



**MAKEYD PF 204
Alkyd Primer Finish**

PRODUCT DESCRIPTION Primer finish is an effective and efficient anti corrosion paint, both as primer and finish .

RECOMMENDED USE Anti corrosion alkyd primer finish,protective coating for all types of steel construction and steel components in midly to moderately corrosive environment.

- CHARACTERISTIC**
- Good hiding power.
 - Good weather resistance.
 - No leaving brush mark.
 - Smooth surface.
 - Easy to apply.

- APPLICATION DATA**
- **Colour** : Available on request
 - **Gloss level** : Gloss
 - **Specific Gravity** : 1.00 ± 0.02 kg/ltr
 - **Volume Solid** : 46 ± 2%
 - **Dry Film Thickness** : 40 microns per coats
 - **Theoretical Coverage** : 11.5 sq.m/ltr for 40 microns
 - **Drying Time** :

| Temperature | Touch Dry | Hard Dry |
|-------------|------------|----------|
| 26°C | 60 minutes | 12 hours |
| 32°C | 45 minutes | 11 hours |
| 36°C | 30 minutes | 10 hours |
| 40°C | 20 minutes | 9 hours |

- **Full Cure** : -
- **Painting Interval** : Min : 3 Hours, Max Unlimited.
- **VOC** : Max. 389 g/ltr
- **Flash Point(DIN 53213)** : 39°.
- **Pot Life** : -
- **Service Temperature** : Continuous : 60°C ; Periodic : up to 90°C.
- **Shelf Life** : 12 months (cool and dry place)

SURFACE PREPARATION Steel : blast cleaned in situ to at least SSPC – SP10 and free from rust, scale, shop primer and any other contamination.

CONDITION OF APPLICATION Temperature ; minimum 10°C : maximum 50°C.
Relative Humidity maximum 85%.
Substrate temperature should be at last 3°C above dew point.

INSTRUCTION FOR USE Stir well before use, preferable by mechanical mixer to ensure good homogenelty.

APPLICATION DETAILS

| Method Application | Airless Spray | Air Spray | Roller Brush |
|--------------------|--------------------|----------------|--------------|
| Thinner No | MAKE 902 | MAKE 902 | MAKE 902 |
| Volume of Thinner | Max 10% | Max 15% | Max 5% |
| Nozzle orifice | 0.017 (0.43m) | 2 mm | - |
| Nozzle Presure | 150 bar (2100 psi) | 4 bar / 57 psi | - |
| Cleaning Solven | MAKE 10 | - | - |

STORAGE & HANDLING The product must be stored in accordance with national regulation. Storage conditions are to keep the containers in a dry, cool, well ventilated space and away from source of heat and ignition. Containers must be kept tightly closed. Handle with care, stir well before use.

SAFETY PRECAUTION

Keep away from heat, spark and open flames. Avoid breathing of vapour on skin and eye contact. Keep container closed and store in cool, ventilated area when not in use. Proper ventilation and protective measures must be provided during mixing, application and drying, to keep vapour concentration within safe limits and to protect against toxic hazard. Necessary safety equipment must be used and ventilation requirements carefully observed, especially in confined or enclosed spaces, such as tank interior and building.

DISCLAIMER

The information in this product data sheet is given to the best of our knowledge based on laboratory testing and practical experience. If the product is used under The product must be stored in accordance with national regulation. Storage conditions are to keep the containers in a dry, cool, well ventilated space and away from source of heat and ignition. Containers must be kept tightly closed. Handle with care, stir well before use. condition beyond our control, we cannot guarantee anything but the quality of the products it self. The information in this product data sheet is liable for modification from time to time in the light of experience and our policy of continuous product development, and without further notice.