Technical Data Sheet

BODYWORK PRIMER

Temporary protection anti-corrosion primer

PROPERTIES

- Up to 6 months of anti-corrosion protection
- Easy application
- High yield
- Easy fusion and pressure welding without any stripping
- Very low VOC content

PRODUCT DESCRIPTION

A bodywork primer for anti-corrosion protection during bodywork repairs after removal of the old coating. The corrosion inhibitors provide at least 6 months of protection after the application. The water-based resins allow easy fusion or pressure welding of metals primed with the product (72 h after the application). Bodywork Primer is designed require cleaning only the bodywork locations repaired by fusion/pressure welding after the product application, followed by degreasing twice with SILICONE REMOVER, and the application of EPOXY PRIMER.

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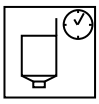
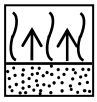
23/11/2023

SUBSTRATES	
Steel	ABRASIVE BLASTING: Steel cleaned to Sa $2^1/_2$ The surface should be dry and free of oils, grease, dust, loose old coatings, milling scale, rust and foreign bodies. The surface should exhibit a bare metallic gloss. Blow off all the dust from the clean steel surface and degrease twice with SILICONE REMOVER and blow off all the dust again. POWER CLEANING: Use a rotary or eccentric grinder with P80 ÷ P120 paper. Blow off all the dust from the clean steel surface and degrease twice with SILICONE REMOVER, and blow off all the dust again. WATER CLEANING OF COATINGS: The substrate should be completely dry, free from oil, grease, loose old coatings, milling scale, rust and foreign bodies. Following this cleaning, use a rotary or eccentric grinder with P80 ÷ P120 paper. Blow off all the dust from the clean steel surface and degrease twice with SILICONE REMOVER and blow off all the dust again.

SPRAY VISCOSITY		
	DIN 4/20°C	40 ÷ 60 s
The product is ready for application by spraying. Add up to 10% of demineralised water to obtain the correct viscosity.		

APPLICATION		
	Clean by hand for a minimum of 5 minutes before application	
 Follow the tool manufacturer's guidelines	Spray nozzle	1.6 ÷ 1.8 mm
	Spray tool input pressure	1.2 ÷ 2.2 bar
	Number of layers	2 ÷ 3
	Single dry layer thickness	25 ÷ 30 µm
	The recommended coating thickness should be <u>50 µm DFT</u> to ensure optimum anti-corrosion protection.	
	Ready-for-use mixture yield for DFT	approx. 5 m^2/l at 50 µm
	The actual yield depends on the surface shape, roughness and application parameters.	

	Flash-off time between layers	15 ÷ 20 min
	Use of the correct PPE is recommended!	
DRYING TIME		
	Handling hardness	3 h/20°C
	Final hardness Primer ready for fusion/pressure welding and EPOXY PRIMER application	72 h/20°C
	Coatable with the EPOXY PRIMER without pre-sanding	Up to 6 months/20°C
The drying time is specified for the body workpiece temperature and not the air temperature!		
VOC CONTENT		
VOC II/B/c limit*	540 g/l	
Actual VOC	53 g/l	
* For a ready-for-use mixture acc. to EU Directive 2004/42/CE		
COATABILITY		
BODYWORK PRIMER can be coated with EPOXY PRIMER up to 6 months after the application of the last product layer without sanding. Apply Epoxy Primer at a minimum of 72 hours at 20°C after the application of the last product layer to ensure full adhesion.		
APPLICATION CONDITIONS		
The surface to be primed must be dry. The BODYWORK PRIMER coated surface and ambient temperatures must be between +5°C and +35°C; the relative humidity should not exceed 80%. The temperature of the surface to be primed must exceed the dew point by at least 3°C.		
COLOUR		
Red		
EQUIPMENT CLEANING		
First wash with demineralised water, tap water or a water-based remover. Finish the washing with a spray gun cleaner or with NC solvent.		

STORAGE CONDITIONS	
Store in a dry and cool room, away from sources of fire and heat. Avoid direct exposure to sunlight. Recommended storage temperature: +5°C ÷ +30°C. Protect from freezing.	
SHELF LIFE	
BODYWORK PRIMER	12 months/20°C
SAFETY	
See the Safety Data Sheet.	
OTHER INFORMATION	
The effectiveness of our systems results from laboratory research and many years of experience. The data contained here meets the current knowledge about our products and their application potential. We can ensure high quality, provided the user follows the instructions and the work is performed in accordance with good workmanship. It is necessary to perform a test application of the product due to its potential for varying reactions with different materials. We cannot be held liable for defects if the final results are affected by factors beyond our control. This TDS supersedes all its previous issues. Registration number: 000024104	