

## Description

**Archco-Rigidon PD2 Primer** is normally applied to suitably prepared steel substrates (see Doc. Ref. 31A/1) as a holding primer/prefabrication primer and to prepared concrete substrates (see Doc. Ref. 31A/2) as a substrate sealer.

**PD2 Primer** should be applied by brush, roller, conventional or airless spray in one coat to a uniform thickness of between 25 and 50 microns

The uncatalysed material must be mixed thoroughly using a mechanical whip. The material should then be catalysed according to quantity and ambient temperature. The quantity of catalyst used can vary between 1% and 4% but the ideal is 2%. Ensure the two components are fully mixed using a mechanical whip prior to application. Use **Archco-Rigidon** materials directly after mixing.

**NOTE Use of less than 1% catalyst will not produce a full cure of the coating material. Inadequate mixing will lead to areas of unsatisfactory cure.**

Pay particular attention to the stated pot life of the material. Clean down tools and equipment with **Archco-Rigidon T2 Cleaner** within this specified time.

Great care must be taken to avoid contaminating the primer with **T2 Cleaner** as this can have adverse effects on the cure of the material.

## Inspection and Testing

Visual inspection only. Check for sags, runs and missed.

Primer Type	PD2 Primer	
Colour	Red	
Catalyst Type	Archco-Rigidon C3	
Volume Solids	98% - 99%	
Specific Gravity	1.02	
Dry Film Thickness Per Coat	25 - 50mic.	1 - 2 mils.
Theoretical Spreading Rate (per m <sup>2</sup> )	Steel 0.06 kg Concrete 0.12 kg	
Practical Spreading Rate (per m <sup>2</sup> )	Steel 0.15 kg Concrete 0.25 kg	
Max. Humidity During Application	90% Rh	
Min. Substrate Temperature	5°C	
Min. Dewpoint/Substrate Differential	Dewpoint +3°C	
Flashpoint	32°C	
Application Method	Brush, Roller, Conventional Spray and Airless Spray	
Airless Spray Tip Size	1500 - 2000psi 105 - 140 kg/cm <sup>2</sup>	
Pressure at Tip	325 - 475 microns 0.031"- 0.019"	
Pot Life	40 mins - 60 mins	
Overcoating Times	6 hrs - 21 Days Dependent on Temperature	
Dilution	Not Applicable	
Tool Cleaning Solvent	T2 Cleaner	
Storage Temperature Limits	10°C – 20°C	
Shelf Life	6 Months	
Ventilation	Do not use in confined spaces without adequate ventilation or breathing equipment	
Lighting/Heating in an Enclosed Environment	Use only BASEFA Zone 1 EEx d IIA T1 or better	