

ViterCoat HSP Primer

Product Description	A high performance, compliant high solids two pack epoxy primer , specially designed for use with ViterThane HS polyurethane topcoats for the ACE market.			
Features & Use	<ul style="list-style-type: none"> Independently tested to world-class OEM client requirements No topcoat sinkage, so high gloss, high performance topcoats can be applied Excellent application and drying properties Good salt spray resistance Suitable for application by airless or conventional spray Excellent adhesion to blast cleaned, degreased or phosphated steel Used for the high performance coating of stone crushing, agricultural, construction and earthmoving equipment 			
Approvals/ Certification	Please consult Axalta Coating Systems for details of testing and approvals			
Finish	Semi-matt			
Volume Solids	69 ± 5% (varies with colour)			
VOC Content	250 ± 20 g/litre mixed (varies considerably with colour)			
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage
	Minimum	25 µm	36 µm	27.6 m ² /litre
	Maximum	45 µm	65 µm	15.3 m ² /litre
Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated				
Drying Times	Applied to 45 microns DFT	+23 °C		
	Flash Off	10 - 15 mins		
	Air Dry	Touch Dry – 1 - 2 hrs; Hard Dry - overnight		
	Force Dry	20 - 30 mins @60 - 80°C		
	Overcoating	Wet-on-wet after 15 - 20 mins		
Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation				
Colours	Black, Light Buff, Buff and shades to order			
Mix Ratio/ Product Code	Base	3381 series	5 parts by volume	
	Hardener	4065 022	1 part by volume	
Pot Life	Gel time - 100 mins at 25°C			
SG	1.4 - 1.5 kg/lit mixed (varies with colour)			
Storage Conditions	Store in dry, cool conditions and protect from frost			
Shelf Life	Minimum 12 months if stored as above in unopened containers			
Flash Point	Below 23°C – low flash material			

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<p>Surface Preparation</p>	<ul style="list-style-type: none"> All surfaces to be coated should be dry and cleaned as necessary to remove all oil, grease, salts, weld flux or other contamination. Where necessary, remove weld spatter and grind smooth all sharp edges and weld seams. Blast clean to BS EN ISO 8501-1:2007 Sa2½, surface profile 50-75 microns, or use a suitable phosphate pre-treatment process, as appropriate. Consult Axalta Coating Systems to check your pre-treatment process is suitable 														
<p>Mixing</p>	<p>Mix only in the proportions stated, mixing each component individually then together using a mechanical agitator.</p>														
<p>Thinner</p>	<p>1728 Thinner</p>		<p>Equipment Cleaner 1728 Thinner</p>												
<p>Application Conditions</p>	<p>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 85% and the steel temperature should remain at least 3°C above the dew point. Paint temperature should ideally be at a minimum of 15°C.</p>														
<p>Application Methods</p>	<table border="1"> <thead> <tr> <th data-bbox="419 875 692 949">Method</th> <th data-bbox="692 875 938 949">Airless Spray</th> <th data-bbox="938 875 1185 949">Conventional Spray</th> <th data-bbox="1185 875 1339 949">Brush</th> <th data-bbox="1339 875 1495 949">Roller</th> </tr> </thead> <tbody> <tr> <td data-bbox="419 949 692 1003"></td> <td data-bbox="692 949 938 1003">Yes</td> <td data-bbox="938 949 1185 1003">Yes</td> <td data-bbox="1185 949 1339 1003">No</td> <td data-bbox="1339 949 1495 1003">No</td> </tr> </tbody> </table>					Method	Airless Spray	Conventional Spray	Brush	Roller		Yes	Yes	No	No
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<ul style="list-style-type: none"> Airless spray: application viscosity 4.5 – 5.5 poise @25°C mixed. Typical tip sizes 11 – 13 thou (0.28-0.33mm) Conventional spray: thin to 30-45 seconds BSB4 cup @25°C for conventional spray. This increases the VOC level Brush and roller should be used for touch-up only Refer to Axalta Coating Systems 'Epoxy Application and Curing Notes' 															
<p>Product Notes</p>	<ul style="list-style-type: none"> Do not apply or cure below 7°C, temperatures above 10°C recommended Product will chalk on prolonged exterior exposure, the degree to which is subject to atmospheric conditions Low flash material - ventilate to keep solvent vapour levels below minimum explosive limit. Observe low flash regulations 														
<p>Health & Safety</p>	<p>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.</p>														

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