

PRODUCT NAME

Paint System Multi Pack Military Vehicles Non Aircraft Low VOC Primer Type 1 Def Stan 80-225

ORIGINALLY ISSUED

26/07/2019

VERSION

4.0

PRODUCT CODE

DEF0101003

VERSION DATE

26/07/2019



PRODUCT DESCRIPTION

A solvent based high solids chromate free Epoxy primer designed for ferrous substrates in conjunction with Polyurethane and Epoxy topcoats.



IMPORTANT INSTRUCTIONS BEFORE USE

- Read and follow SDS, TDS and label instructions
- Stir all paints thoroughly before use
- Always use the same batch number on the same job
- Check colour & sheen. HMG will not accept any discrepancies arising after use
- Filter the product immediately before use
- Reduce emissions and maintain quality by replacing tin lid after use
- If in any doubt speak HMG Technical Service Department on (0161) 205 7631



MAXIMUM VOC CONTENT (RFU)

0.250Kg/L



COLOUR RANGE

- Light Aircraft Grey.



GENERAL INFORMATION

Coverage 12.5 square metres per litre.
Flashpoint 24°C
Storage Store between 5°C - 25°C. When not in use, cans must be kept sealed
Shelf Life 12 months from delivery date in original sealed containers



CLEANING

Ensure surfaces to be coated are dry and must be cleaned using the appropriate HMG product to remove all traces of contaminants.

HMG produce a full range of cleaners, silicone removers, degreasers and preparatory cleaners suitable for the cleaning process.

Please refer to our website for Knowledge Base article Prep-Cleaning Techniques (KNB0009) and Preparatory Cleaners from the Product Guide.



SURFACE PREPARATION

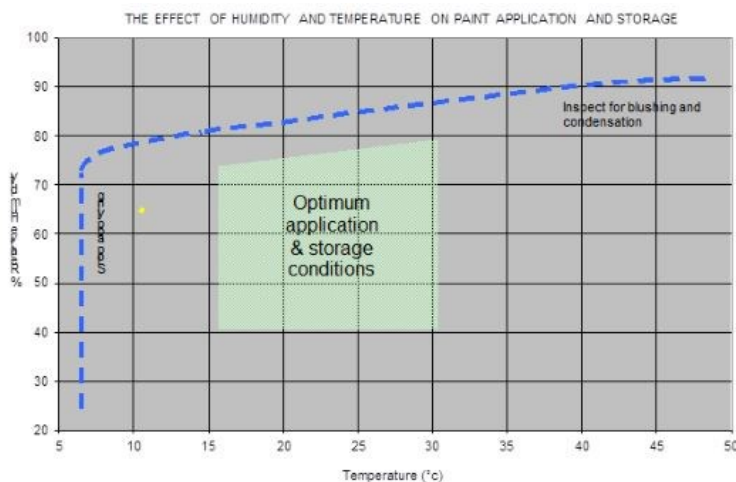
Please refer to Knowledge Base on our website for details on Surface Preparation.



ADDITIONAL INFORMATION

Induction time:- 15-20 mins
Mixing time:- Mechanical shaking on gyro - 3 mins
By hand until thoroughly mixed.

Humidity data:- see graph below:













HEALTH AND SAFETY

- Refer to SDS and tin label prior to use.
- RFU product contains isocyanates. Suitable air fed respiratory equipment should be worn when spraying.
- Refer to JD11/77 health and safety data sheet.

APPLICATION METHODS

COMPLIANT SPRAY GUN

	MIXING RATIO							
	Base	3.5						
	Hardener	1						
	HARDENER OPTIONS							
	Primer Epoxy Hardener part B							
	VISCOSITY							
	1.5cps	I.C.I cone&plate						
	SPRAY GUN SETUP							
	1.6-1.8							
	NUMBER OF COATS (GUIDE ONLY)							
	2 full coats							
	FLASH OFF							
	15 mins between coats							
	DRYING TIME							
	Touch dry	2-4hrs @20°C						
	Hard dry	24hrs @20°C						
	Full dry	5 days @20°C						
	RECOATABILITY / OVERCOATING							
	Up to 24hrs, no flattening required. Over 24hrs, flattening required (denib with P500g dry)							
	POT LIFE							
	1.5-2hrs @20°C							
	WET FILM THICKNESS*							
	65-110 microns							
	DRY FILM THICKNESS*							
	45-75 microns							

* - HMG Technical Data Sheets indicate a Dry Film Thickness that will be achieved when applying a particular Wet Film Thickness. These values are a guide only and are not to be used as specifications. Film thickness will vary depending on actual use and specification. Great care should be taken to achieve the dft stated in the agreed specification and to avoid areas of excessively low or high thickness.

This information relates only to the specific material designated and may not be valid for such material used in combination with any other materials or in any process. Such information is to the best of HMG's knowledge and belief accurate and reliable as of the date indicated. However, no representation, warranty or guarantee is made as to its accuracy, reliability or completeness. It is the user's responsibility to satisfy themselves as to the suitability and completeness of such information for their own particular use. For professional use only.