

ViterCryl HBC-W Primer/Finish

Product Description	A low VOC, single pack, water based anticorrosive primer/finish for the ACE market. It is also suitable for the coating of some plastics.			
Features & Use	<ul style="list-style-type: none"> • Low VOC's, below previous 'compliant' level of 250gm/lt. • Fast air drying properties • Good corrosion resistance • Suitable for application by airless or conventional spray • Excellent adhesion to blast cleaned, degreased or phosphated steel • Suitable for use on some plastics • Used for the high performance coating of structural steelwork, stone crushing, agricultural, construction and earthmoving equipment 			
Approvals/ Certification	Please consult Axalta Coating Systems			
Finish	Low gloss			
Volume Solids	42 ± 3% depending on colour			
VOC Content	128 ± 20 g/litre (inc. water), 233 ± 20 g/litre (without water), varies with colour			
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage
	Minimum	25 µm	59 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 30 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 20 - 30 mins		
Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation.				
Colours	Black and full range of colours to customer specifications			
Product Code	3448 (existing shades) and 3451 (new shades)			
SG	1.14 – 1.24 kg/lt, 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	Above 60°C			

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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 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 														
Mixing	Mix thoroughly before use														
Thinner	Potable water		Equipment Cleaner 1921 Cleaner												
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"> <thead> <tr> <th data-bbox="448 954 692 1025">Method</th> <th data-bbox="692 954 938 1025">Airless Spray</th> <th data-bbox="938 954 1185 1025">Conventional Spray</th> <th data-bbox="1185 954 1339 1025">Brush</th> <th data-bbox="1339 954 1489 1025">Roller</th> </tr> </thead> <tbody> <tr> <td data-bbox="448 1025 692 1084"></td> <td data-bbox="692 1025 938 1084">Yes</td> <td data-bbox="938 1025 1185 1084">Yes</td> <td data-bbox="1185 1025 1339 1084">No</td> <td data-bbox="1339 1025 1489 1084">No</td> </tr> </tbody> </table>	Method	Airless Spray	Conventional Spray	Brush	Roller		Yes	Yes	No	No				
Method	Airless Spray	Conventional Spray	Brush	Roller											
	Yes	Yes	No	No											
<ul style="list-style-type: none"> Airless spray: typical tip sizes 11 – 13 thou (0.28-0.33mm) Brush and roller should be used for touch-up only 															
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.														

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