



NATIONAL RED OXIDE AIR DRYING / STOVING PRIMER  
PROTECTIVE COATINGS

TECHNICAL DATA SHEET

## NATIONAL RED OXIDE AIR DRYING / STOVING PRIMER

<b>PRODUCT DESCRIPTION</b>	An air drying / stoving anti-corrosive primer based on special alkyd resin and pigmented with iron oxide red pigments. It gives excellent adhesion to metal, after air drying / stoving the painted film. The dried film gives tough and flexible coating.
<b>RECOMMENDED USES</b>	Anti-corrosive primer for steel surfaces. It can be used for air drying or stoving purpose on production line jobs. It is suitable for interior and exterior use in alkyd systems.

### TECHNICAL DATA

<b>COLOUR, DRY FILM</b>	Red - Brown
<b>FINISH, DRY FILM</b>	Smooth / Matt
<b>VOLUME SOLIDS (ASTM D2697)</b>	53 ± 2%
<b>SPECIFIC GRAVITY</b>	1.61 ± 0.05
<b>THEORETICAL SPREADING RANGE</b>	13.2 – 10.6 M <sup>2</sup> /LTR
<b>RECOMMENDED DFT RANGE (DRY FILM THICKNESS)</b>	40 – 50 Microns/Coat
<b>RECOMMENDED WFT RANGE (WET FILM THICKNESS)</b>	76 – 95 Microns/Coat
<b>FLASH POINT</b>	25°C
<b>FLEXIBILITY</b>	Good

### DRYING TIME

Drying time @ 30°C (Temperature, humidity, air movement, film thickness and number of coats all affect the drying time.)	
<b>TOUCH DRY</b>	30 – 45 minutes
<b>DRY TO RECOAT/OVER COAT</b>	10 hours (for air dry)
<b>HARD DRY</b>	24 hours (for air dry)
<b>STOVING SCHEDULE</b>	80 – 90 °C for 10 minutes

### ADVANTAGES

<b>NATIONAL RED OXIDE AIR DRYING / STOVING PRIMER</b>	It gives excellent adhesion to metal after air drying as well as stoving of the applied film. The dry film is tough and flexible.
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### APPLICATION INSTRUCTION

<b>SURFACE PREPARATION</b>	<p><u>New Steel:</u> All surfaces to be coated should be clean, dry and free from any contamination. Oil and grease should be removed by solvent cleaning as per SSPC-SP1. Abrasive blast cleaning to Sa 2.5 or mechanical cleaning using hand/power tool to minimum of St 2 standard should be done.</p> <p><u>Repair/Maintenance:</u> Existing paints system should be dry and free from salt and other contaminants. Corroded and/or damaged areas should be blast cleaned to Sa 2 or power tool cleaned to St 3.</p>
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### APPLICATION DATA

<b>APPLICATION METHOD</b>	Airless Spray	Conventional Spray	Brush
<b>CLEANING/THINNING</b>	National Toluol Thinner		
<b>THINNER (VOLUME)</b>	5 – 10%	10 – 15%	10%
<b>CONV. SPRAY REQUIREMENTS</b>	Atomizing Pressure : 50 psi		
<b>AIRLESS SPRAY REQUIREMENTS</b>	Pressure: 2000 – 2200 psi		
<b>NOZZLE SIZE</b>	0.018” – 0.020”		
<b>MIXING RATIO (BY VOLUME)</b>	Not applicable		
<b>POT LIFE @ 30°C (100 ml)</b>	Not applicable		

### SYSTEM

<b>RECOMMENDED SYSTEM</b> To be applied on prepared surface.	No. of Coats x DFT (Microns)	
	National Red Oxide Air Drying / Stoving Primer	: 1 x 40
	National Synthetic Enamel Gloss-II (For Air Drying)	: 2 x 35
	OR	
National Stoving Enamel (For Stoving)	: 2 x 40	

### ADDITIONAL DATA

<b>SHELF LIFE @ 30°C</b>	18 months, in original sealed container, with proper storage conditions.
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**HEALTH & SAFETY**

<p><b>SAFETY PRECAUTIONS</b></p>	<p>As a general rule, avoid skin and eye contact by wearing overalls, gloves, goggles, and airmask etc. Spillage on skin should immediately be removed by thorough washing with water and soap or suitable cleaner. Eye should be flushed with fresh water. Avoid inhalation of vapours and paint mist by wearing suitable airmask. In the event of ingestion and eye contact, seek medical attention immediately. Painting must be carried out in well-ventilated area.</p> <p>This as industrial product, contains flammable materials and should be kept away from ignition sources. Local safety regulations should be followed.</p>
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**STORAGE & HANDLING**

<p><b>STORAGE</b></p>	<p>Store the paint in proper storage conditions as per the local regulations. Keep the paint container in sealed condition under shed, away from direct sunlight and extreme temperatures. Do not stock paint material near to any ignition sources. Do not put back the half or unused material back in original container, containing the supplied paint, to avoid contamination. Handle with care. Stir well before use.</p>
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**NOTE:** We warranty only the quality of our product and this data sheet is based on results obtained from experience and tests. We reserve the right to change data without prior notice. For surface preparation, safety details refer specifier and safety data.

This data sheet supersedes all previous issued.  
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