



Nap-Gard®

7-1808

Red Phenolic Liquid Primer

Revised: 20 September 2021

DESCRIPTION

Nap-Gard® product No. 7-1808 Red Phenolic Liquid Primer used to enhance adhesion for down hole tubulars and lined pipe that are internally coated. It is compatible with Axalta's 7-0008, 7-0010, 7-0014, 7-0015, 7-0016, 7-0017, 7-0017HT and 7-0017VHT.

TYPICAL POWDER PROPERTIES

Color:	Red	Components:	Single Component
Mixing Ratio:	Not applicable Mix the primer thoroughly before use.	Shelf Life:	12 months Below 25°C (77°F) and 50% RH

GENERAL APPLICATION PARAMETERS

- SOLIDS BY VOLUME 25%
- **RECOMMENDED FILM THICKNESS:** Wet: 50 microns-100 microns (2.0 - 4.0 mils).
(Primer for powder topcoat only) Dry: 13 - 25 microns (.5 -1.0 mils).
- **THINNING BY VOLUME:** Thin up to 15% with Phenolic reducer if required.
- **APPLICATION EQUIPMENT AND METHODS:** Spinning Head.
- **SURFACE PREPARATION**
Cleanliness: White Metal-Surface shall be free of all visible oil, grease, dirt, mill scale, rust, paint, oxide, corrosion products, and any other foreign matter.

Standards: White Metal in accordance with accordance with Swedish standards #Sa3 using steel grit. Flint or garnet of the appropriate particle size.

Profile: 38 microns minimum to 100 microns maximum
Minimum 1.5 mils, maximum 4.0 mils.

GEL TIME & CURE SCHEDULE GUIDELINES

- Spray apply Nap-Gard® 7-1808 primer to the recommended film thickness.
- Air dry primer for 5 minutes.
- Preheat the primed metal to 375°F to 425°F (191°C to 218°C).
- Apply Nap-Gard powder topcoat.
- Post cure the coating system at 400°F to 450°F (204°C to 232°C) for 30 min to 1 hour depend on product.
- Check cure by DSC or other approved methods.

Always consult product Material Safety Data Sheet (SDS) prior to handling.

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