
BITUMINOUS PAINT FOR DIP COATING

Parsibitu 2791D4

DESCRIPTION

* Bitumen based solvent born primer according to DIN 30674 part 4. It is adjusted to meet high speed coating requirement for various dip coating procedures.

USES

- * Top coat of paint systems for buried cast iron pipes consisting of a zinc rich primer and bituminous paint.
- * For inexpensive short to medium term anticorrosive protection of interior and exterior steelwork .
- * As a primer on cast iron surfaces and fittings .

FEATURES

- * Excellent compatibility to various primers.
- * High speed dip is possible.
- * High build.
- * Water proofing.
- * Excellent applicability.
- * Excellent flexibility.
- * Economical.

TECHNICAL DATA

Finish	Flat
Colour	Black
Specific gravity (at 20 °C , Mix)	1.18 ± 0.05 (gr/cc)
Volume solid	54 ± 2 %
Recommended DFT	70 - 90 (mic)
Flash point	23 °C
Shelf life (at 20 °C)	12 months
Package	Drum, others on request

SURFACE PREPARATION

- 1. When apply on a primer :**
 - The surface should be dry and free of all contaminations.
 - Remove any dust, oil and moisture from last coat.
- 2. When apply as a primer :**
 - can be applied on cast iron surfaces without preparation.
 - can be applied on steel with low degree surface preparation.
 - blasting the cast iron and steel greatly improves the results.

RECOMMENDED PAINT SYSTEMS

P : 7411 ¹ , 4424 (all series) OR zinc metal spray	50 - 70	micron
P & T : 2795D4	70 - 90	micron

¹ See note J when selecting or using zinc ethyl silicate .

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APPLICATION DATA

Method Dip Method , Brush (Just for touch up)
Thinner / Cleaner T - 213 **Package: 215 Kg in Drum**

- Depending on dip situation and environment temperature, the type of thinner might be changed.

Theoretical Coverage :

Dry film thickness (mic)	70	80	90
Coverage (m ² / lit)	7.71	6.75	6.00
Coverage (m ² / kg)	6.54	5.72	5.08

Touch dry (70 mic , 20 °C) 1 hr

Tack dry (70 mic , 20 °C) 4 hrs

- At higher dry film thickness, lower temperature and poor ventilation drying time will be longer.
- Application in closed area results in long touch & tack drying time and therefore longer minimum intervals. So sufficient air draft is required for maintaining normal application condition.

Recoating interval :

Surface temperature	10°C	20°C	30°C
Min. Interval (hrs)	6	4	3
Max. Interval (days)	Extended	Extended	Extended

- Extended : **See note E**
- The minimum required time for testing air drying alkyd paint is 10 -14 days in 20 °C.

APPLICATION INSTRUCTIONS

- * Check all equipments are dust, oil and moisture free. If needed , flush with cleaner thinner.
- * It is recommended to use the paint with the temperature above 15°C, otherwise more thinner would be required to reach the application viscosity. Too much thinner may results in sagging, low thickness and poor hiding. In cold seasons it is recommended to keep the paint at a warmed up storage at least 3 days before use.
- * Stir the paint well by a power mixer to a homogenous stick mixture before use.
- * Thin the paint with defined thinner depend on required thickness & application viscosity then mix it again.
- * If you need to spray paint instead of the dipping process, you can use the following instructions.

The given data could be adjusted by applicator in practical situation by his own actual trial.

	Pressure (atm)	Orifice	Tip Range	Thinner (vol%)
Air spray	4 - 6	1.5 - 3 mm		15 - 25
Air less	5 - 7	19 - 23 mic	219 - 323	5 - 15
Brush / Roller	Suitable for small areas only .			

SURFACE TEMPERATURE

Must be at least 3°C above dew point, apply the coats when surface temperature is from 10°C to 40°C. Please contact Parsifam if the substrate temperature is lower or higher.

SAFETY

- ▲ Due to high flammability , keep away the paints from heat , sparks and flames.
- ▲ Avoid contact the paints with eyes and skin.
- ▲ Use mask & gloves and provide suitable ventilation for the reasons of health and safety.

REMARKS : The information submitted in this data sheet is based on our best current knowledge and experiences. The ultimate performance of this coating is quite related to quality of surface preparation, application procedure and conditions and even storage conditions that limit our liability to the submitted figures in technical and application data .