Nap-Gard®
7-1808 Red Phenolic Liquid Primer

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, 7-0016, 7-0017, 7-0017HT and 7-0017VHT.

TYPICAL POWDER PROPERTIES

<table>
<thead>
<tr>
<th>Color</th>
<th>Red</th>
</tr>
</thead>
<tbody>
<tr>
<td>Components</td>
<td>Single Component</td>
</tr>
<tr>
<td>Mixing Ratio</td>
<td>Not applicable</td>
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<td></td>
<td>Mix the primer thoroughly before use.</td>
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<tr>
<td>Shelf Life</td>
<td>12 months</td>
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<tr>
<td>Below 25°C (77°F)</td>
<td>and 50% RH</td>
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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 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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