

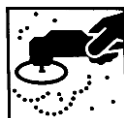
5-8070

2K PU PRIMER

PRODUCT DESCRIPTION

2K PU primer is a two components waterborne polyurethane light grey primer designed for protection of steel, aluminium and galvanized steel surfaces with full waterborne paint systems. It is suitable for use in moderately aggressive environments and providing good resistance to water, solvents and good resistance to abrasion. 5-8070 PU primer has been developed to offer corrosion protection that is equal to better than performances of solvent-borne coatings.

SELECTION AND PREPARATION OF SUBSTRATES



Bare steel
Aluminium
Galvanized steel

Sand
P80-120 (dry)
P240-320 (dry)
Scotch Brite (dry)



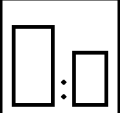
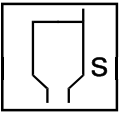

Degrease

All surfaces should be thoroughly degreased using the appropriate cleaner
Degrease thoroughly prior to painting. All substrates should be free from any supports contamination such as oil, grease and rust.

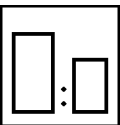
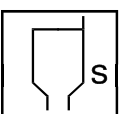

HARDENER SELECTION

9-574 (Medium Hardener):	Suitable from 15°C to 35°C (Large surfaces)
9-572 (Slow Hardener):	Suitable from 35°C to 45°C (Large Surfaces)
9-110 (Medium Single Stage Hardener):	Suitable from 15°C to 25°C (Low VOC)
9-125 (Fast Curing Single Stage Hardener):	Suitable from 15°C to 25°C (Low VOC)

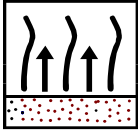
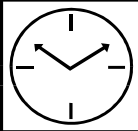
APPLICATION GUIDE - 9-574 / 9-572 Hardeners

		AIRMIX	CONVENTIONAL
	<i>Mixing ratio (by weight):</i>	5-8070 1000 9-574 or 9-572 400	5-8070 1000 9-574 or 9-572 400
	<i>Mixing ratio (by volume):</i>	5-8070 2 9-574 or 9-572 1	5-8070 2 9-574 or 9-572 1
	<i>Thinning:</i>	Thoroughly mix primer and hardener and then add: 5-10% with water (*) (*) It is very important to thoroughly mix topcoat and hardener during 5 minutes before adding water	Thoroughly mix primer and hardener and then add: 15-25% with water (*) (*) It is very important to thoroughly mix topcoat and hardener during 5 minutes before adding water
	<i>Pot life 20°C:</i>	2 hours	2 hours
	<i>Spray viscosity:</i>	55 - 65 sec DIN6 @20°C	30 - 40 sec DIN4 at @20°C
	<i>Spray gun set up:</i>	09-13 thou tip	1.8 mm
	<i>Spray pressure:</i>	90-100 bar (3.5 bar air atomization)	2-3 bar
	<i>Number of coats:</i>	1 visit (1 light/dust coat followed by 1 full coat) Or 2 medium coats to get higher film build	2 medium coats

APPLICATION GUIDE - 9-110 / 9-125 Hardeners

		AIRMIX	CONVENTIONAL
	<i>Mixing ratio (by weight):</i>	5-8070 1000 9-110 or 9-125 200	5-8070 1000 9-110 or 9-125 200
	<i>Mixing ratio (by volume):</i>	5-8070 4 9-110 or 9-125 1	5-8070 4 9-110 or 9-125 1
	<i>Thinning:</i>	Thoroughly mix primer and hardener and then add: 5-10% with water (*) (*) It is very important to thoroughly mix topcoat and hardener during 5 minutes before adding water	Thoroughly mix primer and hardener and then add: 15-25% with water (*) (*) It is very important to thoroughly mix topcoat and hardener during 5 minutes before adding water
	<i>Pot life 20°C:</i>	2 hours	2 hours
	<i>Spray viscosity:</i>	25-35 sec DIN6 at 20°C	20-30 sec DIN4 at 20°C
	<i>Spray gun set up:</i>	09-13 thou tip	1.8 mm
	<i>Spray pressure:</i>	90-100 bar (3.5 bar air atomization)	2-3 bar
	<i>Number of coats:</i>	1 visit (1 light/dust coat followed by 1 full coat) Or 2 medium coats to get higher film build	2 medium coats

APPLICATION GUIDE

 <p><i>Flash off between coats:</i></p> <p><i>Flash off before stoving:</i></p>  <p><i>Drying times at 60°C (metal T°):</i></p> <p><i>Drying times at 20°C:</i></p> <p><i>Dust free :</i></p> <p><i>Touch free:</i></p> <p><i>Handling:</i></p> <p><i>Recommended thickness:</i></p>	AIRMIX 1 visit	AIRMIX 2 coats	CONVENTIONAL 2 coats
	5 minutes at 20°C (*)	30 to 45 minutes at 20°C and until the first coat is fully matt (*)	15 to 25 minutes at 20°C and until the first coat is fully matt (*)
	30 to 45 minutes at 20°C and until the second coat is fully matt (*)	30 to 45 minutes at 20°C and until the second coat is fully matt (*)	30 to 45 minutes at 20°C and until the second coat is fully matt (*)
	20 to 30 minutes (*)	20 to 30 minutes (*)	20 to 30 minutes (*)
	20-25 minutes (*)	20-25 minutes (*)	20-25 minutes (*)
	4-6 hours (*)	4-6 hours (*)	4-6 hours (*)
	6-8 hours (*)	6-8 hours (*)	6-8 hours (*)
80-100 microns	100-140 microns	80-100 microns	
<p><i>Overcoatable with:</i></p> <p><i>Overcoat time at 20°C:</i></p>	<p>2K Selemix System Topcoats (7-512 and 7-110) or Selemix Aqua Topcoats</p> <p>After 4-6 hours air dry or overnight as preferred option (*). If baked it can be recoated after the baking time and when substrate has cooled down</p> <p>(*) Drying and recoating times are related to the film thickness, temperature, relative humidity and ventilation</p>		

TECHNICAL DATA

Theoretical coverage: 6.6-7.6 m²/l of paint ready to use for 50µm of thickness

Primer	Hardener	Primer:Hardener ratio by weight	Water %	Density in Kg/L	Solids % by Weight	Solids % by Volume
5-8070	9-110 or 9-125	100/20	5 to 25%	1,18-1,22	47-54%	36-43%
5-8070	9-572	100/40	5 to 25%	1,14-1,17	41-50%	30-36%
5-8070	9-574	100/40	5 to 25%	1,13-1,16	41-47%	30-36%

Storage: STORE FREE FROM FROST ABOVE 4°C. Prolonged exposure to high temperatures or direct sources of heat should be avoided

HEALTH AND SAFETY

These products are for professional painting 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.selemix.com/selemix_MSDS

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