



IRABOND 9924

PRODUCT INFORMATION

Description	A two component spray applied corrosion resistant etch primer developed for use on most metallic substrates.	Features	• Holding primer
Recommended Applications	A metal primer suitable for any of the Irathane and Aqualine range which are to be applied onto Mild and Stainless Steel substrates, aluminium and other alloys. (in house testing is recommended where data is not currently available)	Package Size	5L

PRODUCT DATA

Physical Properties	A	B	Mixed
	Colour	Red	Colourless
Flash point (°C)	19	22	19
Mix Ratio by Volume	1	1	
Mix Ratio by Weight	1.12	1	
Solids by Volume (%)	18 +/- 5		
Coverage (m²/L)	8-12		
	10°C	20°C	30°C
Standing time after mixing (Minutes)	15	15	15
Pot Life / Maximum (Hours)	8	8	8



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APPLICATION INFORMATION

Surface Preparation

Proper surface preparation is essential to a successful application. The following procedures should be considered :

- All surfaces must be dry and clean.
- If surface is oily or greasy, use MEK to degrease the surface.
All surfaces must ideally be grit blasted to SA 2 ½ or better in accordance with SIS 055900 or NACE specification Number 2.. Where this is not possible then grinding with a coarse wheel or disc is a suitable alternative.
- Metal that has been handling sea water or other salt solutions should be grit blasted and high pressure water blasted and left overnight to allow any salts in the metal to 'sweat' to the surface. Repeat blasting may be required to 'sweat out' all the soluble salts. A test for chloride contamination should be performed prior to any application. The maximum soluble salts left on the substrate should be no more than 40 p.p.m. (parts per million).

See relevant Method statement for comprehensive information on surface preparation required.

Mixing

Use a spark proof variable speed electric drill fitted with a spiral or Jiffy type mixing paddle. Stir part A for 2 minutes before decanting, add part B then mix thoroughly and leave to stand for 15 minutes. If thinning is required then just prior to application mix in to 20% by volume of either MEK or MIBK. MIBK is recommended as MEK evaporates very rapidly at elevated temperatures.

Application

Application is best made using air assisted or airless spray. The correct thickness has been applied when the substrate is fully wetted, a second coat is not recommended as once dry although the 9924 may look as though it has not been applied at a sufficient rate it can be deceptive and too much primer can cause adhesion problems.

Irabond UU55 or UU52 intercoat adhesive will be required prior to overcoating, see relevant method statement for more detail.

	10°C	20°C	30°C
Minimum overcoat time (Minutes)	80	60	45
Maximum overcoat time (Days)	28	28	28
Reblast + reapply (Days)	>28	>28	>28

Cure

Overcoat times are stated in the above table. If after application the primed parts are maintained in a clean environment or sealed from the atmosphere then a 3 month maximum overcoat time is possible.

Clean Up

All equipment should be thoroughly cleaned directly after use using EC19, MEK or suitable alternative.

Shelf life & Storage

A shelf life of 12 months from date of shipment can be expected when stored in dry conditions at room temperature (~22°C) in their original containers.

Precautions

For complete safety and handling information, please refer to Material Safety Data Sheets prior to using this product.

Warranty

Irathefutura will replace any material found to be defective. Because the storage, handling and application of this material is beyond our control we can accept no liability for the results obtained.

