

ViterCryl MB35W Primer/Finish

Product Description	A water based acrylic primer/finish specially designed for major OEM suppliers in the Modular Building and related markets.				
Intended Use	<ul style="list-style-type: none">• Water based to aid compliance with SED and environmental legislation• Low in VOC's• Use over steel and Plastisol-type coated steel• Good drying properties• Good roller application properties for small repair areas				
Approvals/ Certification	Please consult Axalta Coating Systems				
Finish	Slight sheen				
Volume Solids	40 ± 2% (varies with colour)				
VOC Content	66 ± 20 g/litre (without water - varies with colour)				
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage	
	Minimum	90 µm	225 µm	4.4 m²/litre	
	Maximum	125 µm	313 µm	3.2 m²/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 100 microns DFT		+10°C	+23°C	+35°C
	Dust Free		3 hr	2 hr	n/a
	Hard Dry		48 hr	24 hr	n/a
	Overcoating*	Minimum	48 hr	24 hr	n/a
		Maximum	Indefinite if clean and sound		
	This is a water based paint. Do not apply below 5°C, temperatures above 10°C are recommended. Temperature will have a marked effect on drying times and susceptibility to damage. Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation				
Colours	Range of colours to customers' requirements				
Product Code	20WSE-				
SG	1.25-1.35 kg/lit mixed (varies with colour)				
Storage Conditions	Store in dry, cool conditions, away from extremes of temperature. Ensure strict stock rotation is carried out. Water based – protect from frost				
Shelf Life	Minimum 12 months if stored as above in unopened containers				
Flash Point	Above 60°C				

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Surface Preparation	<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 Sa2½ (ISO 8501-1:2007), surface profile 50-75 microns Where blast cleaning is impractical the surface should be prepared to St2 (ISO 8501-1:2007) taking care to avoid 'polishing' the surface 				
Mixing	Must be mixed thoroughly by using a mechanical agitator before use. Agitate periodically to ensure paint remains homogeneous.				
Thinner / Cleaner	Clean water				
Application Conditions	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. Only apply this product when the above conditions can be maintained throughout the critical application and drying/curing process. Paint temperature should ideally be at a minimum of 15°C.				
Application Methods	Method	Airless Spray	Conventional Spray	Brush	Roller
		Yes	Yes	Yes	Yes
	<ul style="list-style-type: none"> Airless Spray: output fluid pressure at tip 1500-2000 psi, Tip Size: 13-15 thou (0.33-0.38mm) Air assisted airless: output fluid pressure at tip 1300-1800 psi, Tip Size: 13-15 thou (0.33-0.38mm) Thinning of the coating will reduce the build qualities It is recommended that a mist coat be applied followed by a full coat Brush/roller – use as supplied but suitable for small areas of touch-up only 				
Product Notes	<ul style="list-style-type: none"> For improved corrosion resistance on bare steel, it is recommended that this product is applied over a suitable primer - please consult Axalta Coating Systems for advice If applying over fresh solvent based paint, leave at least 48 hours before applying ViterCryl MB35W As with all water based coatings, sufficient drying time (to remove the water from the applied film) is required before the coating will be water resistant, and able to withstand rain or condensation. Times required will depend on film thickness/humidity/ventilation and temperature during application and initial drying. As a general guide, for typical applications of around 100um dft and 15°C, we would suggest the following times are required under good drying conditions: Resistance to light shower - 24 hours Resistance to heavier rain – 48 hours Full weather resistance – 7 days Drying times will be extended in colder winter conditions, and particularly where there is limited ventilation/heating during application and initial drying 				
Health & Safety	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.				

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