DHDC-1650UL



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 minute	2S	3 minutes		1 minute
	Dry-hard	20 minute	es	10 minutes		5 minutes
	Over-coat (Max.)	24 hours	s	16 hours		10 hours
	Pot life 10 hours		s	8 hours 6 hours		6 hours
Thinner	DR-660		Dilutio	Dilution ratio		
Specific gravity	Approx. 1.4		Dilation fatio		\triangleright Airless, spray coating: less than 5%	
Theoretical Coverage	14 m³/ℓ (1time - 20µm)		Solid volu	ume ratio	Approx. 28±1%	
Color	Metal zinc gray		Thickness of dried film		20µm	
Mixing ratio	Base(A)/Hardener(B)=3/1 (Weight ratio)		Flash point At least 11°C		At least 11℃	
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	Temporary anti-corrosive primer for steel structures, which is excellent in adhesion, anti-corrosive properties, heat					
property resistance, and electric welding workability.						
How to Use						
Surface treatment	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.					
	2. For steel, apply immediately after surface treatment.					
	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).					
Coating Method	1. Although coating can be done by either brush or airless spraying, airless spray coating is best.					
	2. Airless spray coating:					
	- Tip diameter : 0.013"~0.019"					
	- Injection pressure : More than 2500 P.S.I(176kg/㎡)					
	- Store the coating equipment after cleaning with an exclusive thinner immediately after use.					
	3. Brush and roller coating should only be used on damaged parts of the coating and should not be repeated					
	more than once.					
Preceding & Follow-up Coating	1. Follow-up coating: Applicable to inorganic zinc system, 2K epoxy system, vinyl system,					
	and chlorinated rubber system					
	2. Unsuitable follow-up coating: Oil-based top coats (ready mixed paint, air-drying enamel, etc.)					
Remarks	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).					
	2. Continue stirring to avoid sedimentation during use. Excessive dilution is prohibited.					
	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.					
	4. Be careful to avoid contamination and damage to the coating by welding residue during welding work.					