

Etch Primer

Product description

A two-pack chromate-free etch primer for use over a wide range of substrates. It is produced zinc-chromate free helping to reduce health and safety concerns. The product is available in buff.

Products

3503 Primer
3504 Catalyst

Note

Product should be at 20°C prior to use.

Information contained herein is based on careful investigation and is intended for information only. User is obliged to test the suitability of the products for their particular use. Supplier may change any specifications without notice.

Uses

The product can be over coated with both wet paint and powder coatings. 3503 should be used to improve adhesion and corrosion resistance of all systems used over metal substrates

The EU limit value for this product (product category IIB .e) in ready for use form is max.840 g/litre of VOC. The VOC content of this product in ready for use form is 600 g/l – 2004/42/IIB.e (840) 600

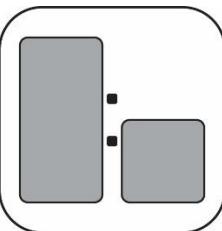
Composition	Acrylic resins, powders, solvents, additives
Colour	Buff
Shelf life	12 months in an unopened, original container from batch date shown
Pack Size	5ltrs & 1ltr

Pre-treatment

Degreasing is recommended and should be carried out after any abrasion of the surface

- **Steel** – de-grease and abrade. If necessary, blast clean to remove millscale
- **Aluminium Galvanised Steel Stainless Steel**

Thoroughly abrade or blast to remove surface oxide layer, degrease and apply the primer within 6 hours to prevent re-oxidation.

	<h3><u>Health and Safety</u></h3> <p>"For professional use only" Important: When using any new product, consult the "Health and Safety" data sheet. Always read the risks and precautions stated on the product label.</p>												
	<h3><u>Mix Ratio</u></h3> <table border="1"><thead><tr><th></th><th>Volume</th><th>Weight</th></tr></thead><tbody><tr><td>1:1</td><td></td><td></td></tr><tr><td>Primer</td><td></td><td></td></tr><tr><td>Catalyst</td><td></td><td>1:1</td></tr></tbody></table>		Volume	Weight	1:1			Primer			Catalyst		1:1
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	<p><u>Spraying viscosity</u></p> <p>30 – 40 seconds ISO Cup4 @ 20°C Pot life : 6 hours @ 20°C</p>												
	<p><u>Application</u></p> <p>Product should be at 20°C</p> <table border="1"><thead><tr><th>Spray Gun</th><th>Fluid tip size</th><th>Working pressure</th></tr></thead><tbody><tr><td>Conventional</td><td>1.2 – 1.8mm</td><td>3.5 – 4.2bar</td></tr><tr><td>Suction feed HVLP</td><td>1.2 – 1.8mm</td><td>0.7bar (max)</td></tr><tr><td>Pressure pot HVLP</td><td>1.2 – 1.8mm</td><td>0.7bar (max)</td></tr></tbody></table> <p>Number of coats: 1-2 light coats to cover Flash off : 5-7 minutes Film thickness :15 – 20 microns</p>	Spray Gun	Fluid tip size	Working pressure	Conventional	1.2 – 1.8mm	3.5 – 4.2bar	Suction feed HVLP	1.2 – 1.8mm	0.7bar (max)	Pressure pot HVLP	1.2 – 1.8mm	0.7bar (max)
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	<p><u>Drying</u></p> <p>All force dry/infrared times operate @ 60°C Metal 80°C Air</p> <p>Bake/Infrared: 15-25 minutes Air dry @20°C: 2-4 hours</p>												