

DESCRIPTION

- an ultra-premium, two-part isocyanate free, non-sanding primer for use direct to mild steel and fibreglass

PRINCIPAL CHARACTERISTICS

- excellent adhesion and flow
- fast drying
- fast finishing wet on wet system
- fills minor surface imperfections
- provides excellent holdout for subsequent topcoats

Note: we advise that you test this product to determine if it is suitable for your particular use.

COLOURS AND GLOSS

- off white, low gloss
- may be tinted with up to 10% Colourthane C-series Part A (refer application instructions)

RECOMMENDED FILM THICKNESS (PER COAT)

	Typical
Dry film thickness microns	25
Wet film thickness microns	55
Theoretical spreading rate m ² /l	18.0

BASIC DATA AT 25 °C AND 50% RELATIVE HUMIDITY

- vehicle type..... acrylic resin
- solids content approx..... 45 % by volume
- mix ratio 4A:1B by volume
- dust free after 15 minutes
- touch dry after 30 minutes
- full cure after 7 days

RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURE

- best coating performance will be obtained with the highest degree of surface preparation
- degrease thoroughly to remove all oil, grease and other surface contaminants
- mild steel; remove all rust and any loose material by wire brush or mechanical sander, abrade entire surface with P180-280 grit sandpaper
- fibreglass; abrade using a Scotch-Brite[®] pad or wet and dry sandpaper. Do not use steel wool
- non-ferrous metals, stainless steel, galvanised iron, ZINCALUME[®], abrade using a Scotch-Brite[®] pad or wet and dry sandpaper. Do not use steel wool. Prime with Wattyl Super Etch[®] Primer (this system may be used on non-ferrous metals to allow for filling and sanding prior to application of Colourthane C-series Topcoat).
- suitable previous coat; degrease and dry sand with P180-280 grit sandpaper or wet sand with P280-400 grit sandpaper
- substrate temperature should be at least 3 °C above dew point
- relative humidity should not exceed 85 % during application and before the dry to handle time

APPLICATION INSTRUCTIONS

- mixing ratio by volume 4A:1B
- mix Colourthane NS300 Non-Sand Primer Part A with Colourthane NS300 Part B only
- induction time - none
- pot life at 25 °C 3 hours when thinned 20%. Do not use after this time even if the mix is still liquid
- stir the components and mixed product well using a mechanical mixer
- the temperature of the mixed product must be above 15 °C, otherwise extra thinner may be required to obtain application viscosity
- too much thinner will result in lower sag resistance and slower cure
- thinner should only be added after mixing the components
- freshly catalysed material should not be added to product that has been mixed for some time
- spray 2 single coats allowing for flash-off time of 3-15 minutes between coats
- flash off time is dependent on temperature and reducer used
- generally applied wet on wet, however may be sanded after 3-4 hours at 25 °C or 30 minutes at 60 °C
- may be force dried at 60 °C after 10 minute flash off
- for mechanical/manual wet sanding; initial sanding P500-600 grit paper, final sanding P800-1000 grit sandpaper
- for mechanical/manual dry sanding; initial sanding P280 grit paper, final sanding P320-400 grit sandpaper
- if recoating after 24 hours, dry sand with P320-400 or wet sand with P800-1000 between coats
- tinting- correctly catalysed product may be tinted with up to 10% (by volume) of Colourthane C-series Tinters; product must be catalysed before adding Colourthane C-series Tinter (so not add Colourthane C-series Part B to the product)
- for recommendations outside those contained in this data sheet, refer to Wattyl

APPLICATION METHODS

- **AIRLESS SPRAY**
 - recommended thinnerColourthane Reduceror L748
 - volume of thinnerup to 30 %
 - nozzle orifice approx.0.48mm (0.019 inch)
 - nozzle pressure15 MPa (2100psi)
- **AIR SPRAY**
 - recommended thinnerColourthane Reduceror L748
 - volume of thinner20-30 %
 - nozzle orifice approx.1.5-2.0 mm
 - nozzle pressure350-450 KPa (50-60psi)
- **CLEANING SOLVENT**.....Colourthane Reduceror L748

REDUCER GUIDE

Temperature	<15°C	20°C	25°C	30°C	>35°C
Colourthane Reducer Fast					
Colourthane Reducer Standard					
Colourthane Reducer Slow					
Thinner L748					

* thinning recommendations are given as a guide and may vary depending upon substrate temperature and weather conditions

SAFETY PRECAUTIONS

- flammable. Avoid contact with heat and naked flame
- avoid contact with skin and eyes
- use gloves, mask and goggles during application
- provide adequate ventilation when using in confined spaces
- this product is intended for use in industrial situations by professional applicators in accordance with the advice given on this sheet. All work involving the use and application of this product should be carried out in compliance with all relevant Health, Safety & Environmental standards and regulations and must not be used without reference to the Material Safety Data Sheet (MSDS)

ADDITIONAL DATA

Overcoating Table

Overcoating with Colourthane NS300 or Colourthane C-series topcoat

Substrate temperature	15°C	25°C	35°C	60°C
Minimum (fast reducer)	15 mins	10 mins	5 mins	5 mins
Minimum (standard reducer)	20 mins	15 mins	10 mins	5 mins
Minimum (slow reducer)	25 mins	20 mins	15 mins	10 mins
Minimum (L748)	30 mins	25 mins	20 mins	15 mins
Maximum	Unlimited- if over 24 hours, ensure surface is adequately degreased and abraded with P240-320 grit sandpaper			

*surface must be dry and free from chalking and contamination

Curing Table

Substrate temperature	15°C	25°C	35°C	60°C
Dry to Handle (ready to sand)	5 hrs	3 hrs	1.5 hrs	30 mins
Hard Dry	16 hrs	12 hrs	6 hrs	1 hr

* adequate ventilation must be continuously maintained during application and curing

Pot Life Table

Substrate temperature	15°C	25°C	35°C
unthinned	4 hrs	3 hrs	2 hrs

PRECAUTIONS

- for recommendations outside those contained in this data sheet, refer to Valspar

STORAGE AND PACKAGING

- shelf life at least 12 months in an unopened container
- all components shall be stored in a dry internal environment at between 5°C and 35°C
- packaging Part A- 4Lt
Part B- 1 Lt.

For the most up to date information visit our website or Contact Valspar Customer Service Hotline on:



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