



PRODUCT DATA SHEET
KoraPrimer® - 400
 Low VOC Alkyd Metal Primer
 Fast Dry

GENERIC TYPE:

Single package, fast drying, modified Alkyd Primer.

DESCRIPTION: *KoraPrimer-400* is an economical, High Solids, VOC compliant primer for protection of steel surfaces. Good resistance to general atmospheric weathering. Easy to apply by spray with fast dry characteristics for shop applications.

FEATURES:

- Low VOC
- Lead and Chromate-free
- Corrosion resistant
- Interior or exterior usage
- Production and shop coat primer
- Very good flexibility and weathering
- High Solids, fast dry primer

RECOMMENDED USES:

KoraPrimer-400 coating is Ideal for interior or exterior structural steel, piping, tankage, equipment, metal doors, handrails, and other steel work in non-chemical or non immersion service. As a Shop prime coat with appropriate topcoat for use on steel substrates such railcal and tank exteriors, piping and equipment to provide good protection in mild or moderate environments.

NOT RECOMMENDED FOR:

Immersion service, or splash and spillage of acids, alkalies, or solvents.

COMPATIBLE COATINGS:

KoraPrimer-400 may be applied directly to substrate. Should be topcoated with alkyds. Non-ferrous surfaces and new galvanizing require a wash coat of *SanyBond-WP100*.

ORDER INFORMATION: Prices may be obtained from *SanyChem Sales Representative* or main Office.

APPROXIMATE SHIPPING WEIGHT :

Freight Classification: Paint, Combustible Liquid UN1263, PG III

Packaging:	1 gallon (3.785L)	5 gallons (18.925L)
<i>KoraPrimer-400</i>	15 lbs. (6 kg.)	75 lbs. (30 kg.)
<i>SolvenSany # 260</i> Thinner	8 lbs.(4 kg.)	40 lbs. (18 kg.)
<i>SolvenSany # 300</i> Thinner	8 lbs.(4 kg.)	40 lbs. (18kg.)

Shipping Weight:	4 gallon case - 60 lbs. (24 kg)
	5 gallon pail - 75 lbs. (30kg)

FLASH POINT (Pensky/Martens Closed Cup) :

	Flash Point
<i>KoraPrimer-400</i>	79 °F (26 °C)
<i>SolvenSany # 260</i> Thinner	83 °F (28 °C)
<i>SolvenSany # 300</i> Thinner	> 200 °F (93 °C)



January 2001 replaces April 1998

SPECIFICATION DATA

- **Solids Content By Volume:** *KoraPrimer-400* 62% ± 2%
- **Theoretical Coverage Rate per Gallon: ***

<i>KoraPrimer-400</i>	25 m ² / Lit at 25 microns
	12.5 m ² / Lit at 50 microns
- Mixing and application losses will vary and must be taken into consideration when estimating job requirements.
- **Volatile Organic Content (VOC) as supplied :**

<i>KoraPrimer-400</i>	2.75 lbs./gal. (330 g/L)
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- **Temperature Resistance** (Non-Immersion)

Continuous	:	200 °F (93 °C)
Non-Continuous	:	250 °F (121 °C)
- **Recommended Dry Film Thickness Per Coat :**

1 Coat <i>KoraPrimer-400</i>	2 mils (50 microns)
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 Dry film thicknesses in excess of 4 mils (100 microns) are not recommended.
- **Color Standard in :** *KoraPrimer-400* : Brick Red and Buff
- **Gloss** Flat
- **Substrates:** Apply over suitably prepared steel, concrete or others as recommended.
- **Shelf Life :** 24 months when stored at 75 °F (25 °C)
- **Storage Conditions:** Store indoors.
Temp.: 40 - 110 °F (4 -43 °C)
Humidity: 0 - 100%

Topcoat Required: Apply directly to substrates. May be topcoated with *SanyChem* Alkyds, Silicone-Alkyds, or other as recommended. Please consult the appropriate system guide, the particular job specification or your *SanyChem Coatings* Industrial Coatings Specialist for proper systems using this product. Systems must be selected considering the particular environment involved.

Specific recommendations do not topcoat directly with coatings containing strong solvents like epoxies or vinyls.

TYPICAL CHEMICAL RESISTANCE
 (With Suitable Topcoat)

Exposure	Splash & Spillage	Fumes
Acids	Poor	Fair- Poor
Alkalies	NR	NR
Solvents	Poor	Fair- Poor
Salt	Very Good	Very Good
Water	Excellent	Excellent

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APPLICATION INSTRUCTIONS

These instructions are not intended to show product recommendations for specific service. They are issued as an aid in determining correct surface preparation, mixing instructions, and application procedure. It is assumed that the proper product recommendations have been made. These instructions should be followed closely to obtain the maximum service from the materials.

Substrates & Surface Preparation

General:

Remove any oil or grease from surface to be coated with clean rags soaked in **SolvenSany # 252** in accordance with **SSPC-SP-1-82**.

All surfaces must be sound, dry, clean and free of oil, grease, dirt, mildew, form release agents, curing compounds, efflorescence, loose and flaking paint and other foreign substances.

NON IMMERSION SERVICE:

New Surfaces: Steel - Best results are obtained over a surface sandblasted to a Commercial Blast (SSPC-SP6-85). Performance over hand or power-tool cleaned surfaces is dependent on the degree of cleaning. Prime with this product.

Previously Painted Surfaces: Wash to remove contaminants. Rinse thoroughly with water and allow to dry. Dull glossy areas by light sanding. Remove sanding dust. Remove loose paint. Scrub heavy chalk areas and overhead areas such as eaves with soap and water. Remove all mildew by washing with a solution of 16 oz. (473 mL) liquid household bleach and two oz. (59 mL) non-ammoniated liquid detergent per gallon (3.785 L) of water. Rinse surfaces clean with water and allow to dry for 24 hours. All areas failed by rusting, peeling, blistering, etc., shall be wire brushed and scraped to remove all loose or loosely adhering material. Prime bare areas with primer specified under

New Surfaces. For optimum performance in more corrosive areas, entire surface should be abrasive blast cleaned and primed with this product.

Mixing: Power Mix to a uniform consistency before thinning.

Thinning:

Spray :

May be thinned up to 15% by volume with **SolvenSany # 260** for hot or windy conditions dictate spray application. SolvenSany # 300 Thinner should be used where the limit is 2.8 lbs/gal. Emissions. **Do not use SolvenSany # 300 with application equipment (guns, pumps, pressure tanks) where aluminum or galvanized parts come in contact with SolvenSany # 300.**

Brush:

May be thinned up to 10% by volume with **SolvenSany # 260** for brush application.

Application Equipment

Listed below are general equipment guidelines for the application of this product. Job site conditions may require modifications to these guidelines to achieve the desired results. The following equipment has been found suitable and is available from manufacturers such as Binks, DeVilbiss and Graco.

Application Equipment



Listed below are general equipment guidelines for the application of this product. Job site conditions may require modifications to these guidelines to achieve the desired results. General guidelines:

Spray Application

(General)

The following spray equipment has been found suitable and is available from manufacturers such as Binks, DeVilbiss and Graco.

Conventional Spray

Use 3/8" minimum I.D. material hose. Hold gun approximately 18-20 inches from the surfaces and at a right angle to the surface.

Mfr. & Gun	Fluid Tip	Air Cap.
DeVilbiss P-MBC or JGA	FF	704
Binks #18 or #62	63C	63 BB
I.D.	Approx. .052"	

Airless Spray

Use 3/8" minimum I.D. material hose. Hold gun approximately 18-20 inches from the surfaces and at a right angle to the surface.

Mfr. & Gun	Pump
DeVilbiss JGB-507	QFA-514 or QFA-519
Binks Model 700	Mercury 5C or B8-36 37:1
Graco 205-591	President 30:1 OR Bulldog 30:1

Use a .013" - .017" tip with 2000 psi.

Teflon packings are recommended and available from the pump manufacturer.

Contact



For information and Prices, Please Call a SANYCHEM Local Sales Representative.

Phones:



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Drying Time:

At 90°F (32°C) and 50% R.H., dries to touch in 30 minutes, to handle in 1 hour, to recoat in two hours and thorough dry in eight hours. If topcoating with heavy duty or waterborne coatings, allow to dry 48-72 hours. Low temperature, high humidity, thick films or poor ventilation will increase these times.

These times are based on recommended dry film thickness. Excessive film thickness or inadequate ventilating conditions after application require longer dry times and will cause premature failure in extreme cases.

Final cure requirement varies depending on exposure. Consult **SanyChem Technical Service** for specific recommendations.

APPLICATION CONDITIONS

	Material	Surfaces	Ambient	Humidity
Normal	10 – 32 °C	13 – 32 °C	13 – 38 °C	30 – 95 %
Minimum	2 °C	2 °C	2 °C	0 %
Maximum	49 °C	74 °C	49 °C	98 %

Do not apply when the surface temperature is less than 5 °F or 2 °C above the dew point.



Brush & Roller

For small areas or touch-up only. Use a natural bristle brush applying full strokes. Use a short nap mohair roller with phenolic core. Avoid rebrushing or rerolling.

Cleanup & Safety

Cleanup

Use **SolvenSany #252**. In case of spillage, absorb and dispose of in accordance with local applicable regulations.

Safety

Read and follow all caution statements on this product data sheet and on the MSDS for this product. Employ normal workmanlike safety precautions. Hypersensitive persons should wear protective clothing, gloves and use protective cream on face, hands and all exposed areas.

Ventilation

When used as a tank lining or in enclosed areas, thorough air circulation must be used during and after application until the coating is cured. The ventilation system should be capable of preventing the solvent vapor concentration from reaching the lower explosion limit for the solvents used. In addition to ensuring proper ventilation, appropriate respirators must be used by all application personnel.

Caution



This product contains flammable solvents. Keep away from sparks and open flames. All electrical equipment and installations should be made and grounded in accordance with the National Electric Code. In areas where explosion hazards exist, workmen should be required to use non-ferrous tools and wear conductive and non-sparking shoes.

FOR INDUSTRIAL USE ONLY. KEEP AWAY FROM CHILDREN. 1/2001



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