

## Technical Data Sheet

# Indofast 310

### Rust Inhibitive Zinchromate Red Oxide Primer

## Product Description

Single component Modified Alkyd based rust inhibitive, General Purpose uses primer pigmented with Zinchrome and Natural Red Oxide as corrosion inhibiting pigment.

## Recommended Use

It is recommended as primer on M.S. surface for General Industries, i.e. various Bus and Truck Body builders, Fabrication Industries, PEB industries, Forging and Casting Industries, Heavy machineries etc, where fast turn around is required. Indofast 310 is quick drying primer and is suitable for coating on hand prepared substrates or as a maintenance coating.

## Physical Data

Colour	: Redoxide
Finish	: Matt to Eggshell (10-40 GU at 60° angle)
Soild by Volume	: 50 ± 3%
Supply Weight (Kg/ Ltr)	: 1.25±0.05
Flash Point	: 31° C
Dry Heat Resistance	: Intermittent : 120°C, Continuous : 100°C
Shelf Life	: 12 months

## Film Thickness

### Recommended film thickness per coat

Dry Film Thickness	: 40-70μ in single coat
Wet Film Thickness	: 80-140μ in single coat
Therotical Coverage Rate	: 12.50 sq.mt / lit at recommended DFT of 40μ

## Surface Preparation

All surfaces to be coated should be clean, absolutely dry and oil or moisture free before painting application. Oil and grease should be removed by solvent cleaning. This product is suitable for use over phosphate washed steel.

**Steel:** Abrasive blast clean to a minimum of Sa2½ (ISO 8501-1:2007). Surface defects revealed by the blast cleaning process should be ground, filled, or treated in the appropriate manner. A surface profile of 30-40 microns is recommended.

**Maintenance:** The surface should be hand or machine abraded or hand abrasive pads to impart a scratch pattern to the surface and to remove all polish from the surface. Else abrasive sweep blast to a standard similar to ISO 8501-1:2007 Sa1 to create a surface profile. 310 is suitable for overcoating on aged surfaces. Brush application is recommended in case of poor surfaces.

**Primed Surface:** Already primed (or wash primed) surface should be dry and free from all contamination and Indofast 310 should be applied within the overcoating intervals specified in earlier primer/ etch primer TDS. Area of damaged primer or rework etc should be prepared as per specified standards, either by power tool cleaning or other means.

**Wood:** Clean and dry surface. Surface contamination is to be removed by detergents and fresh water cleaning.

## Application Data

Application Method	: Spray/ Airless Spray/Brush/ Roller
Mixing Ratio	: One Component Coating
Thinner and Cleaner	: Indokote Thinner (IK.707)
Airless Nozzle Orifice	: 0.43 - 0.53mm
Nozzle Pressure	: 176 kg/cm <sup>2</sup> or 2500 psi

**Working Precautions:** Material should not be allowed to remain in pipeline, hoses, gun or spray equipment. Thoroughly flush all equipment with IK.1702 thinner. Once units of paint have been mixed they should not be resealed and it is advised that after prolonged stoppages, the work should recommence with freshly mixed units.

**Maintenance:** Clean all equipment immediately after use with IK.1702 thinner. It is good working practice to periodically flush out spray equipment during the course of the working day. All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.

## Drying Characteristics

Surface Dry	: 20 mins
Touch Dry (to Handle)	: 45 mins
Hard Dry	: 24 Hours
Overcoating Interval	: Minimum 2 Hours

Drying and curing times are determined at 30°C under controlled temperatures and relative humidity below 85 %, and at average of the DFT range for the product.

## Compatibility

Previous Coating : Alkyd, Poly vinyl  
Subsequent Coating : Modified Alkyd, Alkyd

## Product Features

Anti corrosive products based on modified alkyds are most suitable for the protection of light industrial steelwork in internal dry environments or on exposed steelwork which is situated in low corrosivity environments corresponding to ISO12944 C1, C2 only. Anti-corrosive performance on hand prepared steel is related directly to both the degree of surface preparation and the dry film thickness of the system applied.

This product must only be thinned using the recommended thinner. The use of alternative thinners, might contains alcohols, can severely affect the curing mechanism of the coating. Indofast 310 should be applied at least 3°C temperatures above dew point and below 85% of relative humidity.

Indofast310 will provide acceptable levels of corrosion protection in mild to moderate environments, with the level of performance depending on the degree of surface preparation and total system dry film thickness. Indofast310 based systems are not suitable for service in wet or aggressive environments.

## Storage

This is solvent based coating and the containers should be kept in a dry, cool, well ventilated space and away from sources of heat and ignition. Containers must be kept tightly closed.

## Precaution

This product is for professional use only. The paint applicators should be trained, experienced and have the capability and equipment to mix and apply the coatings correctly as instructed. Applicators should use appropriate protection equipment when using this product.

This is solvent based product and should be use under well ventilated conditions. Do not inhale spray mist. Skin contact should be avoided. In case of spillage on the skin, it should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water.

### Limitation of Liability

This information is given to the best of our knowledge. Because of the multitude of formulations, production, and application conditions, all the above-mentioned statements have to be adjusted to the circumstances of the processor. Our products are often used under conditions beyond INDOKOTE's control. INDOKOTE cannot guarantee anything but the quality of the product itself. No liabilities can be derived from this fact for individual cases. This issue replaces all previous versions – Printed in India.

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