### Epoxy Blast Primer Weldable

**Application 10 - 35 microns**  
**Qty 88.5 = 1 Litre**

#### Component A

<table>
<thead>
<tr>
<th>Raw material</th>
<th>Quantity</th>
<th>Supplier</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Notes</strong></td>
<td><strong>Litres</strong></td>
<td><strong>Kg</strong></td>
</tr>
<tr>
<td>Toluene</td>
<td>11.12</td>
<td>9.67</td>
</tr>
<tr>
<td>Isopropanol</td>
<td>4.12</td>
<td>3.22</td>
</tr>
<tr>
<td>Razeen SR 5199</td>
<td>10.96</td>
<td>12.9</td>
</tr>
<tr>
<td>Sir under high shear mixer until fully dissolved</td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Bentone in toluene)</strong></td>
<td><strong>14.77</strong></td>
<td><strong>13.55</strong></td>
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<tr>
<td>Add to the resin solution disperse for 15-20 minutes</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Nuosperse 657 / CA510</td>
<td><strong>0.56</strong></td>
<td><strong>0.54</strong></td>
</tr>
<tr>
<td>Bayferrox 130M</td>
<td><strong>1.88</strong></td>
<td><strong>8.54</strong></td>
</tr>
<tr>
<td>Vialcalc VT15</td>
<td><strong>0.88</strong></td>
<td><strong>2.5</strong></td>
</tr>
<tr>
<td>Plastorit S</td>
<td><strong>1.79</strong></td>
<td><strong>4.98</strong></td>
</tr>
<tr>
<td>Nanoguard ACP DCP</td>
<td><strong>3.36</strong></td>
<td><strong>10.65</strong></td>
</tr>
<tr>
<td>Add into the mix and disperse for 20 minutes then pass through beadmill</td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Methoxy propanol</strong></td>
<td><strong>5.97</strong></td>
<td><strong>5.48</strong></td>
</tr>
<tr>
<td><strong>Toluene</strong></td>
<td><strong>23.95</strong></td>
<td><strong>20.83</strong></td>
</tr>
<tr>
<td><strong>Isopropanol</strong></td>
<td><strong>9.14</strong></td>
<td><strong>7.14</strong></td>
</tr>
<tr>
<td>Premix and use half to flush out the bead mill, add remainder and High speed disperse. Check viscosity If adjustment required use 3:1 mix toluene to isopropanol</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

**Total**  
88.5  
100
Parameters
Grind
7+
Hegman (tolerance +0.5)

Red oxide
(Matt)

colour (Visual)

5 - 10

minutes

Drying

Specific Gravity
1.13 +/- 0.05

Mix Ratio by weight B:A

Component B
Qty 111.11 = 1 litre

Notes Raw material
Razeencure 9115X70
61.5
58.72
JANA

www.jana-ksa.net

Toluene
36.5
31.74
Petrochem

www.petrocheme.com

Isopropanol
12.2
9.53
Petrochem

www.petrocheme.com

Parameters
Specific Gravity
0.9

+/-0.05

Drying 5 - 10 minutes
5.02:1

Mix Ratio by weight B:A

1) Mixture of 10% of bentone in toulene. Stir until get a stiff gel.

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