VITROS STOVING PRIMER

INTRODUCTION
A single pack stoving primer for application to suitably prepared components or other stoving finishes. May be used as an air drying primer prior to the application of a stoving finish, or as a heat cured primer prior to the application of stoving finishes. This product helps obtain a uniform substrate, and possesses good flatting properties.

AVAILABILITY
Supplied from stock in Grey.

PACKAGE SIZES
Supplied in 5 litre lever lid cans and 20 litre pails.

COMPOSITION
An alkyd melamine resin with organic and inorganic pigments in a suitable solvent blend.

APPEARANCE WHEN DRY
Slight sheen

SHELF LIFE
12 months in original unopened container

SOLIDS BY WEIGHT
62% Typical

SOLIDS BY VOLUME
43% Theoretical

VISCOSITY AS SUPPLIED
2·0 - 2·5 Poise (Cone and Plate)

SPECIFIC GRAVITY
1·31 Typical

SURFACE PREPARATION
Vapour degreasing is recommended. Alternatively manual degreasing to a high standard should be employed to ensure a clean dry substrate free from oils, greases, waxes and dirt. Phosphate pre-treatments may be used with this product.

APPLICATION
For application to ferrous substrates, or as an intermediate coat between an etch primer and finish.
Recommended for application by:-
Conventional air assisted spray. An addition of approximately 10 - 20% T3 Thinners will be required to achieve optimum application viscosity. Typical air atomising pressure 40 - 60 Psi.
May be used with pressure pot and transfer pump delivery systems.
If applying by air assisted airless spray or airless spray viscosity adjustment may be required to suit a given application.
Viscosity for most applications will be found to be within 25 - 55 seconds @ 25°C (BS EN ISO 2431).

THEORETICAL COVERAGE
Applied at 12²m per litre will give a theoretical DFT of 35µ, corresponding WFT 100µ.
Losses on narrow section and bar may be considerable due to overspray.

DRYING AND CURING SCHEDULE
Method 1 - Air dry the stoving primer for a minimum of 16 hours prior to applying the stoving finish. Allow to flash off and then stove for 20 minutes at 120°C.
Method 2 - Apply the primer and allow to flash off for 20 minutes before stoving for 10 minutes at 120°C. Apply the finish and then stove for a further 20 minutes at 120°C.

OVERCOATING
May be overcoated with conventional alkyd amino stoving finishes. Vitros stoving finishes are recommended.

SOLVENT FOR THINNING AND CLEANING EQUIPMENT
T3 Thinners.

ADDITIONAL INFORMATION
Crosbie Coatings Limited believe that the aforementioned information is to the best of our knowledge correct but no responsibility can be held for conditions of use beyond our control. Should there be any query as to the suitability for use please do not hesitate to contact the Technical Department of Crosbie Coatings Limited.

HEALTH AND SAFETY INFORMATION
This Data Sheet should be read in conjunction with Product Safety Data Sheet 35b.