

Protective Primer 161

Technical Data Sheet: 153-60 **P1610**

ALEXSEAL P corrosion inhil excellent adhe aluminium sul economical aj adhesion pror 161 has been	rotective P bitors and esion prom bstrates. T pplication p moter for a	rimer 161 is a combinatio notion on all he long re-co process. Afte dditional lay	an epoxy-b on of epoxy substrates a pating time r curing, Al ers of ALEX	based two resin bin as well as of 6 mon _EXSEAL	o-compor ding age s corrosic ths withc Protect	nent primer. nts, this prir on protection out sanding ive Primer 1	Due to specific ner offers n on steel and allows an 61 is the ideal
with low hame	espread ch	by IMO Res naracteristics	olution MS s.	C.307 (88	oducts. A 3)-(FTP-(ALEXSEAL Code 2010)	Protective Primer as marine paint
ALEXSEAL Protective Primer 161 is used for corrosion protection and adhesion promotion o steel and aluminium substrates, both above and below the waterline.							
Color of mixtu Base Materia Converter:	ure: I:	White White Clear					
Volume Solids catalyzed without reduction: 48 % Note: Coverage rates are figured for base and converter. Reducer is added as percent of total quantity of base & converter							
				m² / liter	m² / gal	sq. ft. / gal	Rec. DFT in µm(mils)
Theoretical				4,8	18	196	80-100 (3-4)
Practical							
Conventiona	al Air Spra	v Fauinmen	t	24	92	100	80-100 (3-4)
HVI P Air Sr	orav Equin	ment	<u>.</u>	2.4	10.2	110	80_100 (3_4)
	nment	ment		2.0	11.2	120	80_100 (3_4)
Brush / Roll	or			2.5	13.2	1/2	80_100 (3_4)
 ALEXSEAL Protective Primer 161 is applied directly to the properly cleaned and substrate (ideally within 6 hours). To achieve optimum adhesion and performance: Steel should be prepared by sandblasting to a minimum of near white metal, SA 2.5 SP10 - 85) or ground (P36 to P40 grit) to a 50 - 100 micron (2 - 4 mils) profile. Note: White metal Sa 3 (SSPC-SP5-85 is preferred. Aluminium should be sandblasted or ground (36 to 60 grit) to bright clean aluminiu 50 - 100 micron (2 - 4 mils) profile. ALEXSEAL Protective Primer 161 may be applied as a tie coat primer before application over gel coat and raw resin lay-up. Gel coat must be sanded with P80 - P100 grit. Fiberglass resin should be ground with P36 - P60 and / or sand blasted. The surt the bottom of any profile should be dull and abraded with no shiny spots. 							
P1610ALEXSEAL Protective Primer 16C1617ALEXSEAL Protective Primer 16			1 White 1 Converter		1 Gal & 5 Gal 0.167 Gal (for 1 Gal) and 0.833 Gal (for 5 Gal)		
R4042	ALEXSEA	L Epoxy Pri	mer Reduc	er		1 QT & 1 (Gal
6 parts by volumeP1610ALEXSEAL Protective Primer 161 Base1 part by volumeC1617ALEXSEAL Protective Primer 161 Converter5 - 10% reduction (vol.)R4042ALEXSEAL Epoxy Primer ReducerExample: $6: 1: \frac{1}{2} = 7$ % reductionReduction							
5 - 10% reduc Example: 6 :	$1 : \frac{1}{2} = 7$	% reduction	,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,	·			
5 - 10% reduc Example: 6 : The amount of For special a	1 : $1/2 = 7$ of reducer	% reduction required ma reduction ca	y vary depo	ending or d up to 2	n the app 5%.	olication cor	nditions.
	ALEXSEAL P steel and alur Color of mixtu Base Materia Converter: Volume Solid <i>Note: Coverage</i> <i>base & convert</i> Theoretical Practical Conventiona HVLP Air Sp Airless Equi Brush / Roll The substrate (ide Steel should SP10 - 85) or Note: White ALEXSEAL F substrate (ide Steel should SP10 - 85) or Note: White Aluminium s 50 - 100 micr ALEXSEAL F application ov Gel coat mus Fiberglass r the bottom of P1610 C1617 R4042 6 parts by vol	ALEXSEAL Protective F steel and aluminium sub Color of mixture: Base Material: Converter: Volume Solids catalyze Note: Coverage rates are in base & converter. Theoretical Practical Conventional Air Spra HVLP Air Spray Equip Airless Equipment Brush / Roller The substrate must be of ALEXSEAL Protective substrate (ideally within Steel should be prepare SP10 - 85) or ground (F Note: White metal Sa 3 Aluminium should be 3 50 - 100 micron (2 - 4 m ALEXSEAL Protective application over gel coa Gel coat must be sandu Fiberglass resin shou the bottom of any profile P1610 ALEXSEA R4042 ALEXSEA 6 parts by volume	ALEXSEAL Protective Primer 161 is steel and aluminium substrates, both Color of mixture: White Base Material: White Converter: Clear Volume Solids catalyzed without rea Note: Coverage rates are figured for base base & converter. Theoretical Practical Conventional Air Spray Equipment Airless Equipment Brush / Roller The substrate must be clean, dry ar ALEXSEAL Protective Primer 161 substrate (ideally within 6 hours). To Steel should be prepared by sandb SP10 - 85) or ground (P36 to P40 g Note: White metal Sa 3 (SSPC-SP: Aluminium should be sandblasted 50 - 100 micron (2 - 4 mils) profile. ALEXSEAL Protective Primer 161 application over gel coat and raw re Gel coat must be sanded with P80 Fiberglass resin should be ground the bottom of any profile should be P1610 ALEXSEAL Protective R4042 ALEXSEAL Epoxy Pri 6 parts by volume P1610	ALEXSEAL Protective Primer 161 is used for of steel and aluminium substrates, both above and Color of mixture: White Base Material: White Converter: Clear Volume Solids catalyzed without reduction: 48 Note: Coverage rates are figured for base and converter. Theoretical Practical Conventional Air Spray Equipment Airless Equipment Brush / Roller The substrate must be clean, dry and free from ALEXSEAL Protective Primer 161 is applied substrate (ideally within 6 hours). To achieve of Steel should be prepared by sandblasting to a SP10 - 85) or ground (P36 to P40 grit) to a 50 Note: White metal Sa 3 (SSPC-SP5-85 is prefective Primer 161 may be at application over gel coat and raw resin lay-up. Gel coat must be sanded with P80 - P100 grit Fiberglass resin should be ground with P36 the bottom of any profile should be dull and ab P1610 ALEXSEAL Protective Primer 161 R4042 ALEXSEAL Epoxy Primer Reduct 6 parts by volume P1610 ALEX	ALEXSEAL Protective Primer 161 is used for corrosion steel and aluminium substrates, both above and below the Color of mixture: White Base Material: White Converter: Clear Volume Solids catalyzed without reduction: 48 % Note: Coverage rates are figured for base and converter. Redubase & converter. Ware Coverage rates are figured for base and converter. Redubase & converter. Marce Coverage rates are figured for base and converter. Redubase & converter. Marce Coverage rates are figured for base and converter. Redubase & converter. 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AlexSEAL Protective Primer 161 is applied directly for substrate (ideally within 6 hou	ALEXSEAL Protective Primer 161 is used for corrosion protectionsteel and aluminium substrates, both above and below the waterColor of mixture:WhiteBase Material:WhiteConverter:ClearVolume Solids catalyzed without reduction: 48 %Note: Coverage rates are figured for base and converter. Reducer is and base & converter. $m^2 / m^2 / $	ALEXSEAL Protective Primer 161 is used for corrosion protection and added steel and aluminium substrates, both above and below the waterline.Color of mixture: White Base Material: White Converter: ClearVolume Solids catalyzed without reduction: 48 % Note: Coverage rates are figured for base and converter. Reducer is added as percebase & converter. $m^2 / m^2 / galgalTheoretical4,8TheoreticalConventional Air Spray Equipment2.610.2110HYLP Air Spray Equipment2.610.2110Airless Equipment2.913.2142The substrate must be clean, dry and free from dust, grease, oil and other of ALEXSEAL Protective Primer 161 is applied directly to the properly cleassubstrate (ideally within 6 hours). To achieve optimum adhesion and perforSteel should be prepared by sandblasting to a minimum of near white metaSP10 - 85) or ground (P36 to P40 grit) to a 50 - 100 micron (2 - 4 mils) profile.ALEXSEAL Protective Primer 161 may be applied as a tie coat primeapplication over gel coat and raw resin lay-up.Gel coat must be sanded with P80 - P100 grit.Fiberglass resin should be ground with P36 - P60 and / or sand blastedthe bottom of any profile should be dull and abraded with no shiny spots.P1610ALEXSEAL Protective Primer 161 Whiteand 0.833R4042ALEXSEAL Epoxy Primer Reducer1 QT & 126 parts by volumeP16101 ALEXSEAL Protective Primer 1611 Gat & 5 0$

The information contained in this data sheet is based on our level of research and development. Revisal by the user with regard to the intended aim is necessary due to the diverse processing and application possibilities. Any liability on part of Mankiewicz for faulty applications and / or improper use is expressly excluded. The processing of the product must be fully documented by means of a paint application protocol. Rev 01/24

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8. Application	Viscositv	Zahn #2; ≈ 80 sec. DIN 4 cup 4mm; ≈ 70 sec
	Nozzle Size Gravity Gun	1.8 – 2.5 mm (0.071 to 0.098) - Conventional & HVLP
	Nozzle Size Siphon Cup	1.6 mm (0.60) - Conventional & HVLP
	Fluid Nozzle Size Pressure Pot	1.4 to 1.6 mm (0.055 to 0.063) - Conventional & HVLP
	Atomizing Pressure	2.0 to 4.0 bar (30 to 60 PSI) - Conventional & HVLP
	Pot Pressure	0.7 to 1.5 bar (10 to 22 PSI) - Conventional & HVLP
	Airless Equipment	Tip 0.35mm / 60° to 0.43mm / 60° (0.014 / 60° to 0.017 / 60°)
		Inlet Pressure 2 to 3 bar (29 to 44 PSI)

Application by Spraying Apply 1 cross coat or 2 coats to a total wet film thickness (WFT) of 200 - 300 microns (8 - 12 mils). This will achieve a dry film thickness (DFT) of 90 - 135 µm.

9. Pot life and Drying

Optimal application environment range - min. 15°C (60°F) 40% RH, up to max. 30°C (85°F) 80% RH

Temperature for minimum recoat time	15°C (60°F)	20°C (68°F)	25°C (77°F)	30°C (85°F)	Max Dry Time			
Pot Life - approx.	8 hrs	8 hrs	6 hrs	4 hrs	N/A			
Dust Free	40 min	30 min	20 min	10 min	N/A			
Tape Dry	30 hrs	24 hrs	20 hrs	16 hrs	N/A			
Fully Cured	11 days	9 days	7 days	5 days	N/A			
Recoating with another coat of ALEXSEAL Protective Primer 161. Sanding is required after the maximum time.	6 hrs minimum	4 hrs minimum	2 hrs minimum	2 hrs minimum	6 months maximum			
Overcoat with other products including 202, 212, 302, 303, 328, 442, 414 and 501. Preparation including sanding is required after maximum time.	32 hrs minimum	16 hrs minimum	16 hrs minimum	12 hrs minimum	6 months maximum			
Note: The above chart reflects approximate minimum and maximum time. Surface temperature, air flow, direct or non- direct sunlight, quantity of reducer, and film thickness will affect actual tack up, recoat, overcoat, and drying times during application. During the drying phase the minimum temperature is 15°C (60°F). Ideal temperature: 25°C (77°F). The minimum application condition should be 3°C (5.4°F) above dew point.								

Professional Use Only

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