

**Era Polymers
Pty. Ltd.**

A.B.N. 14 003 055 936

erapol@erapol.com.au
www.erapol.com.au**SYDNEY**25 – 27 Green St
East Botany, NSW 2019
Ph: +61 2 9666 3788
Fax: +61 2 9666 4805**MELBOURNE**29 Trade Place
Vermont, VIC 3133
Ph: 03 9872 4033
Fax: 03 9872 4099**BRISBANE**Unit 6/5 Deakin Street
Brendale, QLD 4500
Ph: 07 3205 8510
Fax: 07 3205 9616**SINGAPORE**H.K. Moey
9 Elias Terrace
Singapore 519772
Ph: +65 6582 8103
Fax: +65 6584 8100
Mobile: +65 9751 0026**TECHNICAL DATA****Conap AD-6 Primer****Polyurethane Primer****DESCRIPTION**

Conap AD-6 Primer is a two component solvented anti-corrosive primer for metal surfaces.

Conap AD-6 Primer promotes adhesion to properly prepared aluminium, steel, and galvanized steel. Conap AD-6 affords superior corrosion protection to properly prepared steel when used in conjunction with Erapol and Eraspray polyurethane elastomers.

PHYSICAL PROPERTIES

	Conap AD-6 Part A	Conap AD-6 Part B	Mixed
Colour	Red	Clear	Red
Solids Content by Weight (%) ASTM D2369-87 Modified	33	None	18
Density (kg/L) ASTM D1475-85	1.1	0.95	1.0
Flashpoint ASTM D3278-82 Closed Cup	19°C	22.7°C	Not applicable
Volatile Organic Compound (kg/L) ASTM D3960-87	679	928	803
Shelf Life @ 20°C	6 months	12 months	8 hours

PROCESSING CHARACTERISTICS

Mix Ratio (Volume)	1:1
Induction Time @ 20°C	15 minutes
Pot Life @ 20°C	8 hours. Do not use after this time has elapsed even if the mixture is still liquid.
Dry Film Thickness (DFT)	6.5µm – 12.5µm Under no circumstances should Conap AD-6 Primer be used at greater than 12.5µm DFT. The metal substrate should be visible under the applied primer.
Recoat Time @ 20°C	Allow AD-6 primer to air dry 30 minutes -2 hours before applying topcoat.
Spread Rate	11m ² /L @ 10µm DFT

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SURFACE PREPARATION

It is essential to remove all oil, grease, cutting / drilling compounds, and other surface contaminants prior to further preparation of the metal surface. This is achieved using a biodegradable degreasing solution in accordance with AS1627.1. Alternatively solvent wiping using a solvent-based degreaser can be used. Clean dry untreated rags must be used and changed regularly to ensure the oil is removed and not spread over a larger area.

Soluble salts and biodegradable degreasing solution residue shall be removed by low pressure water washing (approx. 20 MPa) using potable water.

Grind all sharp edges and corners to a minimum radius of 2mm. Remove all weld slag and spatter, and grind all weld seams and high spots smooth.

Mild Steel

Abrasive blast all surfaces in accordance with AS1627.4 to a minimum Sa2½ (AS1627.9). A surface profile of 50 – 75 µm shall be achieved. Dust / vacuum down to remove all preparation residues. Blasted surfaces shall be primed prior to surface deterioration or contamination. The surface shall resemble the specified visual standard and profile immediately prior to priming.

Aluminium, Galvanized Steel, Stainless Steel

Low pressure sweep abrasive blast using inert media (e.g. garnet) to achieve a roughened uniform flat appearance over the entire surface. Dust / vacuum down to remove all preparation residues. Blasted surfaces shall be primed with four hours, and before surface contamination occurs.

Other Metals

Test patches of the complete coating system should be examined and tested for adhesion to ensure suitability of Conap AD-6 Primer for other metallic surfaces.

PRODUCT MIXING

The mix ratio of Conap AD-6 Primer is 1:1 by volume. The primer is supplied in pre-measured kits. Mix Part A well, then add approximately ½ of Part B into the Part A can and mix well. Add the remaining quantity of Part b in two additions. Stir well after each addition. Allow to stand for 15 minutes @ 20°C prior to use. Stir again before and during use.

ADDITION OF THINNERS

Addition of thinners to Conap AD-6 Primer may be required to provide good flow properties and better film build control. Thin up to 20% using MEK. Add thinner slowly with constant stirring to avoid “shocking” of the pigment. Take into account thinner addition when determining wet film thickness.

APPLICATION

Conap AD-6 Primer is best applied by siphon or pressure pot spray equipment. Airless spray equipment may be used, provided a maximum of 12.5µm DFT is applied.

Conap AD-6 Primer is applied in a single wet pass with 50% overlap. Hold the gun at right angles to the surface approx. 20-30 cm away. Make even, parallel passes and spray approx. 80µm Wet Film Thickness (WFT) to achieve 9µm DFT. A thicker film is not required. The desired film thickness will be obtained when the film appearance is continuous, but mottled and translucent.

CLEAN UP

Clean all mixing and application equipment immediately after use with MEK.

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SUGGESTED EQUIPMENT

Siphon Spray Equipment

Fluid Tip	0.070”
Needle	0.070”
Atomizing Pressure	275 – 345 KPa

Pressure Pot Spray Equipment

Fluid Tip	0.0425”
Needle	0.0425”
Fluid Pressure	102 KPa
Atomizing Pressure	102 KPa



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