Corroless QDR

Rust Stabilising Primer

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Code: LQDR1/2/3

Product Description	A quick drying, single pack, rust stabilising primer reinforced with self-leafing glass flake.
Features & Use	• Over 30 years track record in corrosion control • Fast overcoating – from only 30 minutes • Designed for fast patch repair of localised damage, offering enhanced short- term repair where turn around times do not allow for normal recoating intervals • Contains glass flake for improved impermeability and abrasion resistance • Contains Corroless Pigment • Applications include pipes, cranes, tank exteriors, jetties, bridges, mechanical equipment, railings and other structural steel • NOT suitable for application onto galvanised steel
Approvals/ Certification	• Sold on track record and customer recommendation • QDR 1: NATO Stock Number 0442 8010 99 915 4034
Finish	Low gloss
Volume Solids	**QDR1 & 2:** 45% ± 2% **QDR3:** 41% ± 2%
VOC Content	**QDR1** 444g/litre, **QDR2 435**g/litre. **QDR3** 514 g/litre ± 20 g/litre

Film Thickness Range And Coverage

	Dry Film Thickness	Wet Film Thickness	Theoretical Coverage
QDR1 & 2	50 µm	111 µm	9.0 m^2/litre
QDR3	50 µm	122 µm	8.2 m^2/litre

Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated
Always apply two coats

Drying Times

Applied to recommended DFT		+10°C	+18°C	+30°C
Dust Free		30 minutes	20 minutes	15 minutes
Hard Dry		6 hr	4 hr	2 hr
Overcoating	Minimum	6 hr	4 hr	2 hr
	Maximum	9 days	7days	3 days

Colours	QDR1 - Red Brown QDR2 - Buff QDR3 - Black
Mix Ratio	Single Pack
Pot Life	Not applicable
SG	QDR1 & 2 1.45 kg/litre QDR3 1.28 kg/litre
Storage Conditions	Store in dry, cool conditions and protect from frost
Shelf Life	Minimum 24 months if stored as above in unopened containers
Flash Point	21-32°C

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Surface Preparation

- If required due to obvious dirt/grease contamination or suspected salt or chemical contamination, clean all surfaces with a water-soluble degreaser, wash down with clean fresh water and allow to dry before commencing main preparation
- **Recommended substrate:** Steel
- **Manual Preparation:** Prepare using rust scrapers, chipping hammers, needle guns, wire brushes etc. to St2 standard of ISO 8501-1:2007 or equivalent. Where necessary, remove weld spatter and grind smooth all sharp edges and weld seams. Wash down with clean fresh water and allow to dry before coating
- **Mechanical preparation:** Blast clean to minimum Sa1 standard of EN ISO8501-1:2007 or equivalent with a surface profile of 50 to 75 microns. Wash down with clean fresh water and allow to dry before coating
- **New Steel:** All mill scale must be removed prior to application
- Before coating all surfaces should be firm, clean dry and free from oil, grease, powdery flash rusting and other contamination

Mixing

Stir thoroughly before use

Thinner / Cleaner

Corroless Thinners No.3 (Solvent Gun Wash may be used for cleaning only)

Application Conditions

Only apply in conditions of good ventilation which must be maintained during drying and curing. Do not apply when rain, mist, sleet or snow are imminent. During application and drying time of the paint coating, the surface should be dry, the Relative Humidity should not exceed 90% and the steel temperature should remain at least 3ºC above the dew point
Paint temperature should ideally be at a minimum of 15ºC

Application Methods

Method	Airless Spray	Conventional Spray	Brush	Roller
	Yes	Yes- Thinning required	Yes	Yes

- **Airless spray**: output fluid pressure 3000 psi, tip size 13-15 thou, Fan angle 30-65º. For detailed advice contact Corroless
- **Conventional Spray:** An addition of up to 10% Corroless Thinners No.3 will be required
- **Brush**: apply unthinned, lay on, do not over brush. **When rollering**, use a short nap lamb's wool roller and a maximum addition of 5% Corroless Thinners No.2. Lay off with a brush to complete the finish

Product Notes

- **Application Temperature**: Range 2ºC-35ºC
- **Stripe Coating:** Stripe coat all edges, nuts and bolts, welds etc.
- **Overcoating:** Overcoat with itself or Corroless RF16. If overcoating time is exceeded and contamination has occurred, clean using a detergent solution/fresh water and allow to dry before continuing
- If maximum overcoat times are exceeded abrade the surface and wash down with fresh water to remove contamination and allow to dry before continuing

Health & Safety

Containers are provided with safety labels which should be observed.
Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Axalta Coating Systems.