

<b>Product Name:</b>	<b>VINAPRIME 41 HB ANTI-CORROSION PRIMER</b>		
<b>Reference Number:</b>	41-120.		
<b>Coating Type:</b>	Vinyl/zinc phosphate.		
<b>Typical Uses:</b>	High build inhibitive primer for steel. Damp tolerant and fast drying.		
<b>Colours Available:</b>	Buff (other colours to special order).		
<b>Appearance of Dried Film:</b>	Low sheen.		
<b>Volume Solids:</b>	38%.		
<b>Dry Film Thickness:</b>	<b>Typical:</b> 50 microns.	<b>Range:</b>	35-75 microns.
<b>Theoretical Coverage:</b>	7.6m <sup>2</sup> per litre at 50 microns.		
<b>Drying Time at 20°C:</b> (Will vary with temperature, air movement etc.)	<b>Touch Dry:</b> 40 minutes.	<b>Firm Dry:</b> 2 hours.	<b>Overcoat:</b> 2 hours.
<b>Packaging:</b>	5 litre tins.		
<b>Shelf Life:</b>	2 years in unopened containers, when stored under cover in good storage conditions.		
<b>Storage:</b>	Under cover within temperature range of 5°C to 32°C.		

**Continued/**

**Surface Preparation:**

**Steel**

Preferred method is abrasive blast to ISO 8501-1 SA 2.5

**Manual Cleaning**

Chip, scrape and power wirebrush to remove all loose millscale, rust and other surface contaminants. Degrease with Dacrylate Thinner R5.

**Application:**

Airless or conventional spray, brush or roller.

**Note:**

Care should be taken with application by **roller** to ensure the correct film build has been applied. A wet film thickness of 135 microns must be obtained to give a d.f.t. of 50 microns.

**Brush application**

Apply using full wet brush. Do not attempt to “brush out” or “lay off”.

**Note:**

Brush application is the preferred method for use on damp surfaces.

**N.B**

Certain products retain solvents for longer periods, which will affect plasticizers within the plastic packaging causing damage to the finish. It is therefore not recommended that finished painted products be wrapped in bubble wrap, plastic sleeves etc, until coatings are fully cured as this can cause damage to the finish especially when stacked or stored in sunlight/elevated temperatures.

Damage can also occur from condensation caused by fluctuations in temperature consequently causing a “greenhouse” effect within the packaging.

**Clean Up:**

Dacrylate Thinner R5.

**Health and Safety:**

Please see relevant MSDS sheet.

Data sheets are issued to supply **general information** on the product but without warranty. Since conditions of service and application are beyond our control we cannot accept claims for loss, damage etc., based on this information. Dacrylate will not accept any claim for consequential or incidental damages.

**Issued:** January 2006

LD/DAE/WHC

<b>Product Name:</b>	<b>VINADAC 41 HIGH BUILD MIO</b>		
<b>Reference Number:</b>	41-Line.		
<b>Coating Type:</b>	Vinyl/micaceous iron oxide with rust-inhibitive pigment.		
<b>Typical Uses:</b>	High-build coating for protection of steel and galvanised steel in aggressive environments. Tolerant of damp surfaces during application. Typical applications include lighting columns and general industrial plant.  Vinadac HB MIO has a 'Class O' Fire Rating when applied to a non-combustible substrate.		
<b>Colours Available:</b>	41-170 Light Grey 41-171 Natural 41-172 Dark Grey 41-173 Blue	41-173 Blue 41-174 Grey Brown 41-175 Brown 41-176 Green	41-177 Black 41-121 Sage 41-204 Gull Grey 41-418 Cupress
	(Other colours to special order – may be subject to minimum order quantities.)		
<b>Appearance of Dried Film:</b>	Matt specular finish.		
<b>Volume Solids:</b>	40%.		
<b>Dry Film Thickness:</b>	<b>Typical:</b> 75 Microns.	<b>Range:</b> 50-125 Microns.	
<b>Theoretical Coverage:</b>	5.3m <sup>2</sup> per litre at 75 microns.		
<b>Drying Time At 20°C: (Will Vary With Temperature, Air Movement etc.).</b>	<b>Touch Dry:</b> 2 Hours. <b>Firm Dry:</b> 3 Hours. <b>Overcoat:</b> 3 Hours.		
<b>Packaging:</b>	5, 15 and 20 litre open-top containers.		
<b>Shelf Life:</b>	2 years or longer in unopened containers when stored under cover in good storage conditions.		
<b>Storage:</b>	Under cover within temperature range of 5°C to 32°C.		
	<b>Continued/</b>		

**Surface Preparation:**

- a) **Mild steel, clean and free of millscale:**  
Thoroughly degrease using Dacrylate Thinner R5. Apply one coat of Vinaprime 41 HB Anti-Corrosion Primer, ref:41-120, to a dry film thickness of 50 microns.
- b) **Mild steel, corroded and/or millscale present:**  
Abrasive blasting to ISO 8501-1 SA2.5 is the preferred method.  
**Manual clean:**  
Chip, scrape and power wire-brush to remove all loose rust, millscale etc., to ISO 8501-1 ST3. Degrease with Dacrylate Thinner R5. Apply one coat of Vinaprime 41 HB Anti-Corrosion Primer, ref:41-120, to a dry film thickness of 50 microns.
- c) **Galvanising (new):**  
Ensure surface is clean and dry.  
**Note:** Adhesion may be further improved on certain types of bright galvanising by the use of Mordant Solution.
- d) **Galvanising (weathered):**  
Use stiff brush to remove any deposits of white zinc salts. Wash down with detergent water to remove road salts etc, rinse and dry off.

**Application Conditions:**

**Temperature:** Minimum 5°C.  
**Humidity:** Less than 90% RH.

**Application Methods:**

**Brush:**  
Apply using a 'full' wet brush. Avoid excessive 'brushing out'. Do not 'lay-off'. A wet film thickness of 190 microns will give a dry film thickness of 75 microns.

**Roller:**  
As for brush application, taking care to apply specified wet film thickness.

**Spray:**  
Vinadac HB MIO, ref:41-line, can be applied using conventional, airless and HVLP spray methods. 5-10% of Dacrylate Thinner R5 may be required to give optimum spray characteristics.  
Brush or roller is the preferred method for use on damp surfaces.

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