

ViterCoat GF Primer

Product Description	A two pack epoxy primer for the ACE market.			
Features & Use	<ul style="list-style-type: none"> • Fast air drying or force dried with good corrosion resistance • Designed for overcoating with a range of standard Axalta Coating Systems topcoats and special products made to customer specifications • Suitable for application by airless or conventional spray • Excellent adhesion to thoroughly degreased mild steel, blast cleaned steel or phosphated steel. • Used for the high performance coating of stone crushing, agricultural, construction and earthmoving equipment 			
Approvals/ Certification	Please consult Axalta Coating Systems			
Finish	Semi-matt			
Volume Solids	42 ± 5% depending on colour			
VOC Content	512 ± 20 g/litre (varies with colour and mix ratio)			
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage
	Minimum	25 µm	60 µm	16.8 m ² /litre
	Maximum	45 µm	107 µm	9.3 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	Buff, Black, Grey and Honey Yellow			
Mix Ratio/ Product Code	Base	3377216 Light Grey, or 3377502 Yellow, or 3377100 White	2.5 parts by volume 2.5 parts by volume 2.5 parts by volume	
	Hardener	4065011	1 part by volume	
	Mix ratio for other shades varies from 2:1 to 3½:1 depending on colour			
Pot Life	4 hrs to double in viscosity at 25°C Gel time is 8 hrs at 25°C			
SG	1.3 – 1.5 kg/lit unmixed, 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	23 - 60°C			

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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="451 907 692 969">Method</th> <th data-bbox="692 907 938 969">Airless Spray</th> <th data-bbox="938 907 1185 969">Conventional Spray</th> <th data-bbox="1185 907 1337 969">Brush</th> <th data-bbox="1337 907 1490 969">Roller</th> </tr> </thead> <tbody> <tr> <td data-bbox="451 969 692 1025"></td> <td data-bbox="692 969 938 1025">Yes</td> <td data-bbox="938 969 1185 1025">Yes</td> <td data-bbox="1185 969 1337 1025">No</td> <td data-bbox="1337 969 1490 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"> Airless spray: Tip size 11 – 13 thou (0.28-0.33mm) typical. Application viscosity 4.5 – 5.5 poise at 25°C mixed 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 5°C, temperatures above 10°C recommended Product will chalk on prolonged exterior exposure, the degree to which is subject to atmospheric conditions 														
<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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