DHDC-3650TL PRIMER

Phenolic epoxy primer, high build

This paint is a premium epoxy phenolic amine primer that is used for the primer of structures in an environment that requires excellent adhesion to hard film and steel surfaces and a chemical-resistant atmosphere such as solvent resistance, and acid and alkali resistance. As it is a high build paint that can be applied at a thickness of up to 100㎛ in one coat, it can shorten the painting process.

Usage	Primer for steel structures under severe chemical environments

Specification

Paint type	Epoxy phenolic amine / Anti-corossive primer / High build (Two-Component)

Drying time

Category	5℃	20℃	30℃
Set-to-touch	2 hours	1 hour	40 minutes
Dry-hard	24 hours	18 hours	12 hours
Over-coat (Min.)	32 hours	24 hours	16 hours
Over-coat (Max.)	4 months	15 days	7 days
Maturation time	30 minutes	20 minutes	10 minutes
Pot life	5 hours	3 hours	2 hours

Thinner	DR-100	Dilution ratio	▷Brush, roller coating: less than 15% ▷Airless, spray coating: less than 10%
Specific gravity	Approx. 1.6		
Theoretical Coverage	7.2 ㎡/ℓ (1time - 100㎛)	Solid volume ratio	약 72±1%
Color	Reddish brown	Thickness of dried film	100㎛
Mixing ratio	Base(A)/Hardener(B)=5/1 (Weight ratio)	Flash point	At least 12℃
Gloss	Matte	Shelf life	12 months (Dry, cool, and dark place with good ventilation)

Product Properties (Physical Property Data)

Primer for steel	A 2K phenolic epoxy high-build primer for steel with superior chemical resistance
Excellent film property	Adhesion, anti-corrosive properties, solvent resistance and chemical resistance are excellent.

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).The surface roughness should not exceed 75 ㎛. 2. For steel, apply immediately after surface treatment. 3. 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.
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 : 0.021"~0.031" - Injection pressure : More than 3000 P.S.I(210kg/㎠) - Store the coating equipment after cleaning with an exclusive thinner immediately after use.
Preceding & Follow-up Coating	1. Follow-up coating : Epoxy system(DHDC-3650TL), urethane paint are suitable.
Remarks	1. Sufficient performance after last coating is achieved after drying for 7 days at 20℃. 2. For coating areas exposed to the outside, yellowing and chalking may occur in a short period of time due to the effect of sunlight. Upon coating for areas exposed to the outside, be sure to apply top coat.