

PRODUCT DATA SHEET

HD ALKYD DTM 656



Description: Quick drying, high solid single pack ready to used modified alkyd primer which use on interior or exterior steel substrate and compatible with various top coats.

Recommended use: It is Suitable for Machinery, Industrial Equipment, Structure steel, Fabricated metals, Tank exterior, Plant maintenance application.

Physical Properties :

Colours/shade Nos.:	Available in all shades.
Finish:	Semi flat
Volume solids, %:	65 ± 2 %
Theoretical spreading rate:	6.5m ² /litre, 100 micron/4 mils
Flash point:	31°C
Specific gravity:	1.35 kg/litre
Surface-dry:	15 minutes at 30°C
Touch-dry:	60 minutes at 30°C
VOC content:	210 g/litre

Application details:

Version, mixed product

Single Pack

Application method:	Airless spray /Air spray/Brush
Thinner (max.vol.):	Unilay C5 Thin(10%)/ Unilay C5 Thin(5%)/Unilay C5 Thin(5%)

Nozzle orifice:	.017"-.023"
Nozzle pressure:	175 bar <i>(Airless spray data are indicative and subject to adjustment)</i>

Indicated film thickness, dry:	75 - 110micron
Indicated film thickness, wet:	
Overcoat interval, min:	According to Specification
Overcoat interval, max:	According to Specification

Safety: Handle with care. Wear Necessary PPEs like safety shoes, gloves, goggles.

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Surface preparation:	<p>New steel: Abrasive blasting to Sa 2½ (ISO 8501-1:1988). For temporary protection, if required, use a suitable shop primer. All damage of shop primer and contamination from storage and fabrication should be thoroughly cleaned prior to final painting.</p> <p>Other metals and light alloys: Thorough degreasing and (light) abrasive sweeping to remove contamination and to secure adhesion - surface profile depending on later exposure.</p> <p>Repair and maintenance: Remove oil and grease etc. thoroughly with suitable detergent. Remove salts and other contaminants by high pressure fresh water cleaning. Clean damaged areas thoroughly by power tool cleaning to St 3 (spot-repairs) or by abrasive blasting to min. Sa 2, preferably to Sa 2½ (ISO 8501-1:1988). Improved surface preparation will improve the performance. As an alternative to dry cleaning, water jetting to min. WJ-3, preferably WJ-2 (NACE No. 5/SSPC-SP 12), may be used.</p>
Application conditions:	<p>Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation.</p> <p>Use only where application and curing can proceed at temperatures above: - 5°C/23°F, preferably above 0°C/32°F.</p>
Film thicknesses/thinning: (optional)	Normal range DFT: 100- 250 micron/4-10 mils. Avoid application of excessive film thickness.
Overcoating note: (optional)	<p>Overcoating details</p> <p>If the maximum Overcoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion.</p> <p>The surface must be dry and clean prior to application.</p>
Note:	The natural tendency of epoxy coatings to chalk in outdoor exposure and to become more sensitive to mechanical damage and chemical exposure at elevated temperatures is also reflected in this product.

This Product Data Sheet supersedes those previously issued.

Data, specifications, directions and recommendations given in this data sheet represent only test results or experience obtained under controlled or specially defined circumstances. Their accuracy, completeness or appropriateness under the actual conditions of any intended use of the Products herein must be determined exclusively by the Buyer and/or User.

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