

## Stokes Etch Primer Chromate-Free

|  |   |                           |                           |                             |
|--|---|---------------------------|---------------------------|-----------------------------|
| <b>Product Description</b>               | <b>A single pack pvb etch primer, chromate-free</b> , for steel and non-ferrous metals.   |                           |                           |                             |
| <b>Features &amp; Use</b>                | <ul style="list-style-type: none"> <li>Formulated to be free from zinc chromate to EU Legislation 2007</li> <li>Use as an adhesion promoter for degreased galvanising, aluminium, copper, brass, nickel and cadmium</li> <li>Also suitable for aluminium cladding, galvanised structures and railings</li> <li>Can be overcoated with a wide range of both single pack and two pack products</li> </ul> |                           |                           |                             |
| <b>Approvals/ Certification</b>          | Please consult Axalta Coating Systems   |                           |                           |                             |
| <b>Finish</b>                            | Matt  |                           |                           |                             |
| <b>Volume Solids</b>                     | 14 ± 2% (varies with colour)  |                           |                           |                             |
| <b>VOC Content</b>                       | 700 ± 20 g/litre (varies with colour)   |                           |                           |                             |
| <b>Film Thickness Range And Coverage</b> |   | <b>Dry Film Thickness</b> | <b>Wet Film Thickness</b> | <b>Theoretical Coverage</b> |
|  | <b>Typical</b>  | 12 µm                     | 86 µm                     | 11.6 m <sup>2</sup> /litre  |
|  | Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated   |                           |                           |                             |
| <b>Drying Times</b>                      | Applied to 12 microns DFT   |                           | <b>+10°C</b>              | <b>+23°C</b>                |
|  | <b>Dust Free</b>  |                           | 20 min                    | 10 min                      |
|  | <b>Hard Dry</b>   |                           | 60 min                    | 30 min                      |
|  | <b>Overcoating</b>  | Minimum                   | 60 min                    | 30 min                      |
| Maximum                                  |   | See Product Notes         |                           |                             |
|  | Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation   |                           |                           |                             |
| <b>Colours</b>                           | Grey (IP136), Black (IP220) plus special shades to order  |                           |                           |                             |
| <b>Product Code</b>                      | <b>20ETC-</b>   |                           |                           |                             |
| <b>SG</b>                                | 0.93 kg/lit (varies with colour)  |                           |                           |                             |
| <b>Storage Conditions</b>                | Store in dry, cool conditions and protect from frost  |                           |                           |                             |
| <b>Shelf Life</b>                        | Minimum 6 months if stored as above in unopened containers  |                           |                           |                             |
| <b>Flash Point</b>                       | Below 23°C – low flash material   |                           |                           |                             |



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| <p><b>Surface Preparation</b></p>    | <ul style="list-style-type: none"> <li>• <b>Carbon Steel</b> (non-blasted): thoroughly degrease and prepare to St2 (ISO 8501-1:2007) taking care to avoid 'polishing' the surface</li> <li>• <b>Non-ferrous metals:</b> thoroughly degrease using a propriety biodegradable degreaser to remove all verdigris, salts and other contaminants. Wash with clean fresh water and allow to dry. Very smooth or glossy areas should be lightly abraded to provide a 'key'</li> <li>• 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</li> </ul>  |                    |   |        |  |        |               |                    |       |        |  |     |     |     |     |
|--------------------------------------|--|--------------------|---|--------|--|--------|---------------|--------------------|-------|--------|--|-----|-----|-----|-----|
| <p><b>Mixing</b></p>                 | <p>Must be mixed thoroughly by using a mechanical agitator before use. Agitate periodically to ensure paint remains homogeneous.</p>   |                    |   |        |  |        |               |                    |       |        |  |     |     |     |     |
| <p><b>Thinner</b></p>                | <p>TH001 Thinner</p>   |                    | <p><b>Equipment Cleaner</b> TH001 Thinner</p> |        |  |        |               |                    |       |        |  |     |     |     |     |
| <p><b>Application Conditions</b></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. 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.</p>  |                    |   |        |  |        |               |                    |       |        |  |     |     |     |     |
| <p><b>Application Methods</b></p>    | <table border="1" data-bbox="459 987 1506 1111"> <thead> <tr> <th data-bbox="459 987 703 1059">Method</th> <th data-bbox="703 987 949 1059">Airless Spray</th> <th data-bbox="949 987 1197 1059">Conventional Spray</th> <th data-bbox="1197 987 1351 1059">Brush</th> <th data-bbox="1351 987 1506 1059">Roller</th> </tr> </thead> <tbody> <tr> <td data-bbox="459 1059 703 1111"></td> <td data-bbox="703 1059 949 1111">Yes</td> <td data-bbox="949 1059 1197 1111">Yes</td> <td data-bbox="1197 1059 1351 1111">Yes</td> <td data-bbox="1351 1059 1506 1111">Yes</td> </tr> </tbody> </table> <ul style="list-style-type: none"> <li>• This product would normally be spray applied, with Conventional Spray preferred, as Airless Spray may result in over-application</li> <li>• Airless Spray: output fluid pressure at tip 1500-2500 psi, tip size: 9-13 thou (0.23-0.33mm), thin as required</li> <li>• Conventional Spray: use 40-60psi pressure with 1.4-1.6mm nozzle, thin as required</li> <li>• Brush or roller application should be used for edges and small areas only, thin as required</li> <li>• DO NOT OVER APPLY or splitting of primer by topcoats may result</li> </ul> |                    |   |        |  | Method | Airless Spray | Conventional Spray | Brush | Roller |  | Yes | Yes | Yes | Yes |
| Method                               | Airless Spray  | Conventional Spray | Brush   | Roller |  |        |               |                    |       |        |  |     |     |     |     |
|                                      | Yes  | Yes                | Yes   | Yes    |  |        |               |                    |       |        |  |     |     |     |     |
| <p><b>Product Notes</b></p>          | <ul style="list-style-type: none"> <li>• Do not exceed the recommended dry film thickness</li> <li>• Should not be applied or cured at temperatures below 4°C. Temperature should preferably remain at a minimum of 10°C</li> <li>• Do not use on surfaces operating above of 60°C</li> <li>• Must be protected from weathering prior to being recoated</li> <li>• <b>Caution - contains phosphoric acid</b></li> <li>• <b>Low flash material</b> – ventilate to keep solvent vapour levels below minimum explosive limit and observe low flash regulations</li> </ul>   |                    |   |        |  |        |               |                    |       |        |  |     |     |     |     |
| <p><b>Health &amp; Safety</b></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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