

## ViterCoat ACP Primer

<b>Product Description</b>	<b>An economic, compliant high solids two pack epoxy primer</b> , specially designed for use with ViterThane HS and 525 series polyurethane topcoats for the ACE market.			
<b>Features &amp; Use</b>	<ul style="list-style-type: none"> <li>• No topcoat sinkage, so high gloss, high performance topcoats can be applied</li> <li>• Excellent application and drying properties</li> <li>• Good salt spray resistance</li> <li>• Suitable for application by airless or conventional spray</li> <li>• Excellent adhesion to blast cleaned, degreased or phosphated steel</li> <li>• Used for the high performance coating of stone crushing, agricultural, construction and earthmoving equipment</li> </ul>			
<b>Approvals/ Certification</b>	Please consult Axalta Coating Systems			
<b>Finish</b>	Semi-matt			
<b>Volume Solids</b>	67 ± 5% (varies with colour)			
<b>VOC Content</b>	300 ± 20 g/litre (varies considerably with colour)			
<b>Film Thickness Range And Coverage</b>		<b>Dry Film Thickness</b>	<b>Wet Film Thickness</b>	<b>Theoretical Coverage</b>
	<b>Minimum</b>	25 µm	37 µm	26.8 m <sup>2</sup> /litre
	<b>Maximum</b>	75 µm	112 µm	8.9 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 75 microns DFT	<b>+23 °C</b>		
	<b>Flash Off</b>	20 - 30 mins		
	<b>Air Dry</b>	Touch Dry – 2 hrs; Hard Dry - overnight		
	<b>Force Dry</b>	20 - 30 mins @60 - 80°C		
	<b>Overcoating</b>	Wet-on-wet after 30 mins		
	Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation			
<b>Colours</b>	TVT 4001 and shades to order			
<b>Mix Ratio/ Product Code</b>	Base	3408 series	3 parts by volume	
	Hardener	4065032	1 part by volume (see Product Notes)	
<b>Pot Life</b>	4 hrs to double in viscosity at 25°C			
<b>SG</b>	1.40 - 1.45 kg/lit mixed (varies with colour)			
<b>Storage Conditions</b>	Store in dry, cool conditions and protect from frost			
<b>Shelf Life</b>	Minimum 12 months if stored as above in unopened containers			
<b>Flash Point</b>	23-60°C			

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<p><b>Surface Preparation</b></p>	<ul style="list-style-type: none"> <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> <li>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</li> </ul>														
<p><b>Mixing</b></p>	<p>Mix only in the proportions stated, mixing each component individually then together using a mechanical agitator.</p>														
<p><b>Thinner</b></p>	<p>1728 Thinner</p>		<p><b>Equipment Cleaner</b> 1728 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. Paint temperature should ideally be at a minimum of 15°C.</p>														
<p><b>Application Methods</b></p>	<table border="1"> <thead> <tr> <th data-bbox="419 898 692 972">Method</th> <th data-bbox="692 898 938 972">Airless Spray</th> <th data-bbox="938 898 1185 972">Conventional Spray</th> <th data-bbox="1185 898 1339 972">Brush</th> <th data-bbox="1339 898 1495 972">Roller</th> </tr> </thead> <tbody> <tr> <td data-bbox="419 972 692 1025"></td> <td data-bbox="692 972 938 1025">Yes</td> <td data-bbox="938 972 1185 1025">Yes</td> <td data-bbox="1185 972 1339 1025">No</td> <td data-bbox="1339 972 1495 1025">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"> <li>Airless spray: Tip size 11 – 13 thou typical</li> <li>Conventional spray: thin to 30-45 seconds BSB4 cup @25°C for conventional spray. This increases the VOC level</li> <li>Brush and roller should be used for touch-up only</li> <li>Refer to Axalta Coating Systems '<b>Epoxy Application and Curing Notes</b>'</li> </ul>															
<p><b>Product Notes</b></p>	<ul style="list-style-type: none"> <li>Do not apply or cure below 7°C, temperatures above 10°C recommended</li> <li>Product will chalk on prolonged exterior exposure, the degree to which is subject to atmospheric conditions</li> <li>An alternative hardener, 4065033 (at 4:1 mix ratio and giving shorter 2 hr pot life), is available for different mixed viscosity – please consult Axalta Coating Systems for details</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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