

# HENSOTHERM®

## Substrate preparation and primer

The objective of the substrate preparation	The surface of the different metals such as stainless steel, cast steel, aluminium, etc. must be prepared so that adhesion of the primer is ensured and application with the selected HENSOTHERM® fire protection system F/R 30, F/R 60 or F/R 90 can take place.		
Metal types	Preparation measures	Primers	
Steel surface, blasted	<ul style="list-style-type: none"> <li>Blasting in accordance with degree of preparation Sa 2.5</li> <li>Clean: dust, oil and grease-free</li> </ul>	HENSOGRUND 1966 E HENSOGRUND 2K EP	The application quantities given in the technical data sheets for the primers do not take into account the correction factors for rough surfaces in accordance with ISO 19840.
Corroded steel parts Sand blasting not possible (PSt 2 / St 2)	<ul style="list-style-type: none"> <li>Hand de-rusting of the corroded surfaces, e.g. using a wire brush or mechanical prepared</li> <li>Minimum requirement PSt 2 / St 2</li> <li>Clean: dust, oil and grease-free</li> </ul>	HENSOGRUND 1K AK	
Corroded steel parts Sand blasting not possible (St 3)	<ul style="list-style-type: none"> <li>Mechanical preparation as St 2, but metallicly bright</li> <li>Minimum requirement St 3</li> <li>Clean: dust, oil and grease-free</li> </ul>	HENSOGRUND 1K AK HENSOGRUND 2K EP	
Cast steel	<ul style="list-style-type: none"> <li>Remove old layers of paint and all contamination up to the bare metal through blasting</li> <li>Clean: dust, oil and grease-free</li> </ul>	HENSOGRUND 1K AK HENSOGRUND 2K EP	
Aluminium	<ul style="list-style-type: none"> <li>Glass blasting</li> <li>Clean: dust, oil and grease-free</li> </ul>	HENSOGRUND 2K PU	
Stainless steel	<ul style="list-style-type: none"> <li>Blasting with non-metallic blasting material</li> <li>Roughening with non-woven abrasive (not metallic)</li> <li>Alternative glass blasting</li> <li>Clean: dust, oil and grease-free</li> </ul>	HENSOGRUND 2K PU	
Transport damage to primed steel surfaces or F/R 30 coatings e.g. defects	<ul style="list-style-type: none"> <li>Hand de-rusting of the corroded surfaces, e.g. using a wire brush</li> <li>Minimum requirement PSt 2</li> <li>Clean: dust, oil and grease-free</li> </ul>	HENSOGRUND 1K AK	
Zinc corrosion (white rust), galvanised surfaces	Alternative in accordance with the degree of the contamination: <ul style="list-style-type: none"> <li>Sweep blasting (Must be used after storage outside!)</li> <li>Sanding, e.g. with a sanding pad</li> <li>Clean with solvent</li> <li>Clean with high-pressure cleaner</li> </ul>	HENSOGRUND AQ HENSOGRUND 2K	
Pre-coated surfaces	<ul style="list-style-type: none"> <li>Suitability and compatibility test, see sheet on „Testing pre-coatings on steel constructions“</li> <li>Protocolling, see template „Protocol on the testing of pre-coatings“</li> <li>If suitable, further process as for transport damage</li> </ul>		

Information on the properties and application of the primers belonging to the HENSOTHERM® fire protection coating systems are in the respective technical data sheets. These are available to you as PDF in the download area at [www.rudolf-hensel.de](http://www.rudolf-hensel.de).

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