

ViterEtch CFE PVB Etch Chromate-free

Product Description	A two pack pvb etch primer, chromate-free , for steel and non-ferrous metals.				
Features & Use	<ul style="list-style-type: none"> • Formulated to be free from zinc chromate to EU Legislation 2007 • Use as an adhesion promoter for degreased galvanising, aluminium, copper, brass, nickel and cadmium • Also suitable for aluminium cladding, galvanised structures and railings • May be applied as a sealer coat to aluminium and zinc metal spray • Can be used as a 'wash' primer on smooth ferrous substrates • Suitable for the commercial vehicle and steel fabrication industry • Can be overcoated with a wide range of both single pack and two pack products 				
Approvals/ Certification	Please consult Axalta Coating Systems				
Finish	Matt				
Volume Solids	12 ± 2%				
VOC Content	720 ± 20 g/litre				
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage	
	Typical	5 µm	42 µm	24.0 m ² /litre	
	Maximum	10 µm	83 µm	12.0 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 10 microns DFT		+10°C	+23°C	+35°C
	Dust Free		40 min	20 min	5 min
	Hard Dry		80 min	30 min	15 min
	Overcoating	Minimum	8 hr	4 hr	2 hr
		Maximum	24 hr		
Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation					
Colours	Buff				
Mix Ratio/ Product Code	Base	6070 815	1 part by volume		
	Hardener	4067 007	1 part by volume		
Pot Life	8 hours at 23°C				
SG	0.89-0.93 kg/lit mixed				
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	Below 23°C – low flash material				



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<p>Surface Preparation</p>	<ul style="list-style-type: none"> • Carbon Steel (non-blasted): thoroughly degrease and prepare to St2 (ISO 8501-1:2007) taking care to avoid 'polishing' the surface • Galvanised Steel: thoroughly degrease using a propriety biodegradable degreaser, rinse with clean fresh water and allow to dry before coating. It is essential to remove all flux, zinc salts and high profile zinc spatter. Very smooth or glossy areas should be lightly abraded to provide a 'key' • Aluminium, Copper, Brass, Cadmium and Nickel: 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' • Zinc and Aluminium Metal Spray: ensure the surface is dust free and no salt formation has occurred. Apply the material until absorption is complete • 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 										
<p>Mixing</p>	<p>Mix only in the proportions stated, mixing each component individually then together using a mechanical agitator. Agitate periodically during use to ensure product remains homogeneous. Mix immediately prior to using. Mixed material must be discarded after 8 hours at 23°C.</p>										
<p>Thinner</p>	<p>950 Thinner Equipment Cleaner 950 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. 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>Application Methods</p>	<table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th style="width: 25%;">Method</th> <th style="width: 25%;">Airless Spray</th> <th style="width: 25%;">Conventional Spray</th> <th style="width: 25%;">Brush</th> <th style="width: 25%;">Roller</th> </tr> </thead> <tbody> <tr> <td></td> <td style="text-align: center;">Yes</td> <td style="text-align: center;">Yes</td> <td style="text-align: center;">Yes</td> <td style="text-align: center;">No</td> </tr> </tbody> </table> <ul style="list-style-type: none"> • Airless Spray: Output fluid pressure at tip 1500-2500 psi, Tip Size: 9-13 thou (0.23-0.33mm) • Avoid sags and runs particularly when application is by brush 	Method	Airless Spray	Conventional Spray	Brush	Roller		Yes	Yes	Yes	No
Method	Airless Spray	Conventional Spray	Brush	Roller							
	Yes	Yes	Yes	No							
<p>Product Notes</p>	<ul style="list-style-type: none"> • Do not exceed the maximum stated dry film thickness • Should not be applied or cured at temperatures below 4°C. Temperature should preferably remain at a minimum of 10°C • Do not use on surfaces operating above of 60°C • Must be protected from weathering prior to being recoated • Inadequate surface preparation will result in poor coating adhesion. • Caution - contains phosphoric acid • Low flash material – ventilate to keep solvent vapour levels below minimum explosive limit and observe low flash regulations 										
<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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