TECHNICAL INFORMATION

SWARCOPLAST Primer Roll 120

swarco
Road Marking Systems

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SWARCOPLAST Primer Roll 120

Important Information:
Please consider our General Terms and Conditions and the general notes of the Technical Information Sheet! No liability is accepted for any errors! The information is provided to our best knowledge and experience. This information is, however, no warranty for any properties of the material. We provide this information without obligation, also regarding the rights of third parties. The user has to make sure that the material is appropriate for the respective application.

1 Main Characteristics

- SWARCOPLAST Primer Roll 120 is a low viscosity, colourless, 2 component reactive resin based on methyl methacrylate (MMA).
- Exhibits excellent adhesion to metal and concrete substrates, enhancing and optimising the adhesion of the SWARCO HITEX MMA product range to difficult substrates.

2 Technical Information

2.1 Technical Characteristics (liquid state)

Viscosity, 25°C	100-130 mPa*s
Density, 25°C	0.99g/ml
Pot life / processing time at 20°C	Approx. 15 mins
Curing time at 20°C	Approx. 30 mins
Flash point	+ 11.5°C

2.2 Technical Characteristics (cured state)

Tensile strength	13.8 N/mm²
Elongation at maximum strength	1.3%
Elongation at fracture	1.3%
Modulus of elasticity	1,500 N/mm²
Density, 20°C	1.16 g/cm³

3 Packaging and Storage

SWARCOPLAST Primer Roll 120 is available in 10kg and 20kg pails. The shelf life is 6 months when stored in a cool and dry place and within original closed packaging. The optimal storage temperature is 15 - 20°C.

4 Application

4.1 Substrate Preparation

All substrates must be dry, sound and free of dust, fats, oil and any other defects. Loose tiles and tiles over hollows must also be removed. Laitance and loose articles must be thoroughly removed. Steel substrates must be prepared to SA 2.5 (according to DIN55929).

The surface structure shall allow the correct application of the primer. Surface tensile strength values obtained shall be a minimum of 1.5 MPa. Mechanical preparation shall be carried out to expose the concrete aggregate and to ensure that an optimised adhesive bonding takes place. Any visible pin holes and craters shall be filled separately using filled primer or a suitable cement mortar, which should be allowed to fully cure before any priming takes place.

4.2 Mixing

Prior to use SWARCOPLAST Primer Roll 120 it must be carefully stirred to achieve a uniform distribution of the product. SWARCOPLAST Primer Roll 120 should then be thoroughly mixed together with the catalyst (50% dibenzoyl peroxide), in accordance with the below guidelines. It should be noted that the amount of catalyst powder to be added depends upon the substrate temperature.

4.3 BPO Catalyst Additions

10kg

Substrate Temperature (°C)	Primer pack (kg)	BPO catalyst (g)
0 - 5	10	600
5 - 15	10	400
15 - 25	10	200
25 - 40	10	100

20kg

Substrate Temperature (°C)	Primer pack (kg)	BPO catalyst (g)
0 - 5	20	1200
5 - 15	20	800
15 - 25	20	400
25 - 40	20	200

Please note:

- Weight to volumetric conversion of catalyst: 1cm³ of catalyst weighs 0.64g
- 1g of catalyst = 1.57cm³
- Substrate surface temperature may range from 0°C to 40°C
- Do not apply when surface temperature is above 40°C and/or rapidly rising. Special care must be observed if area is under exposure to direct sunshine
- Substrate temperature must be at least 3°C higher than the actual dew point.

4.4 Application

After the catalyst has been stirred in, the primer is poured onto the substrate in stripes and distributed with a short-pile paint roller. A notched rubber squeegee can be used when installing over larger areas. Apply the primer at a rate of between 300 g/m² to 500 g/m² depending on the density and porosity of the substrate.

In any case, continue applying primer until saturation occurs to obtain a continuous resin film. On extremely porous substrates a second coat of primer may be required.

When a continuous resin film is obtained and the primer has fully cured, apply the SWARCO HITEX MMA surfacing product without delay.

5 Certifications

The management system of SWARCO HITEX LTD has been assessed and registered as meeting the requirements of BS EN ISO 9001 and BS EN ISO 14001.