



HI-ALKYD 1401 RED OXIDE HB PRIMER

TECHNICAL DATA SHEET

PRODUCT DESCRIPTION

Hi-Alkyd 1401 Red Oxide HB Primer is a one-pack, high build, and fast-drying alkyd based primer pigmented with red iron oxide for protection of structural steel in industrial environments.

INTENDED USE

It is designed for use as a high quality anti-corrosive alkyd primer on fabricated structures, equipment, machinery, pipes and other ferrous metal surfaces such as gates and fences.

GENERAL PROPERTIES

Colour	: Reddish Brown
Gloss Level	: Matt
Volume Solids, %	: 50 ± 2 %
Specific Gravity	: 1.39 kg/l
Flash point	: 23°C
VOC	: 420 g/L (EPA Method 24)
Typical Thickness	: 50 – 100 µm dry film : 100 – 200 µm wet film

SURFACE PREPARATION

All surfaces should be clean dry, and free from contamination. The surface should be assessed and treated in accordance with ISO 8504. Oil or grease should be removed in accordance with SSPC-SP1 solvent cleaning.

Abrasive Blast Cleaning

Abrasive blast cleaning to Sa 2½ (ISO 8501-1:2007) or SSPC-SP6. For optimum performance, blast cleaned to SSPC-SP10 with a surface profile of 25 – 50 microns (1 – 2 mils). If oxidation has occurred between the blasting and application of this product, the surface should be re-blasted to the specified visual standard. Surface defect revealed by the blast cleaning process should be ground, filled or treated in the appropriate manner.

Hand or Power Tool Preparation

Hand or power tool clean to a minimum St3 (ISO 8501-1:2007) or SSPC-SP3 for atmospheric use only. Note, all scale must be removed and areas which cannot be prepared adequately by chipping or needle gun should be spot blasted to a minimum standard of Sa 2 (ISO 8501-1:2007) or SSPC-SP6.

Other Surfaces

The coating may be used on other substrates. Please contact your local Nippon Paint office for more information.



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CONDITION DURING APPLICATION

Avoid paint application when the temperature is below 10°C and relative humidity is above 85%. The temperature of steel surface must be minimum 3°C above dew point of surrounding air.

APPLICATION GUIDE

Mixing : Mixed thoroughly before use with a power agitator.

Theoretical Coverage : 10.0 m²/litre at 50 µm DFT
5.0 m²/litre at 100 µm DFT

Thinner : Hi-Pon Alkyd Thinner

APPLICATION METHOD

Conventional air and airless spray are recommended for application. Brush and roller are recommended for stripe coating and small areas. Care must be taken to achieve the specified dry film thickness.

APPLICATION DETAILS

Airless Spray : Tip Size : 0.015" – 0.021"
Pressure at nozzle : 160 - 210 kg/cm²

Typical Thickness : 50 – 100 µm dry film
: 100 – 200 µm wet film

Drying Time	Substrate Temperature	25 °C	40 °C
	Surface Dry	15 mins	10 mins
	Through Dry	50 mins	30 mins
	Dry to recoat (min)	1.5 hrs	1 hr
	Dry to recoat (max)*	Extended	

The given data must be considered as guidelines only. The actual drying time/times before recoating may be shorter or longer, depending on film thickness, ventilation, humidity, underlying paint system, the requirement for early handling and mechanical strength etc. A complete system can be described on a system sheet, where all parameters and special conditions could be included.

* Where an "extended" overcoating time is stated, consult Nippon Paint Protective Coatings for recommended surface preparation to achieve optimal intercoat adhesion.



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RECOMMENDED PAINTING SYSTEM

The following coating systems are recommended for Hi-Alkyd 1401 Red Oxide HB Primer :

Top Coat:

- Hi-Alkyd 1501 Alkyd Top Coat
- Hi-Acryl 1901 Acrylic Top Coat
- Hi-Acryl 1902 Acrylic Top Coat
- Hi-Pon 40-04 Epoxy Top Coat
- Hi-Pon 50-01 Polyurethane Top Coat

NOTE: Epoxy and Polyurethane Top Coats can only be applied over primed surfaces aged for 30 days or more.

For the choice of a coating system for different application, refer to the product brochure or contact Nippon Paint for professional recommendation.

PACKAGING

Unit	Vol	Container Size
20 L	20 L	20 L

STORAGE

Shelf life : 12 months (25°C)

Subject to re-inspection thereafter. Higher temperature during storage may reduce the shelf life and may lead to gelling in the tin. Frequent temperature cycles may also shorten the shelf life.

Store in tightly closed container in a dry, cool and well ventilated space, keep away from sources of heat and ignition.

SAFETY PRECAUTION

- This product is intended for use by professional applicators. Refer to the safety information display on the container and in the safety data sheet (SDS) before using the product.
- Use this product in well-ventilated area, avoid skin contact, spillage on the skin should immediately be removed with suitable cleanser, soap and water.
- Eye should be well flush with water and seek for medical attention immediately upon contact with this product.
- During the application, naked flame, welding operation and smoking is not allowed. Adequate ventilation should be provided.
- If you have any doubt regarding the suitability of use, refer to Nippon Paint for further advice.



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DISCLAIMER

The information in this data sheet is given to the best of Nippon Paint's knowledge and practical experience. Users may consult with Nippon Paint on the general suitability of the product for their needs and specific application practices though it remains each user's responsibility to determine the suitability of the product for the user's particular use. The condition of the substrate and application are not within Nippon Paint's control. Therefore no implied conditions, warranties or other terms will apply to the Product. Nippon Paint does not and cannot warrant the results which the user may obtain by using the product. In no event will Nippon Paint be liable to the user for any kind of loss (whether direct or indirect) even if Nippon Paint was previously advised of it. In line with Nippon Paint's policy for continuous development, Nippon Paint reserves the right to modify the product and the information in this data sheet without prior notice. It is the user's responsibility to check with Nippon Paint for the latest version of this data sheet. This data sheet has been translated into various languages. In the event of any inconsistency, the English version shall prevail.