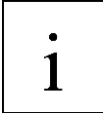


Always use correct Personal Protective Equipment

Fleetprime Hi Build

Description



Fleetprime Hi Build is a single pack modified alkyd inhibitive primer for general industrial and heavy steel chassis priming with excellent application and performance properties.

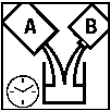
For use with the following RALI topcoats: High Solids Acrythane, Std 805 Acrythane, Spraying Enamel, on correctly prepared steel and other ferrous substrates. Ideally this product is used with RALI topcoats as mentioned above however alternative topcoats can be applied but it is highly recommended that you test a small sample area first to ensure compatibility of your particular topcoat with desirable finish and product performance.

Fleetprime Hi Build can be a substrate for many topcoats however for best results and performance of a 2K topcoat it is recommended to use 440 Industrial Primer. 2K primers for 2K topcoats will always have superior performance.

Point to Note:

All raw steel MUST HAVE Mill scale removed to white metal Sa 2.5 minimum by power tool or 30 micron anchor profile grit blasting with Garnett grade C. Fleetprime Hi Build can be used on agricultural and industrial implements and machinery also ideal for heavy steel chassis. It has excellent adhesion on a variety of substrates and works very well as a holding primer for up to 3 months if kept out of the weather.

Products



Product Type:	Modified Alkyd
Colour:	Grey
Pot Life:	N/A
Induction Time:	N/A
Recommended WFT:	100 microns WFT PER COAT at 53 sec Ford4 or 48 sec Din4 cup time.
Theoretical Coverage:	8 m ² / L this is only a guide due the varying methods of application equipment.

Properties



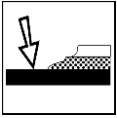
Volume Solids:	60%
Recoat-ability:	Can be recoated when fully cured or at least over night at 20 deg. For best results 1 to 5 days is recommended. This product can be left up to 3 months as a holding primer non exterior.

For best practise It is **highly** recommended that you test a small sample area first to ensure compatibility of your particular topcoat to achieve a desirable finish and satisfactory product performance. If Fleetprime Hi Build has been left for some time ie after one week it is advisable to test a small area for topcoat performance given the varying nature of many topcoats. If necessary well abrade before topcoating.

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Substrates



Fleetprime High Build can be applied over correctly prepared:

- Steel
- Galvanised Steel
- Sanded cured substrates.
- Sanded cured 2K substrates

Surface Preparation



Coating performance is in general, proportional to the degree of surface preparation. Surfaces to be painted must be clean, dry and free from all traces of contamination, corrosion and must be well abraded.

Heavy Steel:

On heavy steel with mill scale evident the substrate must be abrasive blasted with Garnett grade C to class 2.5 to 30 micron profile. The substrate should be clean white metal with no rust, mill scale, welding flux or any other surface contaminates. This exposed blasted surface should be kept in dry conditions and must not come into contact with any contaminates such as open or uncovered hands, the use of approved gloves are highly recommended. For best results this surface should have Fleetprime Hi Build applied as soon as practical or within the working day in a controlled environment such as a heated spray booth.

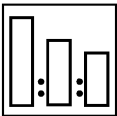
Aluminium & Galvanised Steel:

Degrease with Wax & Grease Remover. Mechanically abrade with P180 or P240 disc. Surfaces to be painted must be clean, dry and free from all traces of contamination, corrosion and must be well abraded. Using approved gloves and lint free cloths air blow and tack clean ready for primer application.

Veneer Coated Plywood & General Timbers:

Strongly advise testing a small area for coating success due to the amount of variables in veneers & timbers. Ensure substrate is dirt, dust & grease free. Depending on the particular wood substrate most can be coated on day one, left for overnight drying in warm temperatures (20°C at least) finish sand with 400 grit detail dry sand and recoated the following day.

Mix Ratios



Mixing By Volume:

Fleetprime Hi Build can be reduced from 4:1 by volume up to 7:1 by volume with Fleetprime Hi Build Reducer.

Mix Ratio: 4:1 to 7:1 BV (By Volume)

Din4 viscosity cup time: 53 sec when mixed at 7:1

Ford4 viscosity cup time: 48 sec when mixed at 7:1

Dry Film Thickness at 53 sec Din4 or 48 sec Ford4 approx 40 microns DFT per coat.

Note: If using electrostatic reducer at 7:1 BV ratio this will achieve approx 20 Mega Ohm's for electrostatic application.

Mixing By Weight:

Fleetprime Hi Build: 1000 gm

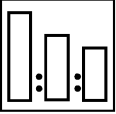
Fleetprime Hi Build Reducer: 80 gm

Mix Ratios

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Cont



RALI Electrostatic Reducer: **80 gm** (option for electrostatic application)
 Dry Film Thickness at 53 sec Din4 or 48 sec Ford4 at approx 40 microns per coat.

Point to Note:

If using electrostatic reducer at the above BW (By Weight) ratios approx 20 Mega Ohm's is achieved. Simply replace Fleetprime Hi Build Reducer with RALI Electrostatic Reducer at 80 gm per 1000 gm of primer.

Dry Time @ 20°C: Touch Dry: 1 Hour / Handle: 6 Hours 20°C

This is film build dependant and therefore a guide only.

Application Method:

Compliant & Conventional spray, air assisted airless or airless, Electrostatic.

Points to Note:

1) Not designed to give extremely long-term protection without over coating with RALI topcoats however Fleetprime Hi Build can be used as a holding primer for up to 3 months providing total film builds are sufficient.

2) When spraying, use the correct primer gun set up as recommended by your equipment supplier to achieve a dry film thickness (DFT) 50 microns above the peaks of the blast profile.

3) Application techniques should be adjusted as necessary to achieve the recommended dry film thickness. It is good practice to check this process on a small sample prior taking on a large project.

4) If you do not have a controlled environment to spray in it is good practice NOT to continue if relative humidity is above 85% and in particular if temperatures are below 15°C.

If using Electrostatic Reducer Fleetprime Hi Build can also be used through electrostatic spraying equipment however your equipment supplier would provide guidelines on appropriate resistant levels to achieve correct wrap.

Spread Rate guide:

Spraying equipment with a transfer efficiency of approx 35% you can expect a spread rate of approximately 4 to 5 m²/ litre. Compliant or HVLP equipment with a transfer efficiency rate of approx 65% can improve your spread rates up to approx 8 to 10 m²/ litre.

Remember always filter products before using them

Spray

Equipment:



Compliant & Conventional suction and gravity feed guns.

Tip Size: 1.8 – 2.5 mm

Spray pressure: 275-380KPA (40-55 psi)

Number of coats: 2 coats (5-10 minutes flash between coats)

Air less / Air assisted airless & electrostatic: Follow equipment manufacturer's recommendations.

Remarks: Do not use activated material beyond pot life time or by reducing it further to get the viscosity down again. This practice results in poor flow and adhesion failures.

Health & Safety

For detailed information refer to Safety Data Sheet (SDS). Inhalation of vapours or dust from sanding may cause respiratory sensitisation. Splashes to eyes will cause irritation.

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Contact with skin may cause irritation. Applicators should use protective clothing and air feed respiratory equipment. Product is flammable, use and store away from heat and ignition sources

Transport & Storage

Sizes:	4L
Dangerous Goods:	3A
UN:	1263
Hazchem:	3[Y]E
Packing Group:	II
Shipment name:	PAINT Flammable Liquid Low Flash Point
Flash point:	22°C

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