

Product Data



404 N/S Primer / Undercoat

PRODUCTS

404 N/S Primer/Undercoat Reducer	Range of colours available R203-Mineral Turps
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Product Description

A single pack high build, zinc phosphate, alkyd resin based primer for use with alkyd enamels and 2-pack topcoats. It is relatively fast drying with excellent durability, and is recoatable within 1 hour as a “wet on wet” application and does not need to be sanded to give excellent topcoat adhesion and gloss holdout.

Available Colours

- 404-6291 Grey
- 404-6903 Light Grey
- 404-0103 Royal Blue
- 404-2181 Yellow
- 404-2508 Yellow Green Electrostatic
- 404-7072 Black Electrostatic
- 404-8333 White Electrostatic
- 404-2718 Yellow Electrostatic

Preparation of Substrate



Surfaces showing light scale or surface rust should be wire brushed then treated with Protec R971 Metal Conditioner and Degreaser.

Heavily rusted surfaces should be abrasively blast cleaned.



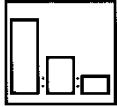
Bare aluminium and zinc coated steel should be thoroughly abraded with a nylon abrasive pad and primed with 406/413 Two pack etch primer or 426 Vinyl etch primer.

Please note: Substrate other than those stated should be tested before use, to ensure that the performance of the product is suitable for the intended use.

Cleaning: Before and after any sanding operation, the substrate must be thoroughly degreased with Protec R123 wax & grease remover to remove all traces of dirt, oil, grease, silicone, wax etc.

Application Guide:

Mixing ratio:



By volume:

404 N/S Primer/Undercoat 100 parts

Thinner R203

Up to 20%

Spraygun Setup:



Suction

Conventional

1.8 – 2.2 mm

Spray Pressure:

45-65 psi

350 - 450 kPa

Application:



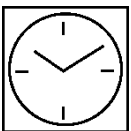
2 – 3 full, wet, even coats allowing flash-off between coats.

Flash Off Time:



5-10 minutes between coats @ 25 °C.
(dependant of film build)

Drying Times:



Air Dry Only:

Dust Free 10-15 minutes

Touch Dry 30 minutes

Wet on Wet application 1 Hour

Hard Dry Overnight (must be sanded after 16 hours)

Recoat:

Can be recoated with most Protec industrial enamel and 2-pack topcoats after 1 hour drying at 25°C and 60% relative Humidity as a wet on wet application.



Can be top coated with a variety of Protec 2-pack topcoats and air drying enamels.

Performance Guidelines

- Drying times will vary dependent on temperature, flash off between coats, number of coats used.
- Is suitable for brush application on small areas.
- Volume Solids – 40% - depending on colour
- Spreading Rate – 11-13 square metres per litre @ 25 µm

Health and Safety

Please refer to Material Health and Safety Datasheets for full health and safety details.

This product is for professional use only.

The information given in this sheet is for guidance only. Any person using the product without first making further inquiries as to the suitability of the product for the intended purpose does so at his own risk and we can accept no liability for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of such use. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.

Drying times quoted are average times at 20°C/68°F. Film thickness, humidity and shop temperature can all affect drying times.



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