

AR-PRIMER 12.5[®]

Inorganic Anti-Rust Primer
Containing Carbon Fiber

APPLICATION GUIDELINE

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1. SCOPE AND PURPOSE

AR-PRIMER 12.5 is a water-based primer for metals and also is designed to be used as a direct-to-metal primer on properly prepared steel or previously painted surfaces in corrosive atmospheres.

The purpose of the guideline is to ensure that the coating system, when correctly applied, provides the necessary protection against corrosion.

2. PRODUCT SPECIFICATION

2.1 Appearance

AR-PRIMER 12.5		Color	Net weight	Packaging
1st & 3rd coats	Emulsion	White	10kg	Plastic container
	Compound	Gray	23kg	Plastic bag
2nd coat	Emulsion	White	10kg	Plastic container
	Compound	Green	23kg	Plastic bag

2.2 Painting specification and Film Layer Thickness

	Product	Color	Minimum DFT (microns)	Minimum DFT (mils)
Standard	1st	Gray	500	20
	2nd	Green		
Heavy corrosion	1st	Gray	750	30
	2nd	Green		
	1st	Gray		

* Each layer must be at least 250 microns or 10 mills DFT.

3. COATING APPLICATION PROCEDURES

3.1 Surface preparation

Prepare areas of corrosion by cleaning with hand and power tools to ISO 8501-2-P St 2. Thoroughly cured old coatings may require scuff sanding for maximum adhesion. Visually inspect all areas to be primed and to make sure that they are clean and have no contaminants on them.

3.2 Mixing

Basic mixing ratio

Emulsion (10kg): Compound (23kg) = 1/2.3

3.3 Application

3.3.1 All surfaces to be primed and/or painted must be clean, dry and free from contamination. High pressure water cleaning, as appropriate and remove all oil, grease and contaminants.

3.3.2 Mix proper amounts of emulsion and compound. Stir all products thoroughly with a mechanical stirrer prior to use. Pour the emulsion into the container first, then add the compound little by little.

3.3.3 While the AR-PRIMER 12.5 recommended in this application guideline can be applied by spray or brush, it is recommended to apply this product by spray for use with heavy viscosity paints for the best appearance. It can be recoated approximately 60 minutes after dry to touch.

Adjust the distance between the air outlet of a spray and the tip of the nozzle to about 5 mm, the nozzle tip size of 4 to 5 mm, and compressor air pressure of about 6 to 8 kg/cm².

Once mixture solidifies in a pail while working, add the emulsion and stir well to adjust viscosity.

Pot life is about 2 to 3 hours.

3.3.4 Apply a topcoat after AR-PRIMER 12.5 is cured and dry. Apply at least 2 coats. The topcoat should be water-based paint. If you use solvent base topcoat, oil components may erode the polymer of AR-PRIMER 12.5, and degrade its anti-corrosion performance. Follow the instruction on handling by paint manufacturers.

3.4 Notes

Avoid outdoor work in rainy weather. If rain is expected, protect applied surface with a sheet.

During application and AR-PRIMER 12.5 curing process, the steel surface temperature must be lower than 5°C(41°F).

Avoid using oil and grease on the areas where AR-PRIMER 12.5 comes into contact directly.

4. Inspection

All work and materials supplied under this application guideline shall be subject to timely inspection by the owner or their authorized representative. The painter shall correct such work that is found to be defective under this application guideline.

5. Cleanup

AR-PRIMER 12.5 is a water base anti-corrosion primer. Clean equipment with water immediately after use.

6. Safety information

Specific safety information is found in the Safety Data Sheet. The sheet should be attached and made a part of this application guideline.

7. Storage

Emulsion: Protect from freezing and direct sunlight. Store containers in an area that can maintain temperatures between 5°C(41°F) and 30°C(86°F). Use within 2 years from the manufacturing date.

Compound: Store in a dry and well-ventilated area away from sources of heat and incompatible substances such as acidic products or water.

8. Notes

it is imperative that, prior to the commencement of anti-corrosion repainting, local regulations regarding health and safety are consulted.