

## Pilot QD Primer Aluminium

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### Product description

This is a one component oxidatively drying alkyd coating. It is a fast drying, high build, zinc phosphate pigmented product. It is an aluminium pigmented product. Can be used as primer or mid coat in atmospheric environments. Suitable for properly prepared carbon steel and aluminium substrates.

### Scope

The Application Guide offers product details and recommended practices for the use of this product.

The Application Guide (AG) must be read in conjunction with the relevant specification, Technical Data Sheet (TDS) and Safety Data Sheet (SDS) for all the products used as part of the coating system.

### Referred standards

Reference is generally made to ISO Standards. When using standards from other regions it is recommended to reference only one corresponding standard for the substrate being treated.

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### Surface preparation

The required quality of surface preparation can vary depending on the area of use, expected durability and if applicable, project specification.

When preparing new surfaces, maintaining already coated surfaces or aged coatings it is necessary to remove all contamination that can interfere with coating adhesion, and prepare a sound substrate for the subsequent product. Inspect the surface for hydrocarbon and other contamination and if present, remove with an alkaline detergent. Agitate the surface to activate the cleaner and before it dries, wash the treated area using fresh water. Paint solvents (thinners) shall not be used for general degreasing or preparation of the surface for painting due to the risk of spreading dissolved hydrocarbon contamination. Paint thinners can be used to treat small localized areas of contamination such as marks from marker pens. Use clean, white cotton cloths that are turned and replaced often. Do not bundle used solvent saturated cloths. Place used cloths into water.

### Process sequence

Surface preparation and coating should normally be commenced only after all welding, degreasing, removal of sharp edges, weld spatter and treatment of welds is complete. It is important that all hot work is completed before coating commences.

### Soluble salts removal

Soluble salts have a negative impact on the coating systems performance. Jotun's general recommendations for maximum soluble salts (sampled and measured as per ISO 8502-6 and -9) content on a surface are:

Areas exposed to (ISO 12944-2):

C1-C4: 200 mg/m<sup>2</sup>

### Carbon steel

#### Initial rust grade

The steel shall preferably be Rust Grade A or B (ISO 8501-1). It is technically possible to apply the coating to rust grades C and D, but it is practically challenging to ensure specified film thickness on such a rough surface, hence risk of reduced lifetime of the coating system.

#### Initial inspection and pretreatment

Inspect the surface for contaminations and if present, remove with an alkaline detergent. Agitate the surface to activate the cleaner and before it dries, wash the treated area by Low-Pressure Water Cleaning (LPWC) to Wa 1 (ISO 8501-4) using fresh water. Non-contaminated areas shall be washed down by Low-Pressure Water Cleaning (LPWC) to Wa 1 (ISO 8501-4) using fresh water to reduce the concentration of surface chlorides.

### Metal finishing

For areas in corrosivity category C1 to C4 (ISO 12944-2) all irregularities, burrs, slivers, slag and spatter on welds, sharp edges and corners shall conform to minimum grade P2 (ISO 8501-3) Table 1, or as specified. All edges shall have a rounded radius of minimum 2 mm subjected to three pass grinding or equally effective method. Defective welds shall be replaced and treated to an acceptable finish before painting. Temporary welds and brackets shall be ground to a flat finish after removal from the parent metal.

### Pitting repair

Pittings in steel can be difficult to cover fully with most coatings. In some areas it is practically feasible to use filler to fill pittings. This should then be done either after the initial surface preparation or after application of first coat.

### Abrasive blast cleaning

Optimum performance is achieved by dry abrasive blast cleaning to Sa 2½ or higher (ISO 8501-1) with a blast medium suitable to achieve a sharp and angular surface profile of 30-85 µm, grade Fine to Medium G; Ry5 (ISO 8503- 2).

### Cleanliness

Minimum acceptable blast cleaning standard is Sa 1 (ISO 8501-1).

### Dust contamination

At the completion of abrasive blasting the prepared surface shall be cleaned to remove residues of corrosion product and abrasive media and inspected for surface particulate contamination. Maximum contamination level is rating 2 (ISO 8502-3) as per Figure 1. Dust size no greater than class 2.

### Hand and Power Tool Cleaning

#### Power tool cleaning

Surfaces to be coated shall be prepared by mechanical preparation methods to minimum St 2 (ISO 8501-1). Suitable methods are disc grinding, hand sanding or hand wire brushing. Ensure the surface is free from mill scale, residual corrosion, failed coating and is suitable for painting. Do not use power wire brushing due to the risk of polishing the surface. The surface should appear rough and mat.

#### Water jetting

Optimum performance is achieved with preparation grade Wa 2½ (ISO 8501-4). Minimum preparation grade is Wa 1. The maximum accepted grade of flash rust for any preparation is FR M.

### Aluminium

#### Abrasive blast cleaning

Abrasive blast cleaning to achieve a surface profile using approved non-metallic abrasive media which is suitable to achieve a sharp and angular surface profile.

#### Hand and Power Tool Cleaning

After pre-treatment of welds, sharp edges, removal of weld spatter and other surface contamination the surface shall be degreased using an alkaline detergent which is agitated with non-metallic brushes and then fresh water rinsed. The cleaned surface shall be then hand or machine abraded with non-metallic abrasives or bonded fibre machine or hand abrasive pads to remove all surface polish and to impart a scratch pattern to the surface. Do not use high speed rotational sanders.

### Coated surfaces

#### Verification of existing coatings including primers

When the surface is an existing coating, verify with technical data sheet and application guide of the involved products, both over coatability and the given maximum over coating interval.

#### Over coating

The surface of previous coats shall be free from contamination by water, hydrocarbon based products, wax, mud, mortar droppings and loose, chalked and flaking coating. Inspect the surface for oil, grease and other contamination and if present, remove with an alkaline detergent. Agitate the surface to activate the detergent and before it dries, wash the treated area using plenty of fresh water. When applied on coatings past maximum over coating interval light abrading may be required to achieve proper intercoat adhesion.

#### Organic primers/intermediates

Primers/ intermediates based on alkyd or epoxy are accepted.

#### Shop primers

Before being overcoated the shop primer must be fully cured, clean, dust free, dry and undamaged. Inorganic zinc shop primers must be free of zinc salts (white rust). Corroded and damaged areas must be mechanically cleaned to minimum St 2 (ISO 8501-1).

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## Application

### Acceptable environmental conditions - before and during application

Before application, test the atmospheric conditions in the vicinity of the substrate for the dew formation according to ISO 8502-4.

#### Standard grade

Air temperature	5 - 50	°C
Substrate temperature	5 - 40	°C
Relative Humidity (RH)	10 - 85	%

The following restrictions must be observed:

- Only apply the coating when the substrate temperature is at least 3°C above the dew point
- Do not apply the coating if the substrate is wet or likely to become wet
- Do not apply the coating if the weather is clearly deteriorating or unfavourable for application or curing
- Do not apply the coating in high wind conditions

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## Product mixing

### Product mixing ratio (by volume)

Single pack

### Thinner/Cleaning solvent

Thinner: Jotun Thinner No. 7

### Application data

#### Airless Spray Equipment

Pump ratio (minimum) :	32:1
Pump output (litres/minute) :	0.9-1.5
Pressure at nozzle (minimum) :	150 bar/2100 psi
Nozzle tip (inch/1000) :	15-19
Filters (mesh) :	70-100

Material hose length :

Several factors influence, and need to be observed to maintain the recommended pressure at nozzle. Among factors causing pressure drop are:

- long paint- and whip hoses
- low inner diameter hoses
- high paint viscosity
- large spray nozzle size
- inadequate air capacity from compressor
- wrong or clogged filters

#### Other application tools

##### Brush application

Suitable for application with brush. Use a high quality, clean natural or synthetic bristle brush with proper shape and size. When used as primer coat, a stiff brush is recommended to secure proper substrate wetting. When used as a finish coat a more long haired brush is recommended to improve flow and appearance. To achieve specified dry film thickness it may be necessary to apply multiple coats.

##### Roller application

Suitable for application with roller. Use a properly sized, high quality, clean roller with natural or synthetic cover. Pre-wash new rollers in proper thinner to remove loose fibres. Roller is not recommended for application of primer coat. Addition of small volumes (5-10 %) of thinner will improve appearance when used as finish coat. To achieve specified dry film thickness it may be necessary to apply multiple coats.

## Recommended film thickness per coat

Film thickness and spreading rate	Dry film thickness	Wet film thickness	Theoretical spreading rate
	( $\mu\text{m}$ )	( $\mu\text{m}$ )	( $\text{m}^2/\text{l}$ )
Minimum	40	80	13
Maximum	125	240	4,2
Typical	75	140	7

### Wet film thickness (WFT) measurement and calculation

To ensure correct film thickness, it is recommended to measure the wet film thickness continuously during application using a painter's wet film comb (ISO 2808 Method 1A). Use a wet-to-dry film calculation table to calculate the required wet film thickness per coat.

A wet to dry film thickness chart is available on the Jotun Web site.

### Dry film thickness (DFT) measurement

When the coating has cured to hard dry state the dry film thickness can be checked to SSPC PA 2 or equivalent standard using statistical sampling to verify the actual dry film thickness. Measurement and control of the WFT and DFT on welds is done by measuring adjacent to and no further than 15 cm from the weld.

### Ventilation

Sufficient ventilation is very important to ensure proper drying/curing of the film.

### Drying process

Attempts to speed up the process by blowing hot air on to the wet paint film may lead to excessive surface drying/curing, entrapped solvents and consequently solvent blistering and inferior corrosion protection.

### Coating loss

The consumption of paint should be controlled carefully, with thorough planning and a practical approach to reducing loss. Application of liquid coatings will result in some material loss. Understanding the ways that coating can be lost during the application process, and making appropriate changes, can help reducing material loss. Some of the factors that can influence the loss of coating material are:

- type of spray gun/unit used
- air pressure used for airless pump or for atomization
- orifice size of the spray tip or nozzle
- fan width of the spray tip or nozzle
- the amount of thinner added
- the distance between spray gun and substrate
- the profile or surface roughness of the substrate. Higher profiles will lead to a higher "dead volume"
- the shape of the substrate target
- environmental conditions such as wind and air temperature

## Drying and Curing time

Substrate temperature	5 °C	10 °C	23 °C	40 °C
Surface (touch) dry	30 min	20 min	15 min	10 min
Walk-on-dry	2.5 h	2 h	1.5 h	1 h
Dry to over coat, minimum	2.5 h	2 h	1.5 h	1 h

Drying and curing times are determined under controlled temperatures and relative humidity below 85%, and at the typical DFT for the product.

Surface (touch) dry: The state of drying when slight pressure with a finger does not leave an imprint or reveal tackiness. Dry sand sprinkled on the surface can be brushed off without sticking to or causing damage to the surface.

Walk-on-dry: Minimum time before the coating can tolerate normal foot traffic without permanent marks, imprints or other physical damage.

Dried to over coat, minimum: The shortest time allowed before the next coat can be applied.

## Maximum over coating intervals for atmospheric exposure

Substrate temperature	5 °C	10 °C	23 °C	40 °C
Itself	36 h	30 h	22 h	20 h
alkyd	36 h	30 h	22 h	20 h

alkyd                      This product can be recoated with coatings containing xylene or stronger solvents before and after the given time frame.

### Other conditions that can affect drying / curing / over coating

#### Repair of coating system

Damages to the coating layers:

Prepare the area through sandpapering or grinding, followed by thorough washing. When the surface is dry the coating may be over coated by itself or by another product, ref. original specification.

Always observe the maximum over coating intervals. If the maximum over coating interval is exceeded the surface should be carefully roughened in order to ensure good intercoat adhesion. Damages exposing bare substrate:

Remove all rust, loose paint, grease or other contaminants by spot abrasive blasting, mechanical grinding, water and/or solvent washing. Feather edges and roughen the overlap zone of surrounding intact coating. Apply the coating system specified for repair.

#### Repair of damaged areas

Sags and runs can be caused by too high wet film thickness, too much thinner added or the spray gun used too close to the surface.

Repair by using a paint brush to smooth the film when still wet.

Sand down to a rough, even surface and re-coat if the coating is cured. Orange peel can be caused by poor flow/levelling properties of the paint, poor atomization of the paint, the spray gun held too close to the surface or by excessive film thickness.

This can be rectified by abrading the surface and applying an additional coat after having adjusted the application properties or the application technique.

#### Coating film continuity

When required by the specification, the coating shall be tested for film discontinuity according to ASTM D 5162, test method A or B as appropriate for the actual dry film thickness.

All recorded defects shall be repaired by best practical means.

## Quality assurance

The following information is the minimum recommended. The specification may have additional requirements.

- Confirm all welding and other metal work, whether internal or external to the tank, has been completed before commencing pre-treatment and surface preparation of the substrate
- Confirm installed ventilation is balanced and has the capacity to deliver and maintain the RAQ
- Confirm the required surface preparation standard has been achieved and is held prior to coating application
- Confirm that the climatic conditions are within recommendation in the AG and held during the application
- Confirm the required number of stripe coats have been applied
- Confirm each coat meets the DFT requirements of the specification
- Confirm the coating has not been adversely affected by rain or any other agency during curing
- Observe adequate coverage has been achieved on corners, crevices, edges and surfaces where the spray gun cannot be positioned so that its spray impinges on the surface at 90°
- Observe the coating is free from defects, discontinuities, insects, spent abrasive media and other contamination
- Observe the coating is free from misses, sags, runs, wrinkles, fat edges, mud cracking, blistering, obvious pinholes, excessive dry spray, heavy brush marks and excessive film build

- Observe the uniformity and colour are satisfactory

All noted defects should be fully repaired to conform to the coating specification.

### Caution

This product is for professional use only. The applicators and operators shall be trained, experienced and have the capability and equipment to mix/stir and apply the coatings correctly and according to Jotun's technical documentation. Applicators and operators shall use appropriate personal protection equipment when using this product. This guideline is given based on the current knowledge of the product. Any suggested deviation to suit the site conditions shall be forwarded to the responsible Jotun representative for approval before commencing the work.

For further advice please contact your local Jotun office.

### Health and safety

Please observe the precautionary notices displayed on the container. Use under well ventilated conditions. Do not inhale spray mist. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water and medical attention sought immediately.

### Accuracy of information

Always refer to and use the current (last issued) version of the TDS, SDS and if available, the AG for this product. Always refer to and use the current (last issued) version of all International and Local Authority Standards referred to in the TDS, AG & SDS for this product.

### Colour variation

Some coatings used as the final coat may fade and chalk in time when exposed to sunlight and weathering effects. Coatings designed for high temperature service can undergo colour changes without affecting performance. Some slight colour variation can occur from batch to batch. When long term colour and gloss retention is required, please seek advice from your local Jotun office for assistance in selection of the most suitable top coat for the exposure conditions and durability requirements.

### Reference to related documents

The Application Guide (AG) must be read in conjunction with the relevant specification, Technical Data Sheet (TDS) and Safety Data Sheet (SDS) for all the products used as part of the coating system.

When applicable, refer to the separate application procedure for Jotun products that are approved to classification societies such as PSPC, IMO etc.

## Symbols and abbreviations

min = minutes

h = hours

d = days

°C = degree Celsius

° = unit of angle

µm = microns = micrometres

g/l = grams per litre

g/kg = grams per kilogram

m<sup>2</sup>/l = square metres per litre

mg/m<sup>2</sup> = milligrams per square metre

psi = unit of pressure, pounds/inch<sup>2</sup>

Bar = unit of pressure

RH = Relative humidity (% RH)

UV = Ultraviolet

DFT = dry film thickness

WFT = wet film thickness

TDS = Technical Data Sheet

AG = Application Guide

SDS = Safety Data Sheet

VOC = Volatile Organic Compound

MCI = Jotun Multi Colour Industry (tinted colour)

RAQ = Required air quantity

PPE = Personal Protective Equipment

EU = European Union

UK = United Kingdom

EPA = Environmental Protection Agency

ISO = International Standards Organisation

ASTM = American Society of Testing and Materials

AS/NZS = Australian/New Zealand Standards

NACE = National Association of Corrosion Engineers

SSPC = The Society for Protective Coatings

PSPC = Performance Standard for Protective Coatings

IMO = International Maritime Organization

## **Disclaimer**

The information in this document is given to the best of Jotun's knowledge, based on laboratory testing and practical experience. Jotun's products are considered as semi-finished goods and as such, products are often used under conditions beyond Jotun's control. Jotun cannot guarantee anything but the quality of the product itself. Minor product variations may be implemented in order to comply with local requirements. Jotun reserves the right to change the given data without further notice.

Users should always consult Jotun for specific guidance on the general suitability of this product for their needs and specific application practices.

If there is any inconsistency between different language issues of this document, the English (United Kingdom) version will prevail.