

APCONYL WP 636

Vinyl Etch Primer

PRODUCT DESCRIPTION

A Two-pack, air drying etch primer based on zinc tetroxy chromate and polyvinyl butyral

FEATURES AND RECOMMENDED USE

- Excellent adhesion on non ferrous metal like aluminium, tin, galvanised iron etc
- Improves adhesion of subsequent coats to the substrate
- Very good flexibility
- Can be top coated with conventional, chlorinated rubber, epoxy, acrylic and polyurethane based primers and finishes

TECHNICAL DATA

Colour	Greenish yellow
Gloss	Matt
Volume Solids	Approx. 6%
Recommended DFT / Coat	8 - 10 microns
Theoretical Coverage Capacity	7.5 sq.mtr/ ltr @ 8 microns DFT 6.0 sq.mtr/ ltr @ 10 microns DFT
Drying time at 30°C	Surface Dry : 5 hours Hard Dry : 1 hours
Over coating interval at 30°C	Min. : 1 hours Max. : 24 hours, provided surface is dry and clean from all contamination.

The data given is for guideline only. The physical values are subject to normal manufacturing tolerances, colour and testing variances

The volume solids indicated are as per ASTM D 2697 air drying method.

The actual drying time/ overcoat interval may be shorter or longer, depending on film thickness, ventilation, humidity, temperature etc.

The information provided above is at 30°C and 65% relative humidity.

DIRECTIONS FOR USE

Surface Preparation

General

- Steel, non ferrous metals and galvanised surfaces; remove oil, grease or other contaminants from the surface.
- Alloys that oxidise should be lightly sanded to remove all loose materials from the surface

Application Conditions

- Substrate temperature should be at least 3°C above dew point but not above 50°C.
- Relative humidity should be below 85%
- Good ventilation is required in confined areas to ensure proper curing

Mixing

- Apconyl WP 636 is supplied in two packs. Stir the base and hardener separately. If settling is observed in the base or hardener, loosen the settled material with the help of hand stirrer followed by power driven stirrer (at lower RPM) for quick homogenous mixing
- Mix hardener gradually into the base under continuous stirring as per the mixing ratio. Once the unit has been mixed, it should be consumed within the working pot life. In case of part mixing (which should be avoided), close the lids of containers tightly to avoid contact with atmospheric moisture

Mixing Ratio (by volume)	Base : Hardener 1 : 1
Induction Time	30 minutes
Pot Life at 30°C	8 hour

Note: Mixed paint not used after 8 hours of mixing shall be discarded

Application

Airless Spray	
Nozzle orifice	1.5 - 3.0 mm (19 – 21Thou)
Nozzle pressure	0.3 - 0.4 MPa (= approx. 3 – 4 atm; 43 – 47 p.s.i.)
Cleaning Thinner	T 180
Brush / Roller	
Only for touch up areas	
Cleaning Thinner	T 180

Cleaning

- Do not allow the product to remain in hoses, gun or spray equipment. Clean all equipment immediately after use with Thinner T 180. It is recommended to periodically flush out spray equipment during the course of the working day. The frequency of cleaning will depend on amount sprayed, temperature and time gap
- All surplus material and empty containers should be disposed off in accordance with appropriate regional legislation

Product Characteristics

- Spray application is the desired method of application
- This wash primer is not intended for use as a shop primer for steel and it should be recoated with primer coat before exposure, preferably within 24 hours
- Product does not hide the base metal but gives it a yellowish tinge
- Do not build up thickness more than 10 microns. Excess deposition can result in loss of adhesion of primer to the metal surface

PACK SIZE	20 ltrs (Base : 10 ltrs & Hardener : 10 ltrs) 4 ltrs (Base : 2 ltrs & Hardener : 2 ltrs)
STORAGE	Shelf Life: Atleast 12 months @ 30°C for original unopened pack, subject to inspection thereafter. Store in a cool, dry place, shaded conditions away from sources of heat, ignition and in accordance with local regulations
REGULATORY INFORMATION	Flash point: Not less than 15°C VOC: Approx. 770 ± 25 gm/ ltr (depending on shades) as per USA-EPA Method 24 Product Weight: Approx. 0.90 ± 0.03 kg/ ltr

SAFETY INFORMATION

- As a general safety measure, inhalation of solvent vapours or paint mist and contact of liquid paint with skin & eyes, should be avoided. Forced ventilation should be provided when applying paint in confined spaces or stagnant air. Even when ventilation is provided, respiratory, skin and eye protection are always recommended when spraying paint
- Please refer our Material Safety Data Sheet prior to using the product



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