

RESICHEM 506 Aluprime

Resichem 506 Aluprime is a high solids solvent-borne epoxy coating designed to provide long term corrosion protection to the externals of new and existing steel structures even when surface preparation is restricted. The material is highly resistant to marine and industrial environments, buried conditions, effluents, salt water, most chemicals and a wide range of oils.

Typical applications

Steel structures

marine decks

steel stairways

tank externals.

Surface Preparation

1. Metallic Substrates

All oil and grease must be removed from the surface of the repair using an appropriate cleaner such as MEK.

For optimum performance, the surface should be abrasive blasted to *ISO 8501/4 Standard SA2.5 (SSPC SP10/ NACE 2)* and a minimum blast profile of 75 microns using an angular abrasive. Once blast cleaned, the surface must be degreased and cleaned using MEK or similar type material. All surfaces must be coated before gingering or oxidation occurs.

PLEASE NOTE: For salt contaminated surfaces the area must be abrasive blast cleaned as mentioned above and left for 24 hours to allow any ingrained salts to come to the surface. After this 24 hour period the surface must be washed with MEK prior to brush blasting to remove the surface salts. This process must be repeated until all ingrained contaminants have been sweated out of the surface.

Where abrasive blast cleaning is not possible (excluding salt contaminated surfaces) the surface should be roughened by MBX, needle gun or grinding. Under these conditions adhesion levels will not be optimal although still satisfactory for most applications.

Mixing and Application

Do not apply when the ambient or substrate temperature is less than 10°C or when the relative humidity is greater than 90%.

Stir the contents of the Activator and Base units to reincorporate any separated material and mix the two components together thoroughly until a uniform material free of any streaks is achieved. From the commencement of mixing the whole of the material should be used within 2 hours at 20°C (68°F) but maximum build properties are achieved early after mixing. For small volume mixes, the mixing ratio is 4:1 by volume.

Apply the mixed material onto the prepared surface by brush or roller. Apply the second coat between 8 and 24 hours after the first and where the maximum over-coating time has been exceeded the surface should be sweep blasted or lightly abraded and cleaned prior to over-coating.

The material can also be applied by airless spray using a tip pressure of 2500psi and a spray tip size of 0.015-0.018inch.

Coverage Rates

5ltrs (1.3 US gallons) of fully mixed product will give the following coverage rates –
 33m² at 150 microns 355ft² at 6mil

Please note that the coverage rates quoted are theoretical and do not take into consideration the profile or condition of the surface being repaired.

Cure Times

At 20°C (68°F) the applied materials should be allowed to harden for the times indicated below before being subjected to the conditions indicated. These times will be extended at lower temperatures and reduced at higher temperatures:

Usable life	2 hours
Movement without load or immersion	8 hours
Light loading	16 hours
Full loading/water immersion	3 days
Chemical Contact	5 days

Pack Sizes

This product is available in the following pack sizes –
5ltrs (1.3 US gallons)

Colour

Mixed material – Mid Grey
Base component – Mid Grey
Activator component – Amber

Over-coating times

Minimum - the applied material can be over-coated as soon as it is touch dry.
Maximum - the over-coating time should not exceed 24 hours.

Where the maximum over-coating time is exceeded, the material should be allowed to harden before being abraded or flash blasted to remove surface contamination.

Storage Life

5 years if unopened and store in normal dry conditions (15-30°C/ 60-86°F)

Technical Data and Performance

Volume solids	85%
Flash Point	23°C
Specific Gravity	1.30
Corrosion Resistance (ASTM B117)	5000 hours

Please see Resichem 506 Aluprime Specification Sheet for further technical and performance data.

Health and Safety

Please ensure good practice is observed at all times during the mixing and application of this product. Protective gloves must be worn during the mixing and application of this product. Before mixing and applying the material please ensure you have read the fully detailed Material Safety Data Sheet.

Legal Notice: The data contained within this Technical Data Sheet is furnished for information only and is believed to be reliable at the time of issue. We cannot assume responsibility for results obtained by others over whose methods we have no control. It is the responsibility of the customer to determine the products suitability for use. Resimac accepts no liability arising out of the use of this information or the product described herein.