PROTEC AUTOMOTIVE PAINTS

TECHNICAL DATA SHEET

AP-4441 PROTEC® ETCH PRIMER

PRODUCT DESCRIPTION

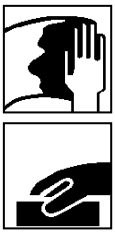
Protec Etch Primer is a 2 pack chromate free etch primer designed for use under Paraglaze, Paraglaze CT and Carmaster 2 pack primers.

It provides maximum adhesion and corrosion resistance when working on large areas of bare steel, galvanised steel, aluminium and fibreglass.

PRODUCTS

Protec Etch Primer	AP-4441
Protec Etch Primer Hardener	AH-4451
Protec Heavy Duty Wax & Grease Remover	AA-6822
Metal Conditioner	971-9119 or SX520
Water-Methylated Spirits cleaner	SWX250

SUBSTRATES & PREPARATION



Protec Etch Primer can be applied over the following substrates once they have been prepared as follows:

SUBSTRATE	PREPARATION
Bare Steel	P240 (dry)
Blasted Steel	Prime within 4 hours of blasting
Bare Steel - Rusted	*Startline* Scourer with 971-9119 or SX520 Metal Conditioner. When fully dry, follow with Startline® P80 - P180 (dry)
Galvanised Steel	*Startline* Scourer with 971-9119 or SX520 Metal Conditioner OR P400 (dry) followed by 971-9119 or SX520
Stainless Steel	*Startline* P240 - P320 (dry)
Aluminium	*Startline* P240 - P320 (dry), then use SWX250 Water-Methylated Spirits mix with one rag to wipe on and another clean rag to wipe off. Prime within 6 hours
Zinc Coated Alloys	*Startline* Scourer with SWX250 Water-Methylated Spirits mix. *Zinc coated metals can vary in alloy composition, therefore, it is recommended that an adhesion test is carried out before completing any major work.*

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GRP & Fibreglass	P240 - P320 (dry)
Aged Painted Surfaces	P320 - P400 (dry) OR P600 - P800 (wet)

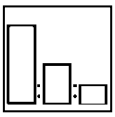
Do not apply acrylic lacquer primers and topcoats or polyester body filler over or under AP-4441 Protec Etch Primer.

Substrates other than those stated above should be tested before use, to ensure that the performance of this product is suitable for its intended use.

CLEANING

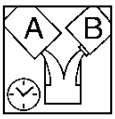
Before and after any sanding operation, the substrate must be thoroughly degreased using AA-6822 *Protec* Heavy Duty Wax & Grease Remover.

MIXING RATIO BY VOLUME



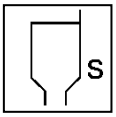
PRODUCT	PARTS
AP-4441	1
AH-4451	1

POTLIFE



Catalysed material is useable for up to 2.5 hours at 25°C.

SPRAY VISCOSITY



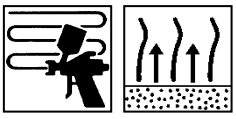
13 - 15 seconds (DIN 4) at 25°C.

SPRAYGUN SETTINGS *(GRAVITY)*

SETUP 1.3 - 1.4 mm

SPRAY PRESSURE
- HVLP / RP: 1.6 - 1.8 bar
- CONVENTIONAL: 2.0 - 2.5 bar

APPLICATION & FLASH OFF



- COATS: Apply 1 even, medium coat.

TOTAL DRY FILM BUILD

15 - 20 µm

TOPCOAT

TIME: 20 minutes, minimum, at 25°C

Ensure that AP-4441 has flashed off for 20 minutes before topcoating with a two pack primer

Protec Etch Primer may be topcoated with the following:

- Two pack primers in the Paraglaze, Paraglaze CT and Carmaster ranges, or as advised by the *Protec* Technical Team
- Two pack polyurethane topcoats such as Paraglaze Gloss and Carmaster DG, or as advised by the *Protec* Technical Team

Protec Etch Primer may NOT be topcoated with the following:

- Basecoats such as Paraglaze Basecoat

EQUIPMENT CLEANING

After use, clean all equipment thoroughly with cleaning solvent or thinner.

HEALTH AND SAFETY

Refer to Safety Data Sheets (SDS) for full Health and Safety details, as well as product can labels.

Protec hardeners and activated products contain isocyanate and therefore particular safety precautions must be taken; please refer to SDS 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 or her 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 25°C/77°F. Film thickness, humidity and shop temperature can all affect drying times.

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