

FREEDOMTUFF™ FT-6509

PRODUCT DESCRIPTION

New Section Content **FT-6509** is a solvent based urethane primer (single component). The primer is a moisture cured coating ideal for priming previously coated and metallic surfaces. The coating is compatible with any of the Freedom polyurethane, polyurea based chemical & corrosion coatings and the UV stable top coat products.

USES

- Steel Structures
- Metal Stairways
- Metal Tanks

ADVANTAGES

- Single Component
- Moisture Cure
- Excellent Adhesion to Metallic Surfaces

MIXING

Prior to mixing please ensure the following:

1. The product is at a temperature between 60-77F° (15-25°C).
2. The ambient & surface temperature is above 50F° (10°C). Once these 2 checks have been met, please proceed with mixing the product.
3. Using an electric paddle mixer agitate the single component coating.

COLOR

Single Component - Grey

SURFACE PREPERATION

Metallic Substrates – Mechanical abrasion

1. All oil and grease must be removed from the surface using an appropriate cleaner such as MEK.
2. All surfaces must be mechanically abraded using handheld grinders to ISO 8501/4 ST3 (SSPC SP3 ST3).
3. Once abraded, the surface must be degreased and cleaned using MEK or similar type material.
4. All surfaces must be coated before gingering or oxidation occurs. Metallic Substrates – Hydro-blasting
5. All surfaces must be hydro-blasted using clean water at 12,000 psi (850bar) to NACE 5 (SSPC SP13 WJ3-WJ1).
6. All surfaces must be coated before gingering or oxidation occurs Metallic Substrates – Abrasive blast cleaning
7. All oil and grease must be removed from the surface using an appropriate cleaner such as MEK.
8. All surfaces must be abrasive blasted to ISO 8501/4 Standard SA2.5 (SSPC SP10/ NACE 2) minimum blast profile of 75 microns (3mil) using an angular abrasive.
9. Once blast cleaned, the surface must be degreased and cleaned using MEK or similar type material.
10. All surfaces must be coated before gingering or oxidation occurs. PLEASE NOTE: For salt contaminated surfaces the substrate must be pressure washed with clean water and checked for salt contamination, please refer to the surface preparation and pre-application guide for further information.

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COVERAGE RATES

1.3 US gallon (5ltrs) of fully mixed product will give the following coverage rates:

- 538ft² at 4mil
- 50m² at 100 microns

Please note that the coverage rates quoted are theoretical and do not take into consideration the profile or condition of the surface being repaired.

OVER-COATING TIMES

Minimum - the material can be over-coated after approximately 4 hours at 68°F (20°C) . Maximum - the over-coating time should not exceed 24 hours. Where the maximum over-coating time is exceeded, the material should be allowed to harden before being abraded or flash blasted to remove surface contamination.

HEALTH AND SAFETY

Please ensure good practice is observed at all times. Protective gloves, goggles & a disposable coverall must be worn during the mixing and application of this product. Before mixing and applying the material ensure you have read the fully detailed Safety Data Sheet.

CURE TIMES

At 68°F (20°C) the applied materials should be allowed to harden for the times indicated below before being subjected to the conditions indicated. These times will be extended at lower temperatures and reduced at higher temperatures:

- Touch dry 2 hours
- Minimum overcoating time 4 hours
- Maximum overcoating time 24 hours

STORAGE LIFE

2 years if unopened and store in normal dry conditions (60-86°F/15-30°C)