Technical Data

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SAFE STEP® Metal Primer

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Part Code: 43265
Pack Size: 0.75 Litre

Description

SAFE STEP® Metal Primer is a solvent based, 2 pack epoxy resin pigmented with zinc phosphate. It is designed for use as a high-performance primer for blast cleaned steel, aluminium and galvanising. It gives excellent corrosion protection in even the most extreme environments.

SAFE STEP® Metal Primer should be applied onto a suitably prepared surface prior to the application of the SAFE STEP® range of floor finishes to promote effective adhesion and corrosion protection between the substrate surface and the floor finish.

Technical Data (Typical)

Colour:	Grey
Pack Size:	0.75 litre
Useable Life When Mixed @ 20°C:	4 hours
Curing Times: Touch Dry: Hard Dry: Full Cure Time:	 2 hours @ 21°C 16 hours @ 21°C 7 days @ 21°C
Over-coating Time:	Minimum of 6 hours @ 20°C Maximum 3 months
Application Film Thickness	88-100µm wet film thickness 75-85µm nominal dry film thickness
Theoretical Coverage Per litre: This figure makes no allowance for substrate profile, porosity, uneven application or losses in containers or rollers/brushes. Soft Roller/Brush:	 $10m^2$ @ 100 microns wet film thickness
Shelf Life:	2 years
Flash Point:	36°C
Application Temperature:	Do not apply when relative humidity exceeds 90% Do not apply when ambient temperature is below 10°C
Storage Conditions:	5-30°C
EU limited valve for this product (Cat A/j):550g/l (2007) / 500g/l (2010)	This product contains max. 165g/l VOC
Volume Solids (BS3900 part A10):	85%
Density (Mixed) - BS3900A19	1.5 g/cm^3 (mixed)

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Mixing Ratio by Volume:	5 parts base component 1 part hardener component
Flammability:	Highly flammable
Cleaning Solvent:	Xylene

Surface Preparation

Steel: should be blast cleaned in accordance with SA 2.5 minimum. SA 3 is recommended for conditions of severe exposure. Oil and grease should be completely removed using solvent (Xylene). Surface profile should be no more than 60 microns for one coat of primer. If the profile is more than 60 microns, more than one coat may be required.

Where blast cleaning is carried out after erection of assembly, special attention should be paid to corners, edges, nuts, bolts, welds, etc. Welds should, if necessary, be ground and all weld spatter, slag, etc. should be removed.

Aluminium: should be phosphate treated. Where this is not available, the surface should be abraded with 180 grade abrasive paper.

Galvanised Steel: new galvanising needs only to be degreased prior to application. Old galvanising must be abraded to remove corrosion deposits.

GRP: abrade with course 240 grade abrasive paper.

For more detailed surface preparation on metal or other surfaces contact ROCOL® Site Safety Systems Technical Department.

Application Instructions

Do not part mix units.
Incorrectly mixed product will affect performance or cause premature failure of the coating.

Mixing of Components
Stir the contents of the base container (Part A) carefully ensuring that all the solids are removed from the bottom using a suitably sized implement. Carefully add all the contents of the hardener container (Part B) and stir thoroughly into the base. Continue stirring until both components are properly mixed and a uniform colour is obtained. (Mix for at least 5 minutes.)

Mixing

1. Pour all the contents of the hardener component into the base component. Larger packs should be accurately proportioned if required.
2. Mix thoroughly with a mechanical mixer for 2 minutes. Ensure all material is scraped from sides of the container and continue mixing for a further 2 minutes. Avoid air entrapment.
3. Product should be used immediately after mixing.
4. Failure to mix components correctly will result in incorrect curing and/or failure of the coating

Application Methods

Can be applied by airless spray, conventional air spray, brush or soft roller.

Airless spray typical spray settings

Devilbiss airless	32:1 pump ratio
Tip size	13-15 thou
Input air pressure	60 psi

Note: When airless spray is being used, excessively high tip pressure should be minimised.

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Brush/Roller
Good quality brushes and mohair rollers should be used.

Welding/Cutting
Areas to be cut or welded should be masked off before application of the SAFE STEP® Metal Primer. Ensure that all edges, corners, bolt holes etc. are adequately covered.

When to Prime
Exterior surfaces should be primed immediately after blast cleaning. Surfaces cleaned within shops should be primed within 4 hours (see details of over-coating times).

Limitations

Primer not to be applied when the relative humidity exceeds 90% or the ambient temperature is below 7°C.

Health & Safety

Refer to Safety Data Sheet before use.

Safety Data Sheets – Safety data sheets are available for download from our website www.rocol.com or may be obtained from your usual ROCOL® contact.

Disclaimer: *The information in this publication is based on our experience and reports from customers. There are many factors outside our control or knowledge which may affect the use and performance of our products, for this reason it is given without responsibility.*

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