

# DHDC-1650P

## Inorganic ethyl silicate shop primer



This paint is a two-component inorganic zinc rich shop primer that is specially designed to be used under conditions where the surface treatment and painting process are automated because the drying speed is very fast. This paint is a fast-drying type, having very good adhesion and anti-corrosion properties. It is used as a shop primer for steel structures in shipyards and other extremely corrosive environments and can withstand temperatures of up to 400°C. In particular, cutting and electric welding workability is very excellent.

### Usage

Temporary anti-corrosive primer for various steel pipes, tanks, and steel structures

### Specification

Paint type	Zinc powder paste / Ethyl silicate			
Drying time	Category	5°C	20°C	30°C
	Set-to-touch	5 minutes	3 minutes	1 minute
	Dry-hard	20 minutes	10 minutes	5 minutes
	Over-coat (Max.)	24 hours	16 hours	10 hours
	Pot life	10 hours	8 hours	6 hours
Thinner	DR-660	Dilution ratio	▷ Brush, roller coating: less than 5%	
Specific gravity	Approx. 1.4		▷ Airless, spray coating: less than 5%	
Theoretical Coverage	14 m <sup>2</sup> /ℓ (1time - 20μm)	Solid volume ratio	Approx, 28±1%	
Color	Metal iron gray	Thickness of dried film	20μm	
Mixing ratio	Base(A)/Hardener(B)=3/1 (Weight ratio)	Flash point	At least 11°C	
Gloss	Matte	Shelf life	12 months (well-ventilated dry, cold and dark location)	

### Product Properties (Physical Property Data)

Shop primer	A shop primer with a quick-drying speed, which can be used even in an automated painting process.
Excellent film property	Temporary anti-corrosive primer for steel structures, which is excellent in adhesion, anti-corrosive properties, heat resistance, and electric welding workability.

### How to Use

Surface treatment	<ol style="list-style-type: none"><li>1. Completely remove oil, moisture, sand, dust, and other foreign matter from the surface to be coated. The degree of surface treatment to obtain an excellent steel protection effect should be at least SSPC-SP 10 or Sa2.5 (near white metal blast cleaning). - Note that adhesion may be weak at a surface treatment grade of SSPC-SP 10 or less.</li><li>2. For steel, apply immediately after surface treatment.</li><li>3. If the subsequent paint is an inorganic zinc primer, the surface treatment should be sweep blasting or more advanced process(SSPC-SP 7, NACE#4, Sa 1.0).</li></ol>
Coating Method	<ol style="list-style-type: none"><li>1. Although coating can be done by either brush or airless spraying, airless spray coating is best.</li><li>2. Airless spray coating: - Tip diameter : 0.013"~0.019" - Injection pressure : More than 2500 P.S.I(176kg/cm<sup>2</sup>) - Store the coating equipment after cleaning with an exclusive thinner immediately after use.</li><li>3. Brush and roller coating should only be used on damaged parts of the coating and should not be repeated more than once.</li></ol>
Preceding & Follow-up Coating	<ol style="list-style-type: none"><li>1. Follow-up coating: Applicable to inorganic zinc system, 2K epoxy system, vinyl system, and chlorinated rubber system</li><li>2. Unsuitable follow-up coating: Oil-based top coats (ready mixed paint, air-drying enamel, etc.)</li></ol>
Remarks	<ol style="list-style-type: none"><li>1. Before use, thoroughly stir the main agent to make it uniform and use after slowly mixing the hardener and sufficiently stirring (After stirring, filter with a 30-60 mesh).</li><li>2. Continue stirring to avoid sedimentation during use. Excessive dilution is prohibited.</li><li>3. Due to the nature of the paint, self-re-coating is impossible. Please be sure to remove the coating if the coating is formed within the container during use.</li><li>4. Be careful to avoid contamination and damage to the coating by welding residue during welding work.</li></ol>