

## ACTIVE RUST PRIMER 662 SG - APPLICATION INSTRUCTIONS

Active Rust Primer 662 SG is a surface-tolerant coating with special properties as a repair primer. Applied on rusty steel surfaces, the primer penetrates and reacts chemically with solubilized ferric ions as well as with Fe in the rust layer, forming an extremely stable insoluble complex compound with Fe. The primer may also be applied directly to bare steel and can be applied to most types of primers and existing coating systems.

It may also be applied over damp substrates. Surface must be free from water droplets. Use rags, towels or other cloth/paper material to remove water droplets on surface.

Refer to the Product Data Sheet for detailed properties and uses.

### Surface Preparation

Remove all thick rust scale, loose rust, dirt, oil, grease and other contaminants from the surface. Use power or hand tools to clean in accordance with SSPC-SP3. Flush prepared area with plenty of fresh water to reduce salt crystals and contaminants. Flash rust or cleaned brown tightly adhered rust may be present when applying the primer.

Use of high pressure water cleaning is excellent. Pressure wash at 5000-10000 psi, depending on the surface condition. Water-based detergents can be used. Always flush with fresh water after detergents or other degreasing agents have been used. Do not use inhibitors.

Surface steel profiles: a semi-polished surface is acceptable. If using an abrasive blast (or equivalent) use the finest abrasive grade available and work at an angle of 30–45 degrees. Active Rust Primer 662 SG will adhere to a near polished surface. Unlike most coatings, ARP 662 SG does not depend on a substrate's "anchoring".

### Environmental Conditions

Air temperature 1° C [34° F] and 40° C [104° F]  
Steel temperature 1° C [34° F] and 40° C [104° F]  
Steel temperature must be at least +1°C (34 F) above dew point.  
RH can be up to 95 %.

### Application Equipment

The primer can be applied with conventional or airless spray equipment, brush or roller.

Airless spray:	nozzle	0.015"-0.018"
	angle	50°-65°
	air pressure	1200-1800 psi

Ensure good ventilation when applied in confined areas to assist evaporation and curing.

### Application Procedure

Active Rust Primer 662 SG is a stable liquid and needs no stirring before use. Just turn the drum upside down and rock back and forth 8-10 times before opening. The primer is single-component - no mixing required. Do not dilute and never use thinner.

Before use pour ARP into non-metallic container. Never pour unused portion back or dip brush directly into original container. The drum may be opened and closed.

Pot life: 12 months after opening.

1. Flush equipment with fresh water before use.
2. Work primer well into surface while wet. It dries quickly, therefore, do not rework after the drying process has started. Stripe coat all welds, rough spots, sharp edges and corners, etc. Apply a wet coat in even, parallel passes. Overlap each pass 50% to avoid bare areas, pinholes and voids.
3. We recommend application of 1 coat of approx. 1-1.5 mil DFT for regular use, 1.5-2 mils DFT for marine/heavy usage. Allowable range is 1-3 mils DFT. Do not recoat before coat has dried at least 1-3 hours. The application of a wet film thickness of 2-3 mils will normally provide 1-1.5 mils DFT (regular)/ 3-4 mils wet = 1.5-2 mils DFT (marine).
4. Repair larger areas with spray. Do not overspray. Work can be interrupted with no deterioration in quality.
5. Touch up random pinholes, voids, small damages or bare areas by brush when film is dry to handle.
6. Clean all equipment immediately after use with water.

Leave 12-24 hours to cure before applying top coat.

### Safety

Active Rust Primer 662 SG does not contain any organic solvents and therefore does not present the dangers normally related to solvents. It is non-toxic and nonflammable, classified as non-hazardous. If used in confined areas, maintain adequate ventilation and sufficient fresh air during application and drying. A dust mask is sufficient when exposed to mist. For further details - see Material Safety Data Sheet.

### Shelf life

36 months without opening.