



Technical Data Sheet

BODYWORK PRIMER

Temporary protection anti-corrosion primer

USE:







- Designed for renovation of classic cars
- Temporary bodywork anti-corrosion protection
- For coating entire vehicle bodies and details after power cleaning

PROPERTIES

- Up to 6 months of anti-corrosion protection
 - High yield
- Weldable and tackable without removal
 - Very low VOC content

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SUBSTRATES				
Steel	Clean steel surfaces to Sa 2 ^{1/2} (wet blasting) or St3 (manual cleaning or with a power tool) in accordance with PN-ISO 12944-4; the surface after treatment must be free of oil, grease, dust, loose old paint coats, mill scale, rust and foreign contaminants; the surface should show the gloss of the metal substrate.			
VISCOSITY:				
	DIN 4/20°C	50 - 70 s		
The product is ready for application by spraying. Add up to 10% of water (demineralised is recommended) to obtain the correct viscosity.				
APPLICATION				
	Stir by hand before use			
 CAUTION: Follow the equipment manufacturer's guidelines	Conventional gravity fed spray gun	Nozzle	Pressure	Distance
		1.4 - 1.8 mm	2 - 3 bar	15 - 20 cm
	Number of layers	2		
	Single dry layer thickness	25 - 30 µm		
	The yield of the ready to use mixture for the given range of dry layer thickness	ca. 5 m ² /l at 50 µm		
	The actual yield depends on the surface shape, roughness and application parameters.			
	Flash-off time between layers	15 - 20 min		
DRYING TIME				
	Operating hardness		180 min/20°C	
	Total hardness (time to apply the primer)		72 h at 20°C	
TECHNICAL DATA				
Product	Solids content by weight	Solids content by volume	Density	
BODYWORK PRIMER	≈ 39%	≈ 25%	1.20 g/cm ³	

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VOC CONTENT	
VOC II/B/c limit*	540 g/l
Actual VOC	24 g/l
* For ready to use mixture acc. to EU Directive 2004/42/CE	
COATABILITY	
The Bodywork Primer can be coated with Novol epoxy and acrylic primers. To achieve full adhesion, prime after 72 h at 20°C. Tack welding is also recommended after 72 h from applying the product. CAUTION! Protect parts coated with Bodywork Primer from direct exposure to atmospheric precipitation.	
APPLICATION CONDITIONS	
The coated surface must be dry. The coat, coated surface and ambient temperatures must be between +5°C and +35°C; the relative humidity must not exceed 80%. The coated surface temperature must exceed the dew point by at least 3°C.	
COLOUR	
Red	
EQUIPMENT CLEANING	
Demineralised water, tap water, NC solvent.	
STORAGE CONDITIONS	
Store in a cool dry room, away from sources of fire and heat. Avoid direct exposure to sunlight. Recommended storage temperature: +5 ÷ +30°C. Protect from freezing.	
SHELF LIFE	
BODYWORK PRIMER	9 months/20°C
SAFETY	
See the Safety Data Sheet.	
OTHER INFORMATION	
The effectiveness of our systems results from laboratory research and many years of experience. The data contained herein meets the current knowledge about our products and their application potential. We ensure high quality, provided the user follows the instructions and the work is performed in accordance with good workmanship. It is necessary to perform a test application of the product due to its potentially different reaction with different materials. We may not be held liable for defects if the final result was affected by factors beyond our control.	