

Tor Hi build phosphate primer

AK623

intended uses

A single pack high build primer for blast/manually cleaned steel. An excellent anti-corrosive which is lead and chromate free.

product description

A urethane alkyd binder with zinc phosphate anti-corrosive, together with inert inorganic pigments and thinned with low aromatic white spirit.

product information

Product reference	AK623
Volume solids	48%
Typical thickness	75 microns dft from 155 microns wet
Theoretical coverage	6.45 square metres per litre
Practical coverage	Reduce above by up to 20%
Appearance/Colour range	Low Sheen/ Grey
VOC content	EU limit value for this product (cat A/i): 500 g/l . This product contains max 500 g/l VOC

application details

Mix ratio	N/A
Method of application	Airless spray (tip size 0.017"-0.021" and 1800 psi atomising pressure). Brush or short pile roller acceptable.
Thinner	Tor TH10 (when required)
Cleaner	Tor TH10 for cleaning equipment
Pot Life	N/A

Drying time

Substrate Temperature	Touch Dry	Hard Dry	Overcoating Interval	
			Minimum	Maximum
20°C	1 hour	16 hours	16 hours	3 months

Note: Drying/curing times will be shortened by higher temperatures and lengthened by lower temperatures

storage and handling

Storage	Store in a safe place out of the reach of children.
Pack Size	5 litres and 20 litres
Flash point	37°C
Product weight	1.24 kilos/litre
Shelf life	2 years in unopened containers

surface preparation

Grit Blasting: Blast clean to BS4272 2nd Quality (Swedish equivalent Sa 2.5) with maximum profile of 75 microns.

Manual Cleaning: Acceptable standard is Swedish ST2. Avoid excessive burnishing. Remove all dust before painting.

limitations

Maximum dft for brushing/roller application will be 50 microns (Cf 75 microns airless spray).

Do not apply if relative humidity exceeds 88% or air temperature falls below 2°C.

safety precautions

A copy of the appropriate Health & Safety Data Sheet should be consulted prior to using the product. Contact Sales on 0191 4106611.

Minimum precautions for all paints:

1. Avoid skin and eye contact i.e. wear gloves, goggles, etc
2. Ensure good ventilation, mechanical if necessary.
3. Store and use away from heat and flame.
4. Do not eat or smoke in the vicinity of work.
5. Wash hands before eating.
6. Refer to supply container for additional warning labels.

definitions

Tolerances

All information quoted in this data sheet is subject to normal manufacturing tolerances.

Practical coverage

Practical coverage can vary considerably depending on method of application, surface roughness, weather conditions and complexity of the structure.

Pot Life

Applies only to two component products and refers to the time the mixture remains usable.

disclaimer

The information contained herein is to the best of our knowledge true and accurate and is given in good faith but without warranty. The user will be deemed to have satisfied him/herself independently as to the suitability of our products for his/her own particular purpose. In no event shall Tor Coatings be liable for consequential or incidental damages.

This document will normally be updated at least every two years. It is the users responsibility to ensure that they have the current copy.

Updated: Nov 2012