

PRODUCT DATA SHEET



HDTHANE 515 PRIMER

Description: HDTHANE 515 Primer is a two pack polyurethane primer, characterized by optimum curing, sanding and excellent filling properties, fast drying as well as adhesion to most substrates.

Recommended use: Excellent adhesion for application to mild steel , stainless steel, chrome, brass, copper, aluminium , lead, fibreglass.

Service temperatures: Maximum, dry exposure only: 120°C/248°F

Physical Properties :

Colours/shade Nos.:	Grey*
Finish:	Flat
Volume solids, %:	45 ± 2%
Theoretical spreading rate:	9 m ² /litre, 50 micron/2 mils
Flash point:	35°C [95°F]
Specific gravity:	1.22 kg/litre
Surface-dry:	30 minutes at 30°C
Touch-dry:	3 hours at 30°C
VOC content:	457 g/litre

Application details:

Version, mixed product

HDTHANE 515 Primer

Mixing ratio:	515 Base: 515 Curing Agent 5 : 1 by volume
Application method:	Airless spray /Air spray/Brush
Thinner (max.vol.):	HD PU Thinner (0-5%)
Pot life:	3-4 hours at 30°C
Nozzle orifice:	.017"-.019"
Nozzle pressure:	175 bar <i>(Airless spray data are indicative and subject to adjustment)</i>
Indicated film thickness, dry:	35 – 50 micron
Indicated film thickness, wet:	77 – 110 micron
Overcoat interval, min:	According to Specification
Overcoat interval, max:	According to Specification

Safety: Handle with care. Wear Necessary PPEs like safety shoes, gloves, goggles.

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Surface preparation:	New steel: Abrasive blasting to Sa 2½ (ISO 8501-1:1988). For temporary protection, if required, use a suitable shop primer. All damage of shop primer and contamination from storage and fabrication should be thoroughly cleaned prior to final painting. Other metals and light alloys: Thorough degreasing and (light) abrasive sweeping to remove contamination and to secure adhesion - surface profile depending on later exposure. Repair and maintenance: Remove oil and grease etc. thoroughly with suitable detergent. Remove salts and other contaminants by high pressure fresh water cleaning. Clean damaged areas thoroughly by power tool cleaning to St 3 (spot-repairs) or by abrasive blasting to min. Sa 2, preferably to Sa 2½ (ISO 8501-1:1988). Improved surface preparation will improve the performance. As an alternative to dry cleaning, water jetting to min. WJ-3, preferably WJ-2 (NACE No. 5/SSPC-SP 12), may be used.
Application conditions:	Use only where application and curing can proceed at temperatures above: 10°C/50°F. Before exposure to outside temperatures below 10°C/50°F within the first day after application the coating must have been forced dried at minimum 15 minutes. The temperature of paint itself should be 15°C/59°F or above. Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. In confined spaces provide adequate ventilation during application and drying.
Preceding coat:	According to specification.
Subsequent coat:	According to specification.
Remarks/Notes:	
Film thicknesses/thinning: (optional)	May be specified in another film thickness than indicated depending on purpose and area of use. This will alter spreading rate and may influence drying time and recoating interval. Normal range dry is: 30-75 micron/1.2-3.0 mils (Consult the separate APPLICATION INSTRUCTIONS).
Overcoating note: (optional)	Before recoating after exposure in contaminated environment, clean the surface thoroughly with high Pressure fresh water hosing and allow drying.

This Product Data Sheet supersedes those previously issued.

Data, specifications, directions and recommendations given in this data sheet represent only test results or experience obtained under controlled or specially defined circumstances. Their accuracy, completeness or appropriateness under the actual conditions of any intended use of the Products herein must be determined exclusively by the Buyer and/or User.

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