



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

**Technical Data Sheet**  
**PRIMER D**  
**(Bitumen Primer)**

<b>Description:</b>	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 and to promote adhesion of bitumen tapes to concrete.
<b>Composition:</b>	Bitumen based resin dissolved in solvent based vehicles.
<b>Characteristics:</b>	<ul style="list-style-type: none"> <li>• stable over a wide temperature range, non hardening or cracking</li> <li>• highly resistant to mineral acids, alkalis and salts</li> <li>• will adhere and remain attached to all cleaned, sound, dry metal and concrete surfaces</li> <li>• resists degradation in aggressive industrial and climatic conditions</li> </ul>
<b>Uses:</b>	The primer is designed to promote the adhesion of bitumen tapes to steel pipelines, concrete surfaces/culverts and fittings. Fills minor blemishes in substrate surfaces. Used in conjunction with the Denso bitumen adhesive tape range which include Densopol, Ultraflex, Ultraseal, Conforming and Densoseal tapes.
<b>Surface Preparation:</b>	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 100 mm band of the pre-existing factory coatings should be abraded and solvent (toluene) degreased either side of joint. Note: concrete surfaces must be well cured and dry with all loose material removed from surface
<b>Application:</b>	Thoroughly stir the primer in its container to ensure uniformity prior to use. Apply an even coating at a rate of 9-11 m <sup>2</sup> /L by brush, sponge roller or spray over new, previously power brushed, or abrasive blasted surface or dry/clean concrete. 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 Concrete may require two coats depending on the porosity
<b>Recommended Temperatures:</b>	Application: 0 to + 55°C Service: - 20 to + 65°C
<b>Shelf Life:</b> <b>Storage:</b>	2 years In cool, dry, ambient conditions, in original cartons away from heat and direct sunlight.
<b>Product code / Available sizes:</b>	B360001: 1 Litre (9/carton) B360004: 4 Litre (4/carton) B360020: 20 Litre pails

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	cP	200 ± 50
	Flash Point	Abel IP 170	°C	> 24

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