

PRODUCT DATA SHEET

Product & Reference: PC4VC Range Steelseal Primer (Dual Quality).

Date of Issue: March 2005

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PC4VC RANGE STEELSEAL PRIMER (DUAL QUALITY)

A high build, single pack primer based on pigmented moisture curing urethane prepolymer intended for application by brush or airless spray to steel, galvanise steel, sound weathered and new plastisol prior to finishing with Steelseal Topcoat PC5VF Range.

PHYSICAL PROPERTIES

| | |
|----------------------|--|
| Weight per litre | 1.2 - 1.3 Kg/L @ 21°C (dependant on colour) |
| Volume solids | 44% +/- 2% |
| Weight Solids | 64% ± 2% |
| Colours available | PC4VC100 Light Grey PC4VC120 Dark Grey PC4VC300 Red PC4VC001 Off White |
| Flash point | 38°C Flammable |
| Theoretical coverage | 8.5 m ² /litre at 50 microns dry film thickness (subject to surface profile, prevailing conditions and application techniques). |
| Pack size | 5 Litres |
| VOC content | 485 ± 10 g/L |

HEALTH AND SAFETY

This product is intended for use by professional applicators in industrial situations in accordance with the advice given on the Health and Safety Data Sheet and the containers. If for any reason a copy of the relevant Health and Safety Data Sheet is not immediately available, the user should contact Akzo Nobel Industrial Coatings to obtain a copy before using the product.

APPLICATION DETAILS

| | |
|-----------------------|--|
| Method of application | 1) Airless spray - Apply using 0.28 mm tip size at tip pressure 140 Kg/cm ² minimum. Select tip angle to suit application conditions. Monitor wet film thickness. If thinned apply at maximum WFT to ensure correct dry film thickness. 2) Brush - Monitor wet film thickness. If thinned apply at maximum WFT to ensure correct dry film thickness. |
| Wet film thickness | 110 - 130 micrometres (maximum) |
| Dry film thickness | 50 - 60 micrometres (maximum) Do not exceed maximum quoted DFT. |
| Mixing instructions | Stir thoroughly before use. |
| Thinner/Cleaner | In hot or humid conditions up to a maximum of 10% by volume (0.5L per 5L) PC4DT001 may be necessary (Consult Technical Advisory Department). Clean all equipment thoroughly. |
| Pot life | Opened containers must be used within 24 hours. This may vary with humidity and temperature. Avoid moisture ingress. |
| Drying Time | With free air circulation. Times will be extended in still air conditions, low humidity or if over applied. Minimum relative humidity 35%. |

| AMBIENT CURING @ 50 MICROMETRES DFT | | | | |
|-------------------------------------|-----------|----------|-----------------------|-------------------|
| Substrate Temp. | Touch dry | Hard dry | Overcoating Intervals | |
| 5°C | 4-6 hrs | 24 hrs | Min. 8-10 hrs | Max.) Indefinite |
| 20°C | 2-3 hrs | 16 hrs | Min. 4-6 hrs | Max.) if clean |
| 30°C | 1-2 hrs | 10 hrs | Min. 3-4 hrs | Max.) and sound. |

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SURFACE PREPARATION

All surfaces must be clean, sound and dry at time of painting.

New unweathered plastisol must be wiped over with white spirit and allowed to dry prior to painting. No other organic solvents should be used. Unsound plastisol can be removed by high pressure washing, blast cleaning or chemical strippers.

Ensure stripped areas are free from stripper residues, zinc salts and dust by suitable hand or mechanical cleaning methods, as stripper residues are not always detected with the naked eye. The surface must be thoroughly washed down with detergent solution and rinsed with clean water before painting.

When dealing with aged plastisol, expert condition diagnosis is required to determine surface preparation requirements and to ensure correct specification is used. Please contact our Technical Service Department.

STORAGE CONDITIONS

Store in a cool, dry, well ventilated place between 5°C and 30°C. Avoid moisture ingress.

SHELF LIFE

6 months in unopened containers.

LIMITATIONS ON USE

Do not apply if rain, sleet, mist or snow are imminent.

Do not apply when relative humidity is less than 35%.

Do not apply when substrate temperature is less than 2°C above dew point.

Do not apply at surface temperatures of lower than 0°C or above 40°C.

Ensure correct primer shade is selected otherwise extra coats of topcoat may be required. White, light colours and certain accent shades will require additional topcoats to obliterate.

For conditions not covered within this data sheet refer to Akzo Nobel Industrial Coatings Advisory Department.

All material supplies are subject to AKZO NOBEL INDUSTRIAL COATINGS LIMITED current Terms and Conditions of Sale.

This Data Sheet supersedes all previous Data Sheets supplied to you relating to this product. It contains important information which must be communicated to the user. The user must satisfy himself of the suitability of the product for the intended application and surface, as surface and application conditions are beyond Akzo Nobel Industrial Coatings Ltd control. The user must also satisfy himself of the suitability of the product in circumstances other than those set out in this Data Sheet. The user must also maintain appropriate quality control procedures. Akzo Nobel Industrial Coatings Ltd is always willing to answer user's enquiries regarding its products.