



Approved Quality
Management System
AS/NZS ISO 9001:2008
Lloyds Register-Certificate
No. MEL 0927759

Technical Data Sheet
PRIMER D
(Bitumen Primer)

Description:	A brush or spray applied bitumen based adhesive primer . For use on new, power brushed, or abrasive blasted pipe work to condition the surface prior to the application of Denso bitumen adhesive tapes. For corrosion prevention of pipelines and field joints.
Composition:	Bitumen based resin and tackifying adhesion promoters dissolved in solvent based vehicles.
Characteristics:	<ul style="list-style-type: none"> • stable over a wide temperature range, non hardening or cracking • highly resistant to mineral acids, alkalis and salts • will adhere and remain attached to all cleaned, sound, dry metal surfaces • resists degradation in aggressive industrial and climatic conditions
Uses:	The primer is designed to promote the adhesion of bitumen tapes to steel pipelines, joints and fittings for the purpose of corrosion prevention and mechanical protection. Fills minor blemishes in substrate surfaces. Used in conjunction with the Denso bitumen adhesive tape range which include Densopol, Ultraflex, Ultraseal and Densoseal tapes.
Surface Preparation:	Prepare steel to St2 (power brushed) / AS1627 P.2 (minimum) if required. Edges on existing adjacent coatings should be chamfered to remove step down. Approximately a 100mm band of the pre-existing factory coatings should be abraded and solvent (toluene) degreased either side of joint.
Application:	Thoroughly stir the primer in its container to ensure uniformity prior to use. Apply an even coating at a rate of 9 to 11 m ² / litre by brush, sponge roller or spray over new, previously power brushed, or abrasive blasted surface. For maximum performance allow surface to tack dry to a sticky state before applying mastic or tape (10 to 20 minutes). Ensure mastic or tape is applied when primer is still tack dry. Wet Film Thickness: 90-110 µm, Dry Film Thickness: 45-60 µm
Recommended Temperatures:	Application: 0 to + 55 °C Service: - 20 to + 65 °C Peak: + 75 °C
Shelf Life: Storage:	2 years In cool, dry, ambient conditions, in original cartons away from heat and direct sunlight.
Available Sizes:	1 Litre, 9/carton 4 Litre, 4/carton

Physical Properties:	Test	Test Method	Units	Value
	Solids Content	ISO 1515	%w/w	50 ± 4
	Specific Gravity @ 15°C	ASTM 1475	-	0.94
	Brookfield Viscosity Spindle # 1 at 30 RPM	ASTM D2196	cps	200 ± 50
	Flash Point	ASTM D92	°C	12