

Aquabond AC500 Primer

Product Description	A water based modified-acrylic anticorrosive primer/finish for cast iron and steel.				
Features & Use	<ul style="list-style-type: none"> • Use as a one coat* anticorrosive primer/finish over suitably prepared cast iron and steel components • Provides 500 hours continuous salt spray under ASTM B117 at 50µm dft • Dipping or spray application • Can be overcoated with Aquabond HP10, Aquabond HP15 and a variety of two pack systems 				
Approvals/ Certification	Arvin Meritor 116/9				
Finish	Matt				
Volume Solids	33 ± 2% (varies with colour)				
VOC Content	28 ± 20 g/litre (varies with colour)				
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage	
	Minimum	25 µm	76 µm	13.2 m ² /litre	
	Maximum	50 µm	152 µm	6.6 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 30 microns DFT	+10°C	+23°C	+35°C	
	Dust Free	40 min	20 min	10 min	
	Hard Dry	1 hr	40 min	30 min	
	Overcoating	Minimum	4 hr	2 hr	1½ hr
		Maximum	Indefinite if clean and sound		
<p align="center">Force drying – see Product Notes Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation.</p>					
Colours	Black, Grey, Red Oxide and special shades to order				
Product Code	04500				
SG	1.32 kg/lit (varies with colour)				
Storage Conditions	Store in dry, cool conditions and protect from frost				
Shelf Life	Minimum 6 months if stored as above in unopened containers				
Flash Point	Above 60°C				

Aquabond AC500 Primer

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 Ideally blast clean to BS EN ISO 8501-1:2007 Sa2½, 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	Mix thoroughly before use														
Thinner	Deionised or soft water		Equipment Cleaner Water												
Application Conditions	<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 80%, the ambient temperature should be above 10°C 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>As with all water based paints, for best results, good ventilation, a minimum temperature of 15°C and Relative Humidity below 70% are recommended.</p>														
Application Methods	<table border="1" data-bbox="451 972 1490 1099"> <thead> <tr> <th data-bbox="451 972 692 1043">Method</th> <th data-bbox="692 972 938 1043">Airless Spray</th> <th data-bbox="938 972 1185 1043">Conventional Spray</th> <th data-bbox="1185 972 1339 1043">Brush</th> <th data-bbox="1339 972 1490 1043">Roller</th> </tr> </thead> <tbody> <tr> <td data-bbox="451 1043 692 1099"></td> <td data-bbox="692 1043 938 1099">Yes</td> <td data-bbox="938 1043 1185 1099">Yes</td> <td data-bbox="1185 1043 1339 1099">No</td> <td data-bbox="1339 1043 1490 1099">No</td> </tr> </tbody> </table> <ul style="list-style-type: none"> Airless Spray: output fluid pressure at tip 1800-2000 psi, Tip Size 15-21 thou (0.38-0.53 mm) Conventional Spray: 50-60psi pressure, 1.4-1.8mm tip size Dipping: thinning ratio should be determined by use, but as a rough guide between 10-25% should give required finish. Avoid the use of hard water. The dip tank and pipe work should be fabricated from suitable corrosion resistant materials. Material should be kept agitated by circulating in a weir-equipped dip tank. Circulation should be carried out using a suitable low shear pump such as diaphragm or peristaltic. High shear pumps must not be used 					Method	Airless Spray	Conventional Spray	Brush	Roller		Yes	Yes	No	No
Method	Airless Spray	Conventional Spray	Brush	Roller											
	Yes	Yes	No	No											
Product Notes	<ul style="list-style-type: none"> Not recommended for prolonged exposure (or force drying) above 80°C This product can be force dried – typical schedule is to allow 5-10 minutes flash off, then 5-10 minutes at 40-70°C *Colours such as yellows, reds and oranges have lower opacity, especially when produced using lead-free pigments. Two or three coats of these shades may be required, relative to only one coat of a grey or red oxide, so that yellows, bright reds and oranges may not be suitable as one coat systems 														
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.														

The information provided herein corresponds to our knowledge on the subject at the date of its publication. This information may be subject to revision as new knowledge and experience becomes available. The data provided fall within the normal range of product properties and relate only to the specific material designated; these data may not be valid for such material used in combination with any other materials or additives or in any process, unless expressly indicated otherwise. The data provided should not be used to establish specification limits or used alone as the basis of design; they are not intended to substitute for any testing you may need to conduct to determine for yourself the suitability of a specific material for your particular purposes. Since Axalta cannot anticipate all variations in actual end-use conditions Axalta makes no warranties and assumes no liability in connection with any of this information. Nothing in this publication is to be considered as a license to operate under or a recommendation to infringe any patent rights. This product is for professional use only.