

Product Data Sheet

September 2006

INTERNATIONAL MASTER
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T3000V

Anti-Corrosive Primer P540-51x

<i>Product</i>	<i>Description</i>
P540-511	Anti-Corrosive Primer - off-white
P540-512	Anti-Corrosive Primer - grey
P540-514	Anti-Corrosive Primer - grey
P540-515	Anti-Corrosive Primer - beige
P210-788	Activator
P850-1335	Fastbuild™ Thinner
P850-1597	Thinner (Medium)
P850-1041	Thinner (Slow)

Product Description

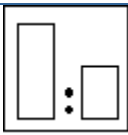





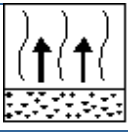
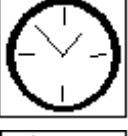

Anti-Corrosive Primer has excellent anti-corrosive properties making it an ideal primer for new steel chassis. It has been specially designed for application by HVLP spray and is formulated to give a maximum application VOC level of 540 g/l, when used in accordance with this PDS. It can be used under **Nexa Autocolor** Commercial Transport 1-pack and 2-pack topcoats as a 1- or 2-pack undercoat.



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Process

	HVLP High-Build Primer	HVLP General Purpose Primer	HVLP Activated Primer
	Anti-Corrosive Primer 7-8 parts Thinner of choice 1 part	Anti-Corrosive Primer 6 parts Thinner of choice 1 part	Anti-Corrosive Primer 3 parts P210-0788 1 part (Do not use thinner P850-1335 when activating)
			Pot Life at 20°C : 4 hours Clean gun immediately after use
	36-43 secs DIN4 (50-60 secs BSB4)	36-43 secs DIN4 (50-60 secs BSB4)	20-26 secs DIN4 (25-35 secs BSB4)
	1.4 mm Air cap pressure : 0.675 bar (10psi maximum)	1.0-1.4 mm Air cap pressure : 0.675 bar (10psi maximum)	1.0-1.4 mm Air cap pressure : 0.675 bar (10psi maximum)
	Pressure Pot : 1.0-1.4 mm Pressure at cap : 0.675 bar (10 psi maximum) Paint pressure : 0.3-1.0 bar (5-15 psi)	Pressure Pot : 1.0-1.4 mm Pressure at cap : 0.675 bar (10 psi maximum) Paint pressure : 0.3-1.0 bar (5-15 psi)	Pressure Pot : 1.0-1.4 mm Pressure at cap : 0.675 bar (10 psi maximum) Paint pressure : 0.3-1.0 bar (5-15 psi)
	2 coats 50-75 microns (2.0-3.0 thou)	2 coats minimum 37-62 microns (1.5-2.5 thou)	2 coats minimum 37-62 microns (1.5-2.5 thou)
	For optimum protection of steel the primer dry film thickness should be a minimum of 50 microns (2 thou). On blast cleaned steel this should be 50 microns (2 thou) as measured above the blast cleaned peaks. Additional coats may be necessary depending on application equipment used, spraying technique, substrate profile and chosen thinning ratio.		
	20 minutes between coats		
	Air dry (20°C) Recoat : Minimum of 30 minutes - 4 hours - Overnight for optimum appearance Handleable : Approx. 2 hours Hard dry : Overnight		
	Flattig is not recommended unless it is necessary to remove dirt or runs and should be denibbed lightly when hard dry (minimum overnight dry)		

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General Process Notes

SUBSTRATES AND PREPARATION

SUBSTRATES	PREPARATION	NOTES
Steel	Blast cleaning is the preferred surface treatment for maximum durability and optimum paint usage. Alternatively flat thoroughly using P80-P180 dry sanding machine discs (P120-P220 wet and dry paper), then clean with P850-1378	Surface must be free from oil/grease, millscale and rust.
Sound Factory Finishes Sound Works Primer Sound old finishes (1- & 2-pack) Sound electrocoat Small areas of aluminium	Flat thoroughly using P240-P320 dry sanding machine discs (P400 wet and dry paper), then clean with P850-1378	
GRP "Glasonite"	Clean with P273-901. Flat thoroughly using P240-P280 dry sanding machine discs (P320-P400 wet and dry paper), then clean with P850-1378.	Take care not to break through the gel coat when flattening GRP.

For more detailed information on the preparation of specific substrates, see "Preparation and Pre-treatment" PDS.

RECOAT

Drying times will depend on film thickness and drying conditions. In common with other primers longer drying times before recoat will improve final appearance. May be recoated with **Nexa Autocolor** Commercial Transport 1-pack undercoats (e.g. Repaint Undercoat P595-line) or directly topcoated with **Nexa Autocolor** Commercial Transport 1-pack and 2-pack topcoats. See appropriate PDS for further details.

Anti-Corrosive Primer must **NOT** be recoated directly with a basecoat/clear system, e.g. Turbo Plus™ Multistripe, P492- line or P497- line , **unless** it has been activated.

To enhance the final appearance of EHS Hi-Gloss 383™ it is recommended that Repaint Undercoat (P595-line) is applied before topcoating.

Vehicles primed with Anti-Corrosive Primer left under cover for up to 6 weeks can be overcoated without flattening. Steam clean or wash using P273-901, dry and thoroughly degrease before overcoating. Primer left longer than 6 weeks should be flattened before applying other materials.

N.B If recoating P540-514 with P498-line topcoat, the primer must be activated.

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General Process Notes

APPLICATION EQUIPMENT INFORMATION

HVLP

The most suitable HVLP gun for the application of Commercial Transport products is the pressure feed system.

Air cap pressure : 0.675 bar (10 psi) maximum

Paint pressure : 0.3-1.0 bar (5-15 psi) maximum

If long fluid lines are used, the paint pressure will need to be increased.

Airless/Air Assisted Airless

P540-51X primers are **NOT** recommended for airless or air assisted airless (air mix) application.

DRYING

The drying times quoted are approximate times and will vary depending on drying conditions and film thickness. Poor ventilation, temperatures below 20°C and excessive film thickness will extend the drying times.

HARDENER ADDITION

2-pack topcoats may be applied directly over Anti-Corrosive Primer. Where build is not so important, Anti-Corrosive Primer can be Isocyanate hardened by adding Activator P210-788. This will give superior through dry, appearance, stone chip resistance and can be used as a sealer for old synthetics. (NB. cannot be used as a bleeding inhibitor sealer).

Do **NOT** use Thinner P850-1335 with Isocyanate hardened Anti-Corrosive Primer.

Isocyanate cured Anti-Corrosive Primer may be recoated with EHS Hi-Gloss 383.

CORROSION PROTECTION

For maximum corrosion protection the dry film thickness should not fall below 50 microns (2 thou) as measured above the blast cleaned peaks.

HOLDING PRIMER

When used as a holding primer over steel, Anti-Corrosive Primer will protect vehicles or components for up to 1 year. A dry film thickness of 75-100 microns (3-4 thou) is recommended for this purpose.

COVERAGE

Approximately 4m² per litre of ready for use paint at a dry film thickness of 50 microns (2 thou).



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VOC INFORMATION

The EU limit value for this product (product category: IIB.c) in ready to use form is max. 540g/litre of VOC.

The VOC content of this product in ready to use form is max. 540g/litre.

Depending on the chosen mode of use, the actual ready to use VOC of this product may be lower than that specified by the EU Directive code.

These products are for professional use only, and are not to be used for purposes other than those specified. The information on this TDS is based on present scientific and technical knowledge, and it is the responsibility of the user to take all necessary steps in order to ensure the suitability of the product for the intended purpose.

For Health and Safety information please refer to the material Safety Data Sheet, also available at: http://www.ppg.com/Autocolor_MSDS

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