

Product Data Sheet

April 2010

INTERNATIONAL MASTER
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T3500V

Waterborne Epoxy Primer P950-650x

<i>Product</i>	<i>Description</i>
<i>P950-6501</i>	<i>Waterborne Two-Pack Epoxy Primer White</i>
<i>P950-6502</i>	<i>Waterborne Two-pack Epoxy Dark Grey</i>
<i>P980-6550</i>	<i>Activator for Waterborne Epoxy Primer</i>
<i>P980-249</i>	<i>Waterborne Medium Thinner</i>
<i>P980-2505</i>	<i>Waterborne Slow Thinner</i>
<i>P980-6000</i>	<i>Waterborne Degreaser</i>
<i>P850-1367</i>	<i>Degreaser</i>
<i>P980-212</i>	<i>Waterborne Gunwash</i>

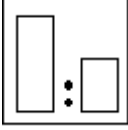

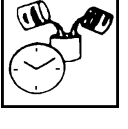







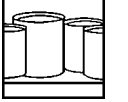
Product Description

This is a waterborne two-pack epoxy for HVLP Application. It is a low VOC (<250g/l RFU) primer designed for use in compliant workshops. It offers excellent corrosion resistance, fast dry, and low odour, with excellent holdout of the topcoat



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PROCESS

	<p>P950-6501/ 6502 P980-6550 P980-249/-2505</p>	<p>HVLP</p> <p>8 parts Paint by volume 1 part Activator by volume Mix thoroughly and then add 2-3 parts Thinner by volume</p> <p>Ensure that paint and activator are thoroughly mixed before addition of thinner The product needs min. 15' of induction time before spray.</p>
	<p>32 - 38 secs DIN 4 cup (when mixed 8/1/2).</p> <p>Based on resin viscosity and product rheology we could have a variation from 8:1:2,5 to 8:1:3 (in volume).</p>	
	<p>Pot-life 1.5 hours (at 20°C).</p> <p>Note: Material does not gel, but must not be used beyond 1.5 hours after mixing.</p>	
	<p>Compliant Pressure Feed Application</p> <p>1.2 mm Fluid Tip / 2-2½ bar input pressure at gun handle. 400 cc/min fluid delivery.</p>	
	<p>Compliant Gravity Feed Application</p> <p>1.8 mm Fluid Tip (Gravity Feed). 2.0-2.2 mm Fluid Tip (Suction Feed).</p>	
	<p>Equipment should be cleaned with Waterborne Gun Cleaner (P980-212) immediately after use. Final clean with solvent.</p>	
	<p>One double or two single full coats depending on film weight required.</p>	
	<p>Low Bake 30 minutes at 60°C. (metal temperature).</p>	
	<p>Air Dry at least for 60 mins before recoat or 4-5 hours before flattening. If low baked, allow to cool to room temperature before denibbing.</p>	
	<p>May be hand denibbed at recommended time with either P320 paper or Scotchbrite.</p> <p>May be flattened at recommended time with open mesh P320 disks.</p>	
	<p>Store indoors and transport at temperatures above 5°C.</p> <p>DO NOT ALLOW TO FREEZE, DO NOT STORE IN DIRECT SUNLIGHT</p>	

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PROCESS – SANDABLE MODE – MIXING AND APPLICATION

	<table border="0"> <thead> <tr> <th></th> <th style="text-align: center;">By volume</th> <th style="text-align: center;">By Weight</th> </tr> </thead> <tbody> <tr> <td>P950-6501/6502</td> <td style="text-align: center;">8</td> <td style="text-align: center;">110g</td> </tr> <tr> <td>P980-6550</td> <td style="text-align: center;">1</td> <td style="text-align: center;">10g</td> </tr> <tr> <td>P980-249 / -2505</td> <td style="text-align: center;">1</td> <td style="text-align: center;">10g</td> </tr> </tbody> </table>		By volume	By Weight	P950-6501/6502	8	110g	P980-6550	1	10g	P980-249 / -2505	1	10g
	By volume	By Weight											
P950-6501/6502	8	110g											
P980-6550	1	10g											
P980-249 / -2505	1	10g											
<p>Important: Mix primer and hardener until homogeneous, before the addition of thinner. After adding thinner, mix again. An induction period of 15 minutes after mixing is necessary, before use. * P980-2505 Thinners should be used in high temperature conditions (above 35°C).</p>													
	<p>The pot life is 1.5 hours at 20°C. Note: Material does not gel, but must not be used beyond 1.5 hours after mixing.</p>												
	<p>60 - 65 seconds DIN 4 at 20°C</p>												
	<p>Fluid Tip 1.6 - 1.8 mm Pressure : Refer to spraygun manufacturers recommendations For best results use gravity feed spraygun.</p>												
	<p>2 - 3 single coats maximum (100 - 150 microns)</p>												
	<p>Allow 5 - 10 minutes flash off between coats @ 20°C or until the primer is matt. Allow 5 - 10 minutes flash off before bake @ 20°C or until the primer is matt.</p>												
	<p>Dry to Sand – 30 minutes at 60°C</p>												

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General Process Notes

NOTE

It is essential that all substrates are free from any surface contamination such as oil and grease, millscale and rust.

SUBSTRATES AND PREPARATION

Original finish and works primer in sound condition, GRP, and well prepared steel. Old 1-pack and 2-pack finishes in good condition.

Substrate should be free from grease, and thoroughly cleaned with either P980-6000 Waterborne Degreaser or P850-1367 Cleaner and Degreaser.

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

RECOAT

Recoat times will depend on film thickness and drying conditions. i.e. air-flow and temperature. In common with other primers, slightly longer drying times before recoat will improve final appearance. May be recoated with Nexa Autocolor commercial transport topcoats. See appropriate PDS for further details

CORROSION PROTECTION

For optimum protection of steel, the primer dry film thickness should be a minimum of 60 microns. On blast cleaned steel this should be 60 microns as measured above the peaks. The blasting standard should be SA2½ with an average blast profile of 30 microns.

To enhance even further, use over substrate coated with Primecoat (P565-625)

DRYING

The drying times quoted are approximate times and will vary depending on drying conditions and film thickness. Poor ventilation, temperatures below 20°C, humidities above 85% RH and excessive film thickness will extend the drying times.

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COVERAGE

Approximately 6-7 m² per litre of ready for use paint at a dry film thickness of 60 microns.

ADDITIONAL INFORMATION

1. This product should only be used in areas with good air movement and force-dry facilities.
2. This product has a VOC of less than 250 g/l.
3. This product must not be mixed with any activators or thinners other than those recommended.
4. This product should NOT be used as a holding primer.
5. Waterborne waste should be minimised and segregated from solventborne waste.

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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

For further information please contact:

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