



SIPRIME 219

Fast Drying Shop Primer

Product No. 6219

Features

- Excellent weld through shop primer
- Dry to recoat in minutes
- Good thin film corrosion protection
- Wide compatibility with variety of top-coats
- Long pot life and overcoatability
- Easy spray application
- **Excellent adhesion to aluminium or polyester fabrications**

Recommended Use

- A holding primer for blasted subassemblies or steel fabrications
- A "tie coat" or "zinc seal" over inorganic zinc primer
- A conventional epoxy primer

Physical Data

Finish	: Flat
Colour	: Oxide Red / Grey / Yellow
Volume Solids	: 28%
Recommended Film Thickness : 20 microns dry = 71 microns wet	
Theoretical Coverage: 14 m ² /ltr. At 20 microns	

Density (mixed)	: 1.10 kg/ltr.
Drying and Recoating Times (25°C / 65% RH):	
Dry to Recoat	: 5 Minutes
Hard Dry	: 3 Hours
Maximum Recoatability	: No Limit
Heat Resistant	: 150°C
Flash Point	: 4°C

Specification Data

Preparation

Steel Surfaces:

To obtain maximum protection, blast cleaning, grinding or phosphating is recommended. The substrate should be thoroughly cleaned in accordance with SSPC-SP1. All burs should be removed and sharp edges or rough welded seams should be ground down.

Aluminium and Galvanized Surfaces

New surfaces must be free of grease, oil, moisture and any other contaminants. A light blast cleaning or abrasive blasting after degreasing it the ideal surface preparation prior to coating. Old surfaces require cleaning with SIPCLEAN 615 cleaner followed by high pressure water rinse.

Application Data

Mixing Ratio by Volume	Base : 1 part Hardener : 1 part
Mixing Advice	The paint is a one is to one mixture of base and hardener portion. Pour the complete contents of both the base and hardener portions into a suitable container. Mix together preferably with a power mixer, until completely homogeneous. The mix paint must be applied within 24 hours.
Thinning	No thinning is required.
Pot Life	8 hours at 25°C.
Induction Time	Allow 20 minutes induction before application.
Application Details	SIPRIME 219 can be applied by both conventional air spray and airless spray equipment. For air spray application, use a fluid tip of 0.070" to 0.086". Where airless spray equipment used, a 30 to 1 pump and 0.015" to 0.019" 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 219 can be applied by brush or roller.
Cleaning of Equipment	Use Thinner 740.

Storage Information

Pack Size	5 and 10 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

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 SPCO Technical Services Department on Tel. (03) 847 2299, Fax (03) 847 3780.