



RG-CSA PRIMER

USE:	RUST INHIBITIVE COATING DIRECT TO METAL (DTM) USE OR OVER RG-CSA PRIMER ON STRUCTURAL STEEL, PIPE BRIDGES, PIPE SUPPORTS, TANK EXTERIORS, ETC...
RESIN TYPE:	CALCIUM SULFONATE ALKYD (CSA), 4:1 RATIO SULFONATE TO ALKYD (MAXIMUM 25% ALKYD by Weight)
SOLVENT TYPE:	ALIPHATIC HYDROCARBON
VISCOSITY:	90 - 120 KU @ 77°F (25°C)
WEIGHT/GALLON:	10.01 ± 0.5 lbs./gallon (1.2012 kg/liter)
WEIGHT % SOLIDS:	74 ± 2.0 (31% CALCIUM SULFONATE by Weight)
VOLUME % SOLIDS:	59 ± 2.0
SURFACE PREPARATION:	SSPC SP-1, SSPC SP-2, SSPC SP-3, SSPC SP-6, SSPC SP-7, SSPC SP-12 OR SSPC SP-14 (OR EQUIVALENT NACE STANDARDS).
WET FILM:	7 - 18 mils (175 – 450 microns)
DRY FILM:	4 - 10 mils (100 – 250 microns)
FLASH POINT:	105°F (40.5°C)
CHARACTERISTICS:	FIRM DRY PROPERTIES. HIGH SOLIDS AND EXCELLENT CORROSION RESISTANCE. CAN BE APPLIED OVER TIGHT RUST.

PERFORMANCE CHARACTERISTICS:

SYSTEM TESTED:	STEEL BLASTED TO SSPC-SP10, CSA-2300 @ 8 mils (200 microns) DFT
CYCLIC WEATHERING:	ASTM D5894, 4 CYCLES OR 5000 HOURS RUSTING ASTM D610 – RATING 10 BLISTERING ASTM D714 – RATING 10 UNDERCUTTING ASTM D1654 – RATING 10
SALT FOG RESISTANCE:	ASTM B117, 2000 HOURS RUSTING ASTM D610 – RATING 10 BLISTERING ASTM D714 – RATING 10 UNDERCUTTING ASTM D1654 – RATING 10
PENCIL HARDNESS:	ASTM D3363 - 5B
FLEXIBILITY:	ASTM D522 PASES 180° BEND, 1/8" (3.2 mm) MANDREL

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This information is based on our best knowledge, but POLYGUARD cannot guarantee the results to be obtained.



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APPLICATION INSTRUCTIONS

RG-CSA PRODUCTS CAN BE APPLIED AS A ONE OR TWO COAT SYSTEM APPLIED AT 20 mils (500 microns) TOTAL WFT OR AS SPECIFIED BY DRY FILM REQUIREMENTS. WHEN USING A TWO-COAT APPLICATION METHOD (i.e. PRIMER/TOPCOAT), A MINIMUM OF 6 HOURS IS REQUIRED BETWEEN COATS.

EQUIPMENT: AIRLESS SPRAY – 30:1 GRACO BULLDOG WITH 3/8” (9.5 mm) I.D. HIGH PRESSURE LINE AND A GRACO SILVER GUN WITH A 0.017”-0.021” (0.43 – 0.53 m) SPRAY TIP.

CONVENTIONAL SPRAY – USE A DV-MBC GUN OR EQUIVALENT WITH A “D” FLUID NOZZLE AND A 64 AIR CAP.

NOTE: BRUSH AND ROLLER APPLICATION CAN BE USED AS WELL AS OTHER SPRAY EQUIPMENT. CONTACT YOUR REPRESENTATIVE FOR RECOMMENDATIONS.

SAG RESISTANCE: 30 mils (750 microns) DFT

COVERAGE: APPROXIMATELY 160 SQ. FT. PER GAL. @ 10 mils WFT

THINNING: UP TO 10% WITH MINERAL SPIRITS AS NECESSARY.

MIXING: MIX TO A UNIFORM CONSISTANCY BY HAND OR POWER MIXER.

DRYING TIMES: DUST FREE.....2 -6 hours* @ 77°F (25°C), 5 mils (125 microns) DFT, 50% RH
FIRM.....20 - 48 hours* @ 77°F (25°C), 5 mils (125 microns) DFT, 50% RH
RECOATABILITY....NO MAXIMUM

THIS MATERIAL NEEDS TIME TO FULLY CURE WHEN APPLIED GREATER THAN 10 MILS WFT. THE LONG CURE TIME ALLOWS THE MATERIAL TO PENETRATE THE PORES OF THE SUBSTRATE AND GIVES SUPERIOR ANTI-CORROSION PROTECTION.

* TIMES VARY DEPENDING UPON COATING THICKNESS, ENVIRONMENTAL CONDITIONS, WIND, SUN EXPOSURE, ETC.

- MAY BE APPLIED TO SURFACES AND IN AMBIENT TEMPERATURES DOWN TO 0°F (-17.7°C) AS LONG AS NO VISIBLE CONDENSATION OR ICE IS PRESENT.
- THE MATERIAL TEMPERATURE, PRIOR TO BEING APPLIED, MUST BE ELEVATED TO ACHIEVE A WORKABLE VISCOSITY. THIS TEMPERATURE MAY BE HIGHER THAN THE MINIMUM RECOMMENDATION OF 35-45°F (1.6 – 7.2°C) BASED ON EQUIPMENT, DESIRED WORKING TIMES AND AMBIENT CONDITIONS.
- AMBIENT TEMPERATURES MUST REMAIN 3° DEGREES ABOVE THE DEW POINT DURING THE APPLICATION PROCESS.
- MATERIALS SHOULD NOT BE APPLIED WHEN THE RELATIVE HUMIDITY EXCEEDS 90%.
- MAY BE STORED AT TEMPERATURES DOWN TO 0°F (-17.7°C).

CLEAN-UP: CLEAN EQUIPMENT WITH MINERAL SPIRITS.

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