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AUSTRALIA
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Erabond 6100FC Primer

POLYURETHANE FAST CURE PRIMER

TECHNICAL DATASHEET

Erabond 6100FC Primer is a high solids, 2 component urethane primer with outstanding adhesion to properly prepared steel, ductile iron and galvanized substrates. It is specially formulated to provide excellent anti corrosive properties and accept fast-set and standard-set polyurethanes.

Features

- Convenient 1:1 mix ratio
- Excellent adhesion to aged Polyurethane and Polyurea coatings
- Very good chemical resistance
- High flexibility and impact resistance
- Prevents undercutting
- Fast drying to aid applicator productivity

Physical characteristics

Mix Ratio (Volume)	1:1
Pot life at 15°C (minutes)	40 - 45
Pot life at 25°C (minutes)	30 - 35
Pot life at 32°C (minutes)	15 - 20
Solids Content by Volume	55%
Solids Content by Weight	68%
Theoretical Coverage	$9m^2/kg$
Recommended Dry Film Thickness (DFT)	25µ - 75µ
Number of Coats required	1
Colour	Red

Mixing conditions

The mix ratio of **Erabond 6100FC Primer** is 1:1 by volume. Each component needs to be mechanically mixed before adding together. They should be combined at a 1:1 ratio and mechanically mixed to a smooth consistency.

Cure time

		22-26°C
Surface Dry	(hours)	2 - 3
Hard Film	(hours)	3 - 5
Recoat (min)	(hours)	3 - 5
Full cure	(days)	4

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 **Erabond 6100FC Primer** for other metallic surfaces.

Addition of thinners

Addition of thinners to **Erabond 6100FC Primer** is not normally required

Application

Erabond 6100FC Primer is best applied by siphon or pressure pot spray equipment. Airless spray equipment may be used, provided a minimum of 25µm DFT is applied.

Erabond 6100FC 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 approximately 40 µm DFT. A thick 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.