



Red Iron Oxide Primer (WB419P1)

Material	Pounds	Gallons
A Side		
Epi- Rez 5522-WY55	383.67	42.00
Dowanol PM	4.53	0.59
Benzyl alcohol	8.79	1.01
De-Fo PI-4	3.51	0.42
DI Water	75.10	9.00
Mica-325	8.23	0.35
10ES Wollastekup	108.00	4.46
HALOX SW-111	98.23	4.13
Kroma Red RO-4097	73.10	1.82
Zeospheres 400	73.10	3.65
Blanc Fix-N	73.10	1.99
<i>High speed disperse to a texture of ~5-7 N.S., then add:</i>		
Epi- Rez 5522-WY55	82.26	8.98
DI Water	13.34	1.60
Total A Side	1004.96	80.00
B Side		
Anquamine 419	61.30	6.80
Dowanol PM	18.00	2.35
Glacial acetic acid	0.37	0.05
DI Water	90.10	10.80
Total B Side	169.77	20.00

Typical Properties

Stoichiometry	1.9
Mix Ratio (A:B, volume)	4:1
PVC	34.9
VOC (lbs/gal)	1.45
VOC (g/l)	174.0
Wt Solids %	62.2
Vol Solids %	47.1
Pigment: Binder Ratio	1.48:1
Pot Life (hrs)	6
Tack Free Time (mins)	15
Hard Dry Time (hrs)	2
Cross Hatch Adhesion	5B
Pencil Hardness (overnight)	6B
Pencil Hardness (7 days)	HB
¼" Mandrel bend	Pass
Direct Impact Resistance (in lbs)	140
Reverse Impact Resistance (in lbs)	100

Anquamine 419 Primer Corrosion Resistance		
Salt Fog	Field	Scribe
1000 hours	10	10
2000 hours	10	9
3000 hours	9	8
Prohesion		
500 hours	10	10
1000 hours	10	8
2000 hours	10	4
Cleveland Humidity		
1000 hours	10	10
1500 hours	9	10
2000 hours	8	10

Corrosion Testing:

- 3-4 mil DFT (2 coats, 16-24 hour re-coat)
- 14 Day Cure at 25°C/50% Relative Humidity
- Salt Fog B117, Prohesion B84-94
- Cleveland Humidity (continuous exposure 43°C)
- Blisters, Scribe Creep D1654 Rating
- Electrochemical Impedance Spectroscopy (EIS)

Coatings spray applied to Grit Blasted Steel Panels-Dry
 Film Thickness 3.5-4.0 mils. Above ratings based on
 ASTM standards.