

# NORUMEL DHDC-0210

## Alkyd oxidized steel anti-corrosive primer (reddish brown)



NORUMEL PRIMER is a paint made by mixing alkyd resin and red lead and active iron oxide, which are anti-corrosive pigments. It is excellent in chemical and mechanical properties against steel surfaces and has good corrosion resistance and adhesion. It has excellent elasticity for expansion of metal and adhesion to surfaces and is widely used as an anti-corrosive primer for steel structures that are not immersed in water.

Usage

Anti-corrosive paint for general steel

### Specification

Paint type	Alkyd / Anti-corrosive primer			
Drying time	Category	5°C	20°C	30°C
	Set-to-touch	2 hours	1 hour	30 minutes
	Dry-hard	12 hours	6 hours	4 hours
	Over-coat (Min.)	24 hours	12 hours	8 hours
Thinner	DR-306	Dilution ratio	▷ Brush, roller coating: less than 15%	
Specific gravity	Approx. 1.53(Based on reddish brown)		▷ Spray coating: less than 20%	
			▷ Airless, spray coating: less than 10%	
Theoretical Coverage	13m <sup>2</sup> /ℓ (1time - 40μm)	Solid volume ratio	Approx. 52±1%	
Color	Reddish brown	Thickness of dried film	40μm	
Mixing ratio	1-component	Shelf life	12 months (Dry, cool, and dark place with good ventilation)	
Gloss	Matte	Flash point	At least 27°C	

### Product Properties (Physical Property Data)

Film property	Corrosion resistance and adhesion are excellent.
Elasticity	Elasticity and surface adhesion for metal expansion are excellent.

### 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 should be of at least SSPC-SP2, SP3, the degree of surface treatment to obtain an excellent steel protection effect should be at least SSPC-SP 6 or Sa2 (Commercial blast cleaning).</li><li>2. Sufficiently dry the surface to be coated.</li><li>3. For steel, apply immediately after surface treatment.</li><li>4. After primer coating, clean up the welded areas (blackened and rusted areas) with a disc sander. Then, touch up with this paint and continue coating.</li></ol>
Coating Method	<ol style="list-style-type: none"><li>1. Coating can be done by either brush, roller, air or airless spray coating.</li><li>2. Airless spray coating:<ul style="list-style-type: none"><li>- Tip diameter : 0.015"~0.019"</li><li>- Injection pressure : More than 2,500 P.S.I.(176kg/cm2)</li></ul>(Airless spray data are for reference only, and it is adjusted according to the coating conditions.)</li><li>3. Coating conditions: The surface of the substrate must be clean. The surface temperature should be at least 3°C higher than the dew point to avoid the condensation of water, and the relative humidity should be less than 85%.</li></ol>
Preceding & Follow-up Coating	<ol style="list-style-type: none"><li>1. Follow-up coating: General ready mixed paint, alkyd paint, and phenol resin paint are suitable.</li></ol>
Remarks	<ol style="list-style-type: none"><li>1. Product with similar specifications: JIS-K-5621(Type 2)</li><li>2. Precautions<ul style="list-style-type: none"><li>- This paint cannot be used in areas that will be immersed in water. If used, the brittle phenomenon in which the coating crumbles occurs.</li><li>- Sufficient performance after last coating is achieved after drying for 7 days at 20°C.</li></ul></li></ol>