

IriPrime333TM

General Description

IriPrime333TM is a two-pack polyurethane-based primer that provides excellent protection of aluminum and galvanized under the marine environment. It can be used above and under the waterline. This product can be applied to fiberglass, steel, and recoated with IRIS[®] epoxy, polyurethane, acrylic coating systems.

Product Technical Information

- Solids by volume 60 ±1 %
- Density 1.40 ±0.05 Kg /Lit
- Flashpoint >22°C
- Colors/Finish Pink / Matt
- Mixing ratio Base to Hardener 77 to 23 (by volume)
- Suitable Thinner/Cleaner IriThin88

Note: Always add thinner after mixing the components.

- Pot Life

@ 10°C	@ 23°C	@ 30°C	@ 40°C
8 hours	6 hours	4 hours	2 hours

Drying & Recoating Times

Temperature	To touch	To handle	To recoat		Full cure
			Minimum	Maximum	
@ 10°C	4 hours	24 hours	36 hours	8 days	10 days
@ 23°C	3 hours	16 hours	24 hours	6 days	7 days
@ 30°C	2 hours	12 hours	16 hours	4 days	5 days
@ 40°C	1 hour	8 hours	10 hours	3 days	4 days

Note: Drying times are dependent on air and surface temperatures as well as film thickness, ventilation, and relative humidity. Maximum recoating time is highly dependent upon actual surface temperatures, not simply air temperatures, higher surface temperatures shorten the maximum recoat window.

The surface should be dry and free from contaminants prior to overcoating. The best inter-coat adhesion is achieved when the subsequent coat is applied before the preceding coat is fully cured. After prolonged exposure times it may be necessary to roughen the surface to ensure inter-coat adhesion. When in doubt, consult your nearest **Darya Tamin** office.

Application

- **Suitable methods**

Air Spray	Airless Spray	Brush/Roller
<ul style="list-style-type: none"> • Nozzle pressure: 3-5 bar • Nozzle size: 1.2-2.0 mm • The volume of thinner: 0-10% 	<ul style="list-style-type: none"> • Nozzle pressure: 150-200 bar • Nozzle size: 0.38-0.53 mm • Spray angle: 40-80 degrees • The volume of thinner: 0-3 % 	<ul style="list-style-type: none"> • Suitable • The volume of thinner: 0-10%

- **Recommended thickness**

	Dry film thickness(μm)	Wet film thickness(μm)	Theoretical spreading rate (m ² /l)
Acceptable range	40-60	70-100	10.0-15.0
Recommended	50	85	12.0

Surface Preparation

Surfaces should be free of oil, grease, salt or other contaminants. Remove all wax, silicone, powdery or scaling rust and then clean the surface by fresh water washing.

Steel: Remove weld spatter and smooth weld seams and sharp edges as applicable. Abrasive blasting: min. Sa 2½ – ISO 8501:1. Apply IriPrime333™ as soon as possible after surface preparation to prevent any contamination.

Aluminum: Solvent cleaning according to SSPC-SP1 followed by light blast cleaning with fine grade abrasive.

Galvanizing: Remove oil or soap film with detergent then followed by light blast cleaning with fine grade abrasive.

Fiberglass: The surface should be degreased thoroughly to eliminate traces of wax, paraffin and other contaminants. Wash with high-pressure fresh water and allow thorough drying. Disc abrade to an even and matt finish. Remove dust and debris prior to painting

Application Condition

The temperature of the substrate should be at least 3°C above the dew point of the air. Temperature and relative humidity should be measured in the vicinity of the substrate. The maximum recommended surface temperature is approx. 40°C and relative humidity during application and curing should not exceed 80% . When applying the paint in confined spaces, provide adequate ventilation during application and drying. The temperature of the mixed paint should be at least 10°C.

Storage, Handling & Shelf Life

Generally, keep the paint containers in dry and cool (5-35 °C) place and away from heat or open flame. Paint containers must be kept tightly closed in the well-ventilated area and handled with care. This product's shelf life @ 23 °C is 12 months.

Environmental, Health & Safety Note

Read the material safety data sheet (MSDS) of the product before use and pay attention to safety signs attached to the product can. This product is flammable so keep away from heat and open flame.

Avoid skin and eyes by wearing overall, glove, goggles, and a suitable mask. Spillage on the skin should immediately be removed with a suitable cleanser, soap, and water. Eyes should be well flushed with water, and medical attention sought immediately. Don't discard the product on planets, sea, river and drinking water sources.

Keep out of reach of children.

Disclaimer

The information in this document is given to the best of IRIS's knowledge based on professional tests by our experts. However other factors that are affecting the use and application of this product are out of IRIS's responsibility.

For more information contact with Darya Tamin.