



ULTRACOTE LD 44 Primer

(Red Oxide Anti-Corrosive Primer)

(Paints & Coatings)

HEAVY DUTY, HIGH PERFORMANCE

GENERIC CLASS: Ultracote LD-44 Primer is a single component modified alkyd and synthetic resin pigmented with red iron oxide with special rust inhibiting properties.

PRODUCT DESCRIPTION: Ultracote LD-44 Primer is a fast drying coating suitable for use on steel substrates and exhibiting good adhesion, opacity covering, resistant to atmospheric corrosion and rust undercutting.

TYPICAL USES: Ultracote LD-44 Primer is ideal on new, slightly rusted, abrasive blasted or previously painted steel. It is use in normal industrial atmosphere, for chemical fumes, light marine service and for general weathering. Ultracote LD-44 Primer is recommended for protection of farm equipment, miscellaneous steel tanks, machinery, plant equipment, pipes, structural steel, ladders, steel building and marine structures.

LIMITATIONS: Immersion service or splash and spillage of strong acids, alkalies and solvents.

CHEMICAL RESISTANCE GUIDE:

(with recommended topcoat)

<u>Exposure</u>	<u>Splash & Spillage</u>	<u>Fumes</u>
Acids	NR	Poor
Alkalies	NR	Poor
Solvents	NR	Poor
Salt	Good	Very Good
Water	Excellent	Excellent

FLEXIBILITY: Very Good

WEATHERING: Excellent

ABRASION RESISTANCE: Good

TEMPERATURE RESISTANCE: (Dry Basis)

Sustained	:	200°F (93°C)
Intermittent	:	250°F (121°C)

SUBSTRATES: Apply over properly prepared steel, cast iron or other surfaces as recommended.

TOPCOAT REQUIRED: May be topcoated with ultracote alkyds, silicone, oil base paints or others as recommended. Recommended topcoat are the ultracote alkyd finishes.

WARNING: Do not topcoat with coatings containing strong solvents like unmodified chlorinated rubbers, vinyls and epoxies.

COMPATIBILITY WITH OTHER COATINGS:

Apply directly to substrate. May be applied over other alkyds, chlorinated rubbers, epoxies and most single package paints.

CALCULATED VOLUME SOLIDS:

Ultracote LD-44 Primer 43%± 2%

RECOMMENDED DRY FILM THICKNESS PER COAT:

1.5 - 2.5 mils (37.5 - 62.5 microns)

CALCULATED COVERAGE PER GALLON:

689.72 sq.ft. (16.94 sq. m./li. @ 25 microns)
460 sq.ft. @ 1.5 mils (11.29 sq.m./li @ 37.5 microns)
276 sq.ft. @ 2.5 mils (6.78 sq. m./li. @ 62.5 microns)

NOTE: Assume loss factor when estimating job requirements at prevailing condition.

SHELF LIFE: One year minimum. Material on stock shall be turned upside down every 4-6 months.

COLORS: Red, Gray

FINISH: Flat

COMPONENT: One

FLASH POINT: (Pensky-Martens Closed Cup)

Ultracote LD-44 Primer	105°F (41°C)
Ultracote Thinner #63	105°F (41°C)

SURFACE PREPARATION: Remove any oil or grease from surface to be coated with clean rags soaked in Ultracote Thinner #2 or tuluol.

STEEL: Hand tool cleaning per SSPC-SP3 for normal requirements. Where prolonged jobsite exposure will occur, commercial blast cleaning per SSPC-SP6 to a degree of cleanliness in accordance to NACE #3 to obtain a profile of notless than 1.5 mils (37.5 microns) may be preferred alternate.

ALLOY STEEL, GALVANIZED STEEL AND NON-FERROUS METALS: Chemically clean surfaces in accordance with SSPC-SP-1 (Solvent Cleaning). Abrasive "brush blast to provide a lightly profiled and etched surface.

WELDING: Welding should precede coating. In the even welding or flame cutting is performed on metal already coated with this product, do so in accordance with the latest instruction in USA Standard Z49:1 "Safety in Welding and Cutting". All welded, burned or otherwise damaged areas should be cleaned to base metal, prepared and recoated as specified.

PREVIOUSLY PAINTED SURFACES: All surfaces must be thoroughly clean, dry and free from dirt, rust, grease and loose paint flake. Lightly sand the surface prior to painting. Loose flaking paint must be scraped off to a firm edge and defective areas must be sanded down to the substrate and primed with the appropriate primer before overcoating.

MIXING: Mix thoroughly to homogenous consistency before application.

THINNER: Thin up to 5% by volume with Thinner #63 or Thinner #6. Do not overthin!

APPLICATION TEMPERATURES:

Materials	:	50-90°F (10-32°C)
Surfaces	:	55-90°F (13-32°C)
Ambient	:	55-100°F (13-38°C)
Humidity	:	30-95%

Do not apply when the surface temperature is less than 5°F (2°C) above the dew point.

SPRAY TECHNIQUE: Use adequate air volume for correct operation. Hold gun 8-10 inches from the surface and at a right angle to the surface. Use 50% overlap with each pass. On irregular surfaces, coat the edges first, making an extra pass later.

APPLICATION EQUIPMENT: Air or airless spray, brush or roller

AIR SPRAY: Use 3/8" minimum I.D. material hose.

<u>Mfr. & Gun</u>	<u>Fluid Tip</u>	<u>Air Cap</u>
Binks #18 or #62	66	66PE
DeVilbiss MBC or JGA	E	704
Approx.: .07" I.D.		
Atomizing Pressure: 10-20 psi.		

NOTE: Low temperature or longer hose requires higher pot pressure.

AIRLESS SPRAY: Use 3/8" minimum I.D. material hose.

<u>Mfr. & Gun</u>	<u>Pump</u>
Graco 205-591	President 30:1 or Bulldog 30:1
DeVilbiss JGB-507	QFA-514
Binks Model 500	Mercury 5C
Atomizing Pressure: 1,800-3,000 psi.	
Manifold Filter: 60 Mesh	
Tip Orifice: 0.013" - 0.019"	
Teflon packings are recommended.	

BRUSH OR ROLLER: Use medium bristle brush or short nap roller.

DRYING TIME:

75-90°F (24-32°C) and 50% RH @ 2 mils.	
To Touch	: 1-2 hrs.
To Recoat	: 3-4 hrs.
Dry Hard	: 24 hrs.
Final Cure	: 3 days

CLEAN-UP: Use Ultracote Thinner #2 or xylol.

STORAGE CONDITION:

Temperature	:	35°F (2°C) to 110°F (43°C)
Humidity	:	0 - 100%

PACKAGING: Gallon (3.785 liters)
Pail (4 & 5 Gallons)

SAFETY INFORMATION: This product (and any recommended thinners) contains solvents and/or other chemical ingredients. Adequate health and safety precautions should be observed during storage, handling, application and curing. Keep away from sparks, heat and open flame and use necessary safety equipment such as air mask, non-sparking tools and ladders, etc. When working in tanks, rooms and other enclosed spaces, adequate ventilation must be provided. Keep out of reach of children.

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