KPC 87205 Aqua Welding Primer AC

Description:
A fast drying primer based on water borne resins.

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Main characteristics :
Good adhesion on blast cleaned steel. Suitable for use as a transport or weldingprimer. Can be recoated with conventional industrial paints or water borne paints. Can be easily applied by conventional airspray and airless spray. Dry to handle after approx. 8 minutes on steel preheated to 25 °C. Up to 35 micron d.f.t. good weldable. The product can be adjusted with normal tapwater to obtain the required film thickness, depending on temperature and conveyor velocity.

Surface preparation:
Steel blast cleaned to Swedish standard sis 055900 grade Sa 2½ and surface roughness of maximal 50 micron gives the best results. As a minimum requirement the surface should be dry, clean and free from rust.

Overcoating:
In cases where a subsequent coat has to be applied on top of a freshly applied coat of KPC 7205 aqua weldingprimer AC, clean the substrate of dust. A freshly applied coat can be recoated with water borne paint after two hours. If a solvent borne paint is used on top of this primer, the removal of dust is sufficient and an interval of 3 days is recommended.

Recoating of old paints requires complete removal of paint on damaged and rusted areas as mentioned under surface preparation. These areas have to be spot primed prior to the application of the new coat over the total surface. If rotating equipment is used for roughening the surface or to remove rust, removal of oil and grease must be done prior to the use of this equipment.

Application:
As a fast drying welding or transportprimer on blast cleaned steel. May only be used on blast cleaned steel.

Application data:
The paint can be thinned with water dependent to application circumstances. If applied with the airless spray we advice to dilute the paint 5 % by volume with water. A nozzle of 0.015 - 0.017 inch can be used. Too high viscosity results in a film of paint that is too thick with the consequence that it takes the paint much longer to dry. The drying can be improved to a large extent by using a warm dry airstream over the paint surface. Minimum temperature of the surface has to be
10 °C. and minimal 3 °C above dewpoint.

Cleaning:
Wet paint in spay lines or on tools can be removed by washing with water. The paint is not longer thinnable with water when dried. If the dry paint has to be removed high-pressure water cleaning or KPC 9901 Thinner X or KPC 9950 Thinner EP should be used.

Changing from conventional solvent borne systems to water borne systems:
It is important to prevent the two paints from contacting. The following procedure must be followed:

1. Flush with plenty of the thinner used for the solvent-based paint.
2. Flush with KPC 9910 thinner
3. Flush with plenty of water
4. Fill the equipment with the water borne paint and spray with the paint the water out of the spraylines.

When changing from water borne systems to solvent borne systems, the procedure has to be followed the other way round, thus starting with water.

Shelf life:
3 months, storaged at temperatures between 5 and 40 °C in the original unopened package.

Safety information:
Protect skin and eyes, and avoid prolonged breathing of solvent vapours. Use with adequate ventilation. Respiratory protection is recommended when applying this material in confined spaces or stagnant air. For more detailed information consult the medical safety sheet.

Miscellaneous information:
Drying times and recoatability are measured at 20°C. and 65% relative humidity. Using a dry filmthickness of 50 µm. These figures ought to be used as a guide. Considerable differences can be found due to variations in coat thickness, temperature differences and weather conditions.

Liability:
The effectiveness of the Kroonint Protective Coating B.V. paint systems is based on longterm practical experience and laboratory research. The directions are believed to be reliable and should be followed carefully. Ineffectiveness or other unintended consequences may result, because of factors which are beyond our control. All such risks are assumed by the buyer.

Product data

Gloss	flat
Solids	40% by volume
Specific gravity	1.2 – 1.3 kg/ltr
Recommended d.f.t.	30 - 40 µm
Theoretical spreading rate	20 m²/ltr
Drying (20 °C and RH of 65%)	dustfree dry 6 minutes, air ventilation 1-3 m/sec. Dry to handle 10 minutes.
Overcoating interval	minimal 2 hours with water borne paints and minimal 3 days when conventional solvent borne paints are used

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