

WASH COAT DHDC-1510

Two-component wash primer (dark green), short exposure type

This paint is a two-component wash primer made of polyvinyl butyral resin with strong adhesion, zinc chromate anti-corrosive pigment and phosphoric acid catalyst. As it has excellent anti-corrosive properties and adhesion, it is an excellent etching primer for metals (iron, light metal, alloy), and KSM-6030 (4 kinds, 1 type) is widely used.

Usage

Primer for nonferrous metals, light metals, electro galvanized steel, and steel surfaces

Specification

Paint type	Etching primer / Short exposure type (Two-Component)			
Drying time	Category	5°C	20°C	30°C
	Set-to-touch	5 minutes	3 minutes	2 minutes
	Dry-hard	20 minutes	10 minutes	5 minutes
	Over-coat (Min.)	4 hours	2 hours	1 hour
	Over-coat (Max.)	24 hours	24 hours	24 hours
	Maturation time	10 minutes	5 minutes	3 minutes
	Pot life	16 hours	12 hours	8 hours
Thinner	DR-510	Dilution ratio	▷ Brush, roller coating: less than 10% ▷ Spray coating: less than 15% ▷ Airless, spray coating: less than 5%	
Specific gravity	Approx. 0.9			
Theoretical Coverage	0.09kg/m ² (10m ² /ℓ)-10μm	Solid volume ratio	Approx. 10±1%	
Color	Dark green	Thickness of dried film	10μm	
Mixing ratio	Base(A)/Hardener(B)=4/1 (Weight ratio)	Flash point	7°C	
Gloss	Matte			

How to Use

Surface treatment	<ol style="list-style-type: none">1. Completely remove oil, moisture, sand, dust, and other foreign matter from the surface to be coated.2. Apply immediately after surface treatment of the steel.3. Light metals should be coated after solvent cleaning. If washed after polished with abrasive paper, adhesion will be better.4. Surface treatment for nonferrous metals should be done by solvent cleaning (SSPC-SP1).5. For zinc plated (electro-galvanized) steel, weak blasting with a fine abrasive is required depending on the degree of contamination and surface conditions.
Coating Method	<ol style="list-style-type: none">1. Coating can be done by either brush, roller, or airless spray coating.2. Airless spray coating:<ul style="list-style-type: none">- Tip diameter : 0.013"~0.017"- Injection pressure : 1500~2000 PSI(105~140kg/cm²)- Store the coating equipment after cleaning with an exclusive thinner immediately after use.3. Clean the surface of the welded part with a disc sander after primer coating and then proceed with coating after touch-up to approx. 5~10μm.
Preceding & Follow-up Coating	<ol style="list-style-type: none">1. Follow-up coating: Oil-based paint, alkyd resin, phenol resin, vinyl resin, chlorinated rubber resin, epoxy resin, urethane resin, PVDF paint
Remarks	<ol style="list-style-type: none">1. Product with similar specifications: KSM-6030 (Type 4, Grade 1), JIS-K-5633(Type 1), DOD-P-1532D2. Precautions<ul style="list-style-type: none">- Do not use the paint whose pot life has expired.- Continue stirring to avoid sedimentation during use.- Since this paint cannot completely hide the material, top coating can be applied in the case there are no problems in the coating even if covered area is uneven after coating.- As this paint is used as a pretreatment agent, it should be thinly coated. If coated thickly, adhesion is lowered.- Apply a top coat within 24 hours. Use a long exposure type wash primer, wash coat DHDC-1520 for prolonged exposure.- Store at room temperature (5~35°C) since it can change into gel if it is stored at low temperatures of 4°C or below for a long period of time. (If paint that has turned into gel is warmed up to room temperature by placing it in a warm room or warm water and is stirred well, it turns back to the original state.)