

Technical Data Sheet

1K ETCH PRIMER

632 Series

FOR PROFESSIONAL USE ONLY

28-Jul-11



GENERAL INFORMATION

Valspar 1K Etch primer is a single pack epoxy primer formulated to give excellent adhesion to most metals including steel, galvanised steel and aluminium alloys



1. COMPONENTS

- 1K Etch Primer



2. MIXING RATIO - RFU

- Ready For Use



3. APPLICATION VISCOSITY

- DIN CUP 4 at 25°C 15 – 20 sec.



4. POTLIFE at 25°C - Indefinite

- N.A.



5. CLEAN UP

- Valspar Multi Purpose Thinners



6. SURFACE PREPARATION

- Surfaces should be prepared using the proper undercoat system following recommended procedures.
- Clean surface with 155 Surface Cleaner, for aluminium clean with 170 Aqua Clean.



7. SUBSTRATES

- Steel
- Galvanised Steel
- Aluminium Alloys



8. APPLICATION

- Spray one to two even wet coats.
- Allow each coat 5-10 minutes flash or until flash is dull.
- Surface temperature should be 10 - 40°C with less than 80% ambient humidity preferred.
- **Recommended Dry film Thickness: 10 um**



9. FLASH / DRY TIMES AIR DRY at 25°C

- Flash between coats 5-10 mins.
- Topcoat 4 hours



10. INFRARED CURE Not recommended



11. GUN SET UP HVLP

- Gravity Feed 1.5 – 1.6mm.



12. AIR PRESSURES

- HVLP inlet at 2 Bar



13. PHYSICAL DATA

- Flash Point 12°C
- Viscosity Din4 RTS: 15 – 20sec / 25°C