

PRODUCT NAME

HB05 Primer

ORIGINALLY ISSUED

22/09/2005

PRODUCT CODE

PRI05

VERSION

1.0

VERSION DATE

22/09/2005



PRODUCT DESCRIPTION

An Alkyd based, high build primer offering outstanding adhesion, moisture resistance and corrosion protection due to incorporation of modified Zinc Phosphate.

Designed for airless or conventional application for structural steelwork, chassis, steel fabrication etc. It is easy to apply without fear of runs or sags at high wet film thickness.



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



SPECIAL PROPERTIES

- Excellent sag resistance in high build airless spray situations.



MAXIMUM VOC CONTENT (RFU)

0.400Kg/L

REGULATIONS / COMPLIANCE

- Not Applicable



COLOUR RANGE

- Black, Buff, Grey, Red Oxide and White. Other colours available on request.



GENERAL INFORMATION

Specific Gravity	1.485
Solids By Volume	55.00%
Coverage	5.5 square metres per litre @ 100 microns wft
Flashpoint	25°C
Temp Resistance	60°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 Preparatory Cleaners suitable for most cleaning and degreasing processes.

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 for details on Surface Preparation.



HEALTH AND SAFETY







- Refer to SDS and tin label prior to use.
- Contaminated Rags, Spray Booth Filters or other substrates should be segregated from other chemical waste, soaked with Water and disposed of in a non-combustible container with a tight fitting Lid.

APPLICATION METHODS



AIRLESS/AIR-ASSISTED		COMPLIANT SPRAY GUN	
MIXING RATIO			
Base	1	Base	1
Thinner	up to 10%	Thinner	up to 10%
THINNER OPTIONS			
Thinner 2621		Thinner 2621	
VISCOSITY			
35-40	seconds B4 cup	25-30	seconds B4 cup
SPRAY GUN SETUP			
13-15thou 40/50°		1.8-2.0	
NUMBER OF COATS (GUIDE ONLY)			
1-2 full coats		1-2 full coats	



	FLASH OFF			
	10 -15 mins between coats		10 -15 mins between coats	
	DRYING TIME			
	Touch dry Hard dry Full dry	20-30mins @20°C 3hrs @ 20°C 24hrs @ 20°C	Touch dry Hard dry Full dry	20-30mins @20°C 3hrs @ 20°C 24hrs @ 20°C
	RECOATABILITY / OVERCOATING			
	1 hour minimum @ 20°C		1 hour minimum @ 20°C	
	POT LIFE			
	n/a		n/a	
	WET FILM THICKNESS*			
	100 microns		100 microns	
	DRY FILM THICKNESS*			
	55 microns		55 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.				

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