

Description

Archco-Rigidon PD2 Primer is normally applied to suitably prepared steel substrates (see Doc. Ref. 31A/1) as a holding primer/prefabrication primer and to prepared concrete substrates (see Doc. Ref. 31A/2) as a substrate sealer.

PD2 Primer should be applied by brush, roller, conventional or airless spray in one coat to a uniform thickness of between 25 and 50 microns

The uncatylased material must be mixed thoroughly using a mechanical whip. The material should then be catalysed according to quantity and ambient temperature. The quantity of catalyst used can vary between 1% and 4% but the ideal is 2%. Ensure the two components are fully mixed using a mechanical whip prior to application. Use **Archco-Rigidon** materials directly after mixing.

NOTE Use of less than 1% catalyst will not produce a full cure of the coating material. Inadequate mixing will lead to areas of unsatisfactory cure.

Pay particular attention to the stated pot life of the material. Clean down tools and equipment with **Archco-Rigidon T2 Cleaner** within this specified time.

Great care must be taken to avoid contaminating the primer with **T2 Cleaner** as this can have adverse effects on the cure of the material.

Inspection and Testing

Visual inspection only. Check for sags, runs and missed.

***Note:**

C3 = Butanox LPT-IN or approved equivalent

Primer Type	PD2 Primer	
Colour	Red	
Catalyst Type	Archco-Rigidon C3 or LPT-IN	
Volume Solids	98% - 99%	
Specific Gravity	1.00	
Dry Film Thickness Per Coat	25 - 50mic.	1 - 2 mils.
Theoretical Spreading Rate (per m ²)	Steel 0.06 kg Concrete 0.12 kg	
Practical Spreading Rate (per m ²)	Steel 0.15 kg Concrete 0.25 kg	
Max. Humidity During Application	90% Rh	
Min. Substrate Temperature	5°C	
Min. Dewpoint/Substrate Differential	Dewpoint +3°C	
Flashpoint	32°C	
Application Method	Brush, Roller, Conventional Spray and Airless Spray	
Airless Spray Tip Size	1500 - 2000psi 105 - 140 kg/cm ²	
Pressure at Tip	325 - 475 microns 0.031"- 0.019"	
Pot Life (20°C)	15 mins - 20 mins	
Overcoating Times at 10°C at 20°C	min. 6 hrs, max 7 days min. 5 hrs, max 5 days.	
Dilution	Not Applicable	
Tool Cleaning Solvent	T2 Cleaner	
Storage Temperature Limits	10°C – 20°C	
Shelf Life	6 Months	
Ventilation	Do not use in confined spaces without adequate ventilation or breathing equipment	
Lighting/Heating in an Enclosed Environment	Use only BASEFA Zone 1 EEx d IIA T1 or better	