epoxy Primer

Product No. 6216

### Features

- Proven performance over many years, long recoatability, outstanding adhesion and fast dry to recoat.
- Approvals:  
Meets specifications given in US Naval Ships' Technical Manual, Chapter 631, Military Sealift Command Instructions 4750.2.

### Recommended Use

- The Siprime 216 Primer is a Widely used as a General Purpose Exterior Primer for High Performance Coating Systems: Primer for steel, aluminium, galvanised or fibreglass, Ideal tie coat over inorganic zinc primers, Suitable for chlorinated rubber, solution vinyl, urethane, polyester and epoxy topcoats, Excellent holding primer, Outstanding aged recoatability, 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** : 50%

**Recommended Film Thickness:**  
50 -75 microns dry = 100 - 150 microns wet

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

**Density (mixed)** : 1.32 kg/ltr.

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

Dry to Recoat : 1 Hour

Hard Dry : 6 Hours

Maximum Overcoatability : 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 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 rerusting or contamination. For areas where sandblasting cannot be accomplished, hand clean, preferably with 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 SIPCLEAN 615 Cleaner followed by a high pressure water rinse.

## Application Data

**Mixing Ratio by Volume**    Base        :        9 parts  
    Hardener    :        1 part

**Mixing Advice**                    SIPRIME 216 Primer 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 the hardener adds is complete, continue to mix slowly for 15 minutes.

**Thinning**                            Thinner 740  
 Thinning is not normally required or desired; however, at lower temperatures, small amounts (10% or less) of Thinner 740 can be added, any solvent addition should be made after the two components are thoroughly mixed.

**Pot Life**                             12 hours at 25°C.

**Induction Time**                    SIPRIME 216 requires a 15 minutes induction time at 25°C.

**Application Details**                SIPRIME 216 Primer 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 216 Primer can be applied by brush or roller.

**Cleaning of Equipment**        Use Thinner 740.

## Storage Information

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

## Safety Information

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

## Disclaimer

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