

# Product Data Sheet

September 2006



FOR PROFESSIONAL USE ONLY

## T1000V

### High-Build Anti-Corrosive Primer P540-414 /-418

<i>Product</i>	<i>Description</i>
<i>P540-414 /-418</i>	<i>High-Build Anti-Corrosive Primer</i>
<i>P850-1335</i>	<i>Fastbuild™ Thinner</i>

#### Product Description

High-Build Anti-Corrosive Primer (P540-414/-418) has been designed for airless and air assisted application over blast cleaned structural steel components such as chassis. It has excellent application properties and offers a high level of protection when applied to the correct film thickness over a carefully prepared substrate.



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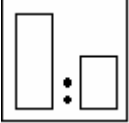




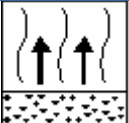


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**PROCESS**

**Airless and Air Assisted Airless (Air Mix) Application**

	<p>No thinning normally required</p> <p><b>NOTE :</b> Up to 10% P850-1335 may be added if lower film weights are required, E.g. when used as weldable temporary protection primer.</p>
	
	<p>Ready for use</p>
	<p><b>Airless :</b> 0.33 - 0.43 mm (13-17 thou) 20-60° angle</p> <p>Paint pressure : 100-200 bar (1500-3000 psi)</p> <p><b>Air Assisted Airless (Air Mix) :</b> 0.33 - 0.43 mm (13-17 thou) 20-60° angle</p> <p>Paint pressure : 50-60 bar (800-1000 psi) Air cap pressure : up to 1.6 bar (25 psi)</p>
	<p>1-2 coats 50 microns (2 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.</p> <p>The total dry film thickness should not exceed 125 microns (5 thou).</p>
	<p>10-20 mins between coats, depending on film thickness and drying conditions.</p>
	<p><b>Air dry (20°C)</b> Recoat : Minimum of 2 hours - Overnight for optimum appearance Handleable : Approx. 2 hours Hard dry : Overnight</p>
	<p>Flattening is not recommended unless it is necessary to remove dirt or runs and should be denibbed lightly when hard dry (minimum overnight dry)</p>



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## General Process Notes

### SUBSTRATES AND PREPARATION

Steel, blast cleaned steel, sound works primer.

Hot and cold rolled steel should be free from loose scale and rust and thoroughly degreased by hand solvent cleaning. Blast cleaning is the preferred surface treatment for maximum durability and optimum paint usage. Alternatively flat thoroughly using P80-P180 dry sanding machine discs or P120-P220 wet and dry paper, then clean with P850-1378.

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 and 2-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.

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

Vehicles primed with P540-414/-418 under cover for up to 6 weeks can be overcoated without flattening. Steam clean or wash using Bodyklean (P273-901), dry and thoroughly degrease before overcoating. Primer left longer than 6 weeks should be flattened before applying other materials.

### APPLICATION EQUIPMENT INFORMATION

#### Hot Spray

May be applied hot via airless and air assisted airless (air mix).

### 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.

### CORROSION PROTECTION

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

### HOLDING PRIMER

When used as a holding primer over steel P540-414/-418 will protect vehicles or components for up to 1 year. It is recommended that 2 coats airless spray be applied to give a dry film thickness of 75-100 microns (3-4 thou) for this purpose.

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**WELDING**

P540-414 can be welded at low film weights when hard dry. It conforms to the UK Health and Safety Executive Guidance Note EH 40 "Occupational Exposure Limits". When sprayed for welding purposes the dry film thickness of P540-414 should NOT exceed 25 microns (1 thou). At this film thickness P540-414 can only be used for temporary protection as a holding primer. Further coats of primer should be applied to achieve maximum durability.

**COVERAGE**

Approximately 7-8m<sup>2</sup> per litre of ready for use paint at a dry film thickness of 50 microns (2 thou).

**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](http://www.ppg.com/Autocolor_MSDS)

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